

## Defect Details

<b>NC No.</b>	8000893366
<b>NC Date</b>	27/09/2024
<b>NC Submission Date</b>	
<b>Part No.</b>	S2DA009070
<b>Part Name</b>	TOP SPRING LOCATOR
<b>Supplier Name &amp; Code</b>	100161-PREMIER ENGINEERS
<b>ETL Plant</b>	1118-ETL E-92,93 Suspension
<b>Defect Details</b>	POWDER COATING NOT OK-POWDER COATING PEEL OFF

## 1. Problem Description

<b>Defect Description</b>	POWDER COATING NOT OK-POWDER COATING PEEL OFF
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	1168
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality.premier@sanghavigroup.co.in
<b>Plant Head/CEO Email ID</b>	prabhune.girish@sanghavigroup.co.in
<b>MD Email ID</b>	sanghavi.rajesh@sanghavigroup.co.in

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	1200	0	0	0	0	1200
<b>Check Qty</b>	1200	0	0	0	0	1200
<b>NG Qty</b>	1166	0	0	0	0	1166

## Action taken on NG part

<b>Scrap</b>	1166
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

All the material available at Endurance End Segregated by hitting method

## 3. Process Flow

**Process Flow Description**

RM+Cutting+Forming+Piercing+Vibro+Powder Coating+Final Inspection

**4. Process Details**

<b>Process / Operation</b>	Powder Coating at Krishna Coating
<b>Outsource</b>	Yes
<b>Machine / Cell</b>	Red wine locator Line
<b>Machine / Cell No.</b>	Red wine locator

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Method	No proper bonding of paint to Locator	At phosphating stage bath concentration not maintained	X
Method	Oil traces on parts	-tank heater not working	X

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Inspection by nail
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	Sampling
<b>Sampling</b>	No
<b>Sample Size</b>	5/100

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	Coating Peel Off
<b>Why 2</b>	Phosphating observed week
<b>Why 3</b>	Bath concentration observed less
<b>Why 4</b>	regular bath analysis not done
<b>Why 5</b>	Lab chemist not done analysis
<b>Root Cause (Occurance)</b>	Phosphating bath concentration not maintained.

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	Coating Peel Off
<b>Why 2</b>	Part missed from inspector
<b>Why 3</b>	Part peel off not observed during Inspection
<b>Why 4</b>	Sampling basis adhesion verification
<b>Why 5</b>	sampling frequency not increased
<b>Root Cause (Outflow)</b>	Due to sampling basis adhesion inspection part could not be cached at final inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
------	------------------------	----------------	-------------	-------------	--------

Occurance	Phosphating bath concentration maintained, Degreasing heater Started	Mr.Lokahnde	01/10/2024	15/10/2024	Completed
Outflow	Sampling frequency for Adhesion increased, Double sampling started	Mr.Lokhande	01/10/2024	15/10/2024	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	Double sampling inspection for adhesion started
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	Cross Adhesion
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	Sampling
<b>Sampling</b>	No
<b>Sample Size</b>	5/100

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	Phosphating Stage Bath Concentration not maintained and Degreasing Heater not working which is started. <a href="#">1116_Occurance_Before.pdf</a>
<b>Occurance (After)</b>	Bath Concentration maintained and Heater Started <a href="#">1116_Occurance_After.pdf</a>
<b>Outflow (Before)</b>	Operator Skill matrix Not Updated <a href="#">1116_Outflow_Before.pdf</a>
<b>Outflow (After)</b>	Training Provided to Final Inspector <a href="#">1116_Outflow_After.pdf</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	Brass Gold Locator, Silver Locator

## 12. Document Review

<b>Documents</b>	WISOP
<b>Specify Other Document</b>	OPL Implemented

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	500
<b>Reason for submission</b>	AFTER TAKING ACTION POWDER COATING FOUND OK- NO POWDER COATING PEEL OFF OBSERVED.