

Defect Details

NC No.	8000890966
NC Date	13/09/2024
NC Submission Date	
Part No.	B2KN01103O
Part Name	RESERVOIR CAP RAW CASTING
Supplier Name & Code	100865-HI TECH ARAI PVT LTD UNIT XI
ETL Plant	1120-ETL K-226/2 Disc Brakes
Defect Details	BUFFING DEFECT-LETTER MARKING NT OK

1. Problem Description

Defect Description	BUFFING DEFECT-LETTER MARKING NT OK
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	978
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	rajeshwaran.m@hitecharai.com
Plant Head/CEO Email ID	sundararaman.v@hitecharai.com
MD Email ID	spm32@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	28000	5000	0	0	3000	36000
Check Qty	28000	5000	0	0	3000	36000
NG Qty	978	200	0	0	0	1178

Action taken on NG part

Scrap	1178
Rework	0
Under Deviation	0

Containment Action

ETL End – 978 Qty rejected by ETL . Available stock at Supplier end verified and sorting out.

3. Process Flow

Process Flow Description

Casting - fettling

4. Process Details

Process / Operation	Casting
Outsource	No
Machine / Cell	Diecasting machice
Machine / Cell No.	125T

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Insert Chip off	Insert verification	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5 / 2hrs

7. Root Cause Analysis (Occurance)

Why 1	Letter damage issue observed
Why 2	Due to material stuck at letter area
Why 3	Due to insert chip off
Why 4	
Why 5	
Root Cause (Occurance)	Letter damage issue happened due to insert chip off issue.

Root Cause Analysis (Outflow)

Why 1	Letter damage issue observed
Why 2	Due to lack of awareness
Why 3	Due to after powder coating only identification
Why 4	
Why 5	
Root Cause (Outflow)	Due to after powder coating only identification

8. Countermeasure (Occurrence , Outflow & System side Actions)

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Insert send to reforming	Mr.Balakrishnan	05/09/2024	05/09/2024	Completed

Outflow	Briefing the quality requirement for fettling operator, inspector & ware house in-charge based on defect details and actual part	Rajeshwaran / Mane	06/09/2024	06/09/2024	Completed
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9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection on PDI stage
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	Defect Photo 1094_Occurance_Before.jpg
Occurance (After)	Correction Photo 1094_Occurance_After.jpg
Outflow (Before)	No 100% inspection 1094_Outflow_Before.jpg
Outflow (After)	To conduct 100% inspection 1094_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	All reservoir Cap

12. Document Review

Documents	InspCheckSheet
Specify Other Document	nil

13. Effectiveness Of Action

Reviewed Quantity	150
Reason for submission	Improvement found.