

Defect Details

NC No.	8000902705
NC Date	09/12/2024
NC Submission Date	
Part No.	F2FQ00407B
Part Name	HOLDER HANDLE UPPER P/C (XF-521)
Supplier Name & Code	201092-PRANEEL INDUSTRIES
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	DENT MARK-DENT DAMAGE

1. Problem Description

Defect Description	DENT MARK
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	8
Is Defect Repeatative?	Yes
Defect Sketch / Photo	3tkupsqk0tnofazl2odznfet.jpg

Supplier Communication Details

Quality Head Email ID	quality@praneelgroup.com
Plant Head/CEO Email ID	praneelindustries@rediiffmail.com
MD Email ID	anilpatil@praneelgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	320	0	0	0	100	420
Check Qty	320	0	0	0	100	420
NG Qty	20	0	0	0	6	26

Action taken on NG part

Scrap	20
Rework	0
Under Deviation	0

Containment Action

All material at ETL end and in-house material verify and rejected at ETL end also at in - house

3. Process Flow

Process Flow Description

Raw casting inward - Drilling - Powder Coating - Powder coating inward - VMC Machining - De- burring - Final Inspection - packing and dispatch

4. Process Details

Process / Operation	VMC MACHINING
Outsource	No
Machine / Cell	VMC CELL
Machine / Cell No.	VMC MACHINE

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Deburring not done as per work instruction	Verify the deburring method by operator and found inadequate	X
Machine	machine parameter required not as per control plan	verify the machine parameter as clamping pressure found ok	O
Tool	Required tooling for part production not as per standard	verify the tooling for production	O
Man	final inspector not as per skill matrix	verify the skill for final inspector and found inspector as per skill matrix	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100 %

7. Root Cause Analysis (Occurance)

Why 1	Dent damage found on parts
Why 2	Clamping pressure not as per control plan specification
Why 3	Part handling not done as per material handling Work instruction
Why 4	De-burring process not done properly as per Work instruction
Why 5	
Root Cause (Occurance)	handling process not done as per Work Instruction

Root Cause Analysis (Outflow)

Why 1	Dent damage issue on part
Why 2	Part skipped by final inspector
Why 3	During material packing dent damage done
Why 4	No awareness to the inspector as well as packing person for dent damage
Why 5	
Root Cause (Outflow)	lack of awareness to final inspector as well as packing person

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Training and awareness given to the final inspector as well as packing person for dent damage	Mr. Vilas Chavan	20/12/2024	20/12/2024	Completed
Occurance	Training given to operator of material handling process for material handling should be done as per Work instruction DISPLAY	Mr Sudarshan Kadam	20/12/2024	20/12/2024	Completed

9. Inspection Method After Customer Complaint

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

10. Evidence of Countermeasure

Occurance (Before)	Operator not aware about dent damage issue on the part 1266_Occurance_Before.pdf
Occurance (After)	Training and awareness given to operator for handling material 1266_Occurance_After.pdf
Outflow (Before)	No any awareness about dent damage issue observed on the parts 1266_Outflow_Before.pdf
Outflow (After)	Training and awareness given to final inspector for dent damage issue observed on the also Q alert display for the raise concern by ETL 1266_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Handle Holder Lower

12. Document Review

Documents	WISOP
Specify Other Document	Q- Alert

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok

