QFR No - 8000894023

Defect Details

NC No.	8000894023
NC Date	01/10/2024
NC Submission Date	
Part No.	530DA00507
Part Name	TOP SPRING LOCATOR
Supplier Name & Code	100161-PREMIER ENGINEERS
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	POWDER COATING NOT OK-POWDER COATING PEEL OFF

1. Problem Description

Defect Description	POWDER COATING PEEL OFF
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	106
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

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

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	208	0	0	0	0	208
Check Qty	208	0	0	0	0	208
NG Qty	106	0	0	0	0	106

Action taken on NG part

Scrap	106
Rework	0
Under Deviation	0

Containment Action
Available lot Qty 208 Nos Segregated for peel off Issue by heating Method.

3. Process Flow

Process Flow Description
RM+Forming +Piercing+Vibro+Powder coating+final Inspection+Dispatch

4. Process Details

Process / Operation	Powder Caoting
Outsource	Yes
Machine / Cell	Tulja Enterprises
Machine / Cell No.	Powder Coating L

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Excess Powder Coating at OD edge	Due to new coater powder coating observed excess on part Edge	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	DFT meter Inspection
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	DFT Chech

7. Root Cause Analysis (Occurance)

Why 1	TSL Powder Coating Peel off at Edge
Why 2	Powder Coating Thickness Observed More on part Edge
Why 3	Excess powder observed (more than 120Micron)observed on Edge
Why 4	New Coater in place of regular coater absentism
Why 5	No new coater powder spraying training for powder DFT 60 to 70
Root Cause (Occurance)	Excess powder coating on part and its Edge

Root Cause Analysis (Outflow)

Why 1	TSL Powder Coating Peel off at Edge
Why 2	Not detected at final Inspection stage
Why 3	Sampling basis DFT verification
Why 4	visual method of 100% Inspection not followed
Why 5	
Root Cause (Outflow)	Sampling basis DFT verification

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
	Inspection frequency increased for DFT verification and				

Outflow	100& visual inspection followed for Excess coating on Edge	Mr.Vishal	15/10/2024		Completed
Occurance	Training provided to available coater for Powder Coating thickness within 60-70 Micron	Mr.Mahendra Patil	15/10/2024		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Inspection Qty increased for DFT Inspection also 100% powder verification at edge for excess powder coating
Inspection Method	Other
Other Inspection Method	Double sampling
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	20/100

10. Evidance of Countermeasure

Occurance (Before)	Excess Coating 1126_Occurance_Before.pdf
Occurance (After)	No Excess Coating training provided to coater. 1126_Occurance_After.jpg
Outflow (Before)	No Training to Coater, Coater Training provided 1126_Outflow_Before.pdf
Outflow (After)	Training Provided to Coater 1126_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Other Locator also

12. Document Review

Documents	WISOP
Specify Other Document	Final Training

13. Effectiveness Of Action

Reviewed Quantity	1000
Reason for submission	After taking action no powder coating peel off observed on part.