Nonconformity management

Organization name	PT Astra Juoku Indonesia
Audit start date	07.Oct.2021
Audit end date	08.Oct.2021
Audit type	Recertification
CB identification no.	ID19/04509
CB certificate no.	ID19/04509

Nonconformity management

NC no.	NC identification no.	Standard	Standard clause	Classification	Due date max. 20 days	Due date max. 60 days	Nonconformity observed in process
1	1 of 10	IATF 16949:2016	8.4.2.4	minor		07.Dec.2021	Pengadaan Barang Dan Jasa / Product & Service Procurement
2	2 of 10	ISO 9001:2015 and IATF 16949:2016	7.1.5.2	minor		07.Dec.2021	Surface treatment production process– shift 1
3	3 of 10	ISO 9001:2015 and IATF 16949:2016	7.5.3.2	minor		07.Dec.2021	Surface treatment production process– shift 1
4	4 of 10	IATF 16949:2016	8.4.2.2	minor		07.Dec.2021	Predictive, Preventive, Dan Maintenance Corrective Maintenance
5	5 of 10	IATF 16949:2016	8.5.1.1	minor		07.Dec.2021	Assembly – shift 1 Relevant processes will also audit were : Pengendalian Produk Tidak Sesuai/Suspect Product management Covid 19 pandemic risk management review
6	6 of 10	ISO 9001:2015 and IATF 16949:2016	8.5.1	minor		07.Dec.2021	Assembly – shift 1 Relevant processes will also audit were : Pengendalian Produk Tidak Sesuai/Suspect Product management Covid 19 pandemic risk management review
7	7 of 10	IATF 16949:2016	8.5.1.5	minor		07.Dec.2021	Predictive, Preventive, Dan Maintenance Corrective Maintenance
8	8 of 10	IATF 16949:2016	7.5.1.1	minor		07.Dec.2021	Pengendalian Dokumen / Document control Pengendalian Rekaman / Quality records control
9	9 of 10	IATF 16949:2016	8.5.1.3	minor		07.Dec.2021	Plastic Moulding Injection – shift 1 & 2 included Pengendalian Produk Tidak Sesuai/Suspect Product management
10	10 of 10	IATF 16949:2016	8.3.5.2	minor		07.Dec.2021	Plastic Moulding Injection – shift 1 & 2 included Pengendalian Produk Tidak Sesuai/Suspect Product management

NC & actions

Nonconformity 1

To be completed by the CB auditor

NC header

NC identification no.	1 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Pengadaan Barang Dan Jasa / Product & Service Procurement
Standard clause	8.4.2.4 Supplier monitoring
Requirement	The organization shall have a documented process and criteria to evaluate supplier performance in order to ensure conformity of externally provided products, processes, and services to internal and external customer requirements. At a minimum, the following supplier performance indicators shall be monitored: a) delivered product conformity to requirements; b) customer disruptions at the receiving plant, including yard holds and stop ships; c) delivery schedule performance; d) number of occurrences of premium freight. If provided by the customer, the organization shall also include the following, as appropriate, in their supplier performance monitoring: e) special status customer notifications related to quality or delivery issues; f) dealer returns, warranty, field actions, and recalls.

Statement of nonconformity

Supplier evaluation process is not fully effective

Objective evidence

It was observed no effective evidence could be shown for regular performance Supplier evaluation for service Supplier, i.e. : Calibration Supplier, i.e. : PT Global Quality Indonesia

Justification for classification

This is minor finding because only single lapse, others material/child part Supplier has been evaluated periodically, i.e. : PT DEM, PT Mitra Amanda, etc. Also observed there is no problem related calibration issue

Ernawati Ahadi **Auditor´s name**	08.Oct.2021 **Audit closing meeting date**	**This document is valid without a signature**

To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 2

To be completed by the CB auditor

NC header

NC identification no.	2 of 10
Standard	ISO 9001:2015 and IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Surface treatment production process– shift 1
Standard clause	7.1.5.2 Measurement Traceability
Requirement	(Enter ISO 9001:2015 requirement) 7.1.5.2 Measurement traceability When measurement traceability is a requirement, or is considered by the organization to be an essential part of providing confidence in the validity of measurement results, measuring equipment shall be: a) calibrated or verified, or both, at specified intervals, or prior to use, against measurement standards traceable to international or national measurement standards; when no such standards exist, the basis used for calibration or verification shall be retained as documented information; b) identified in order to determine their status; c) safeguarded from adjustments, damage or deterioration that would invalidate the calibration status and subsequent measurement results. The organization shall determine if the validity of previous measurement results has been adversely affected when measuring equipment is found to be unfit for its intended purpose, and shall take appropriate action as necessary.

Statement of nonconformity

Calibration system is not fully effective

Objective evidence

- It was observed that measuring viscosity painting used viscosity cup on mixing process, however calibration/verification for this equipment has no evident.
- It was observed standard sample Head Lamp LH, PN : 20-0650 expired date 06.05.2021, however has not been re-verified.

Justification for classification

It is raised as minor NC because measuring product such as appearance and cross cut has been conducted effectively with no significant problem found. Other sampling calibration has been determined well for analytical balance on 22 April 2020, next calibration on 21 April 2022 and also observed the calibration certificate and observed other sample standard still in valid condition, i.e : standard sample D06A, Rear Comb Lamp, valid until : 06.03.2022

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To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 3

To be completed by the CB auditor

NC header

NC identification no.	3 of 10
Standard	ISO 9001:2015 and IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Surface treatment production process– shift 1
Standard clause	7.5.3.2 Control of Documented Information
Requirement	(Enter ISO 9001:2015 requirement) 7.5.3.2 For the control of documented information, the organization shall address the following activities, as applicable: a) distribution, access, retrieval and use; b) storage and preservation, including preservation of legibility; c) control of changes (e.g. version control); d) retention and disposition. Documented information of external origin determined by the organization to be necessary for the planning and operation of the quality management system shall be identified as appropriate, and be controlled. Documented information retained as evidence of conformity shall be protected from unintended alterations. NOTE Access can imply a decision regarding the permission to view the documented information only, or the permission and authority to view and change the documented information.

Statement of nonconformity

Process to control of updated document is not fully effective

Objective evidence

During audit surface treatment production, date : 08.10.2021, Part Name : LAMP ASSY REAR COMBINATION RH-LH, PN : 1550-D12LA - 81560-D12LA, it was observed 2 version document standard parameter setting, 11-AT01R/D12L, rev.1, date : 10.06.2021 with difference standard value of item check press pump painting, E-spray, E-patern, E-Automized, etc.

Justification for classification

It is only minor because actually standard parameter on check sheet already follow updated standard parameter setting updated and already controlled well. Also observed there is no impact to quality product.

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Auditor´s name	**Audit closing meeting date**	

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Correction (Containment) action, including timing and responsible person:

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Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

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Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 4

To be completed by the CB auditor

NC header

NC identification no.	4 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Predictive, Preventive, Dan Maintenance Corrective Maintenance
Standard clause	8.4.2.2 Statutory and regulatory requirements
Requirement	The organization shall document their process to ensure that purchased products, processes, and services conform to the current applicable statutory and regulatory requirements in the country of receipt, the country of shipment, and the customer-identified country of destination, if provided. If the customer defines special controls for certain products with statutory and regulatory requirements, the organization shall ensure they are implemented and maintained as defined, including at suppliers.

Statement of nonconformity

compliance management related applicable statutory and regulatory requirements was not effective

Objective evidence

Following document of generator used refer to related applicable statutory and regulatory was not evident :
#1. Generator use permit
#2. Generator Operator license

Justification for classification

This case was not systemic problem - regarding to other regulation verification could be shown effectively :compliance - for Crane operator - SIO number : 73723-OPK3-OC/PAA/XII/2016 for Mr. Wawan Edi Santoso; Mr. Andri Dwi Yatmoko - SIO number; 79370OPK3-OC/PAA/VIII/2017; Mr. Imam Joko Susilo - SIO number : 73722-OPK3-OC/PAA/XII/2016. and Pressure vessel - certificate number : 566.2/3927/UPTD-WIL II/IX/2021 - date 20.9.2021. This NC could be only Minor NC

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To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 5

To be completed by the CB auditor

NC header

NC identification no.	5 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Assembly – shift 1 Relevant processes will also audit were : Pengendalian Produk Tidak Sesuai/Suspect Product management Covid 19 pandemic risk management review
Standard clause	8.5.1.1 Control plan
Requirement	The organization shall develop control plans (in accordance with Annex A) at the system, subsystem, component, and/or material level for the relevant manufacturing site and all product supplied, including those for processes producing bulk materials as well as parts. Family control plans are acceptable for bulk material and similar parts using a common manufacturing process. The organization shall have a control plan for pre-launch and production that shows linkage and incorporates information from the design risk analysis (if provided by the customer), process flow diagram, and manufacturing process risk analysis outputs (such as FMEA). The organization shall, if required by the customer, provide measurement and conformity data collected during execution of either the pre-launch or production control plans. The organization shall include in the control plan: a) controls used for the manufacturing process control, including verification of job set-ups; b) first-off/last-off part validation, as applicable; c) methods for monitoring of control exercised over special characteristics (see Annex A) defined by both the customer and the organization; d) the customer-required information, if any; e) specified reaction plan (see Annex A); when nonconforming product is detected, the process becomes statistically unstable or not statistically capable. The organization shall review control plans, and update as required, for any of the following: f) the organization determines it has shipped nonconforming product to the customer; g) when any change occurs affecting product, manufacturing process, measurement, logistics, supply sources, production volume changes, or risk analysis (FMEA) (see Annex A); h) after a customer complaint and implementation of the associated corrective action, when applicable; i) at a set frequency based on a risk analysis. If required by the customer, the organization shall obtain customer approval after review or revision of the control plan.

Statement of nonconformity

Production process control was not always effectively determined

Objective evidence

during shift 1 & shift 3 audit - with sample taken line Glue 3 - and product VT01 -P/N: 898592480 - Head Lamp-ASM Halogen RH - for customer name : isuzu (IAMI) following discrepancies control has been observed refer to quality control plan document - PFMEA : AJI/PFMEA/PE/001 - document number : AJI/PFMEA/VT-01/PE/051 - key date 12.8.2019 for Riveting process - it has been confirm the preventive action has been planned : air pressure visual check and parameter setting standard defined for process - meanwhile refer to quality control plan - document number : AJI/QA/QCPC/032A - for P/N: 8982592480/898259290 - revision 1 - date 6.9.2017 - for Riveting process it has been confirm appearance consideration of process result such as : crack, over pressing - and check by visual with limit sample. Actual demonstration has been observed ; there was no limit sample available for riveting process and also production has been explained the riveting quality will be

verified by torque check.

Base on interview of qc member it has been explained in shift 1 - the sample check of visual was 2 of 3 every package regarding to tightening sample used. How ever no specific instruction could be shown - during shift 3 - inspector QC has been explained the visual will be done every 2 hours - meanwhile quality control plan confirm base on AQL.

During handling claim customer from ADM- KAP with LMK No. KAP/QCD/04/2021/036/A date 28 Apr 2021, product: BDG D06A A LH, part no: 76804-BZ070-00, problem: White welding, qty 1 pcs, It was found that corrective action has been conducted with additional check sheet cleaning JIG, however review of risk analysis and control plan for this claim was not conducted.

Justification for classification

This NC could be only minor NC - regarding to other sample taken seen could be effectively demonstrated VT01 -P/N: 898592480 - Head Lamp-ASM Halogen RH - for customer name : isuzu (IAMI) following discrepancies control has been observed refer to quality control plan document - PFMEA : AJI/PFMEA/PE/001 - document number : AJI/PFMEA/VT-01/PE/051 - key date 12.8.2019 for glue application process & Pressing process, Other sample of check could be effectively demonstrated for example ; glue weighing process, and torque control .

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To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products? Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

Missing required	Missing required
Organizations representative	**date**

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 6

To be completed by the CB auditor

NC header

NC identification no.	6 of 10
Standard	ISO 9001:2015 and IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Assembly – shift 1 Relevant processes will also audit were : Pengendalian Produk Tidak Sesuai/Suspect Product management Covid 19 pandemic risk management review
Standard clause	8.5.1 Control of Production and Service Provision
Requirement	8.5.1 Control of production and service provision The organization shall implement production and service provision under controlled conditions. Controlled conditions shall include, as applicable: a) the availability of documented information that defines: 1) the characteristics of the products to be produced, the services to be provided, or the activities to be performed; 2) the results to be achieved; b) the availability and use of suitable monitoring and measuring resources; c) the implementation of monitoring and measurement activities at appropriate stages to verify that criteria for control of processes or outputs, and acceptance criteria for products and services, have been met; d) the use of suitable infrastructure and environment for the operation of processes; e) the appointment of competent persons, including any required qualification; f) the validation, and periodic revalidation, of the ability to achieve planned results of the processes for production and service provision, where the resulting output cannot be verified by subsequent monitoring or measurement; g) the implementation of actions to prevent human error; h) the implementation of release, delivery and post-delivery activities.

Statement of nonconformity

Production process control was not always effectively performed

Objective evidence

During audit shift 1 - for Hot Plate Assembly line - with sample taken : Line Hot plate 1 for BDG D06 - Garnish Sub Assy Backdoor RH/LH - P/N: 76803-BZ090/76804-BZ070 - standard quality control plan - document number : AJI/QA/QCPC/041 - date 12.8.2018 - confirm for annealing process (Heating with oven) with standard process : 75celcius degree +/- 5 celcius degree - with single cycle time : 180 seconds and time : 20 +/- 2 minutes. refer to technical standard the requirements of annealing was defined shall be performed at 77.5 celsius degree +/- 25 celsius degree with time 60 +/- 10 minutes.

Justification for classification

Seen the process has been defined regarding to technical standard defined - other process control could be effectively demonstrated such as : pressing process, hot plate welding process refer to process control defined - this NC could be a minor NC.

Danang Widoyoko **Auditor´s name**	08.Oct.2021 **Audit closing meeting date**	**This document is valid without a signature**

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Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

Missing required	Missing required
Organizations representative	**date**

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 7

To be completed by the CB auditor

NC header

NC identification no.	7 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Predictive, Preventive, Dan Maintenance Corrective Maintenance
Standard clause	8.5.1.5 Total productive maintenance
Requirement	The organization shall develop, implement, and maintain a documented total productive maintenance system. At a minimum, the system shall include the following: a) identification of process equipment necessary to produce conforming product at the required volume; b) availability of replacement parts for the equipment identified in item a); c) provision of resource for machine, equipment, and facility maintenance; d) packaging and preservation of equipment, tooling, and gauging; e) applicable customer-specific requirements; f) documented maintenance objectives, for example: OEE (Overall Equipment Effectiveness), MTBF (Mean Time Between Failure), and MTTR (Mean Time To Repair), and Preventive Maintenance compliance metrics. Performance to the maintenance objectives shall form an input into management review (see ISO 9001, Section 9.3); g) regular review of maintenance plan and objectives and a documented action plan to address corrective actions where objectives are not achieved; h) use of preventive maintenance methods; i) use of predictive maintenance methods, as applicable; j) periodic overhaul.

Statement of nonconformity

Total productive maintenance was not always effectively demonstrated

Objective evidence

Refer to BOT performance review for all categories : Utility, Injection, Surface coating and Assembly, - it has been observed that all BOT could not be effective achieved as a planned and has negative trend such as seen for BOT of Injection until August 2021.

meskipun terdapat analisa dari timbulnya masalah dalam catatan breakdown yang dilaporkan secara strategy rencana tindakan terhadap program perawat mesin tidak efektif ditemukan seperti melakukan evaluasi perawatan mesin dari mesin terkait, dan atau melakukan evaluasi program action plan yang telah disusun. Dalam contoh action plan disebutkan terjadi program overhaul untuk tahun 2021 akan tetapi korelasi dengan pencapaian dari masalah produksi tidak bisa efektif ditampilkan/ even though there is an analysis of the emergence of problems in the breakdown notes reported strategically, the action plan for the machine maintenance program was found to be ineffective, such as evaluating the machine maintenance of the related machine, and or evaluating the action plan program that had been prepared. In the example of the action plan, it is stated that there will be an overhaul program for 2021, but the correlation with the achievement of the production problem cannot be effectively displayed.

Justification for classification

This NC could be a Minor nc - regarding to maintenance plan already planned as preventive maintenance planned, predictive maintenance and measurable objectives that already effectively confirm for year 2021. top management has also shown their commitment with budgeting defined in year 2021

Danang Widoyoko
Auditor´s name

08.Oct.2021
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Correction (Containment) action, including timing and responsible person:
Missing required

Evidence of implementation
Missing required

Root cause analysis
Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result
Missing required

Systemic corrective actions, including timing and responsible person
Missing required

Evidence of implementation
Missing required

Action taken to verify effective implementation of corrective actions
Missing required

Submission(s)	
Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 8

To be completed by the CB auditor

NC header

NC identification no.	8 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Pengendalian Dokumen / Document control Pengendalian Rekaman / Quality records control
Standard clause	7.5.1.1 Quality management system documentation
Requirement	The organization's quality management system shall be documented and include a quality manual, which can be a series of documents (electronic or hard copy). The format and structure of the quality manual is at the discretion of the organization and will depend on the organization's size, culture, and complexity. If a series of documents is used, then a list shall be retained of the documents that comprise the quality manual for the organization. The quality manual shall include, at a minimum, the following: a) the scope of the quality management system, including details of and justification for any exclusions; b) documented processes established for the quality management system, or reference to them; c) the organization's processes and their sequence and interactions (inputs and outputs), including type and extent of control of any outsourced processes; d) a document (i.e., matrix) indicating where within the organization's quality management system their customer-specific requirements are addressed.

Statement of nonconformity

Control document of customer-specific requirements are addressed is not effective

Objective evidence

During audit control of CSR document, It was found that
- Retention document for customer AHM on 15 years and customer ADM on 10 years, however CSR matrix cross customer was not defined related retention document.
- Reference CSR matrix cross customer was not updated it seen on SQAM for Direct Consumable Material Rev. 1, 12.Sep.2014 from customer ADM and QAS for Supplier 4th Edition, Feb 2018 from customer AHM

Justification for classification

It was minor finding because standard retention document has been defined on Retention Document / Record doc. no.AJI/FR/MR/74 rev. 01. Other requirement CSR has been controlled effectively such as working standard, control plan, preservation, identification and traceability, etc

Adi Koesoema **Auditor´s name**	08.Oct.2021 **Audit closing meeting date**	**This document is valid without a signature**

To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation
Missing required

Root cause analysis
Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result
Missing required

Systemic corrective actions, including timing and responsible person
Missing required

Evidence of implementation
Missing required

Action taken to verify effective implementation of corrective actions
Missing required

Submission(s)	
Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 9

To be completed by the CB auditor

NC header

NC identification no.	9 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Plastic Moulding Injection – shift 1 & 2 included Pengendalian Produk Tidak Sesuai/Suspect Product management
Standard clause	8.5.1.3 Verification of job set-ups
Requirement	The organization shall: a) verify job set-ups when performed, such as an initial run of a job, material changeover, or job change that requires a new set-up; b) maintain documented information for set-up personnel; c) use statistical methods of verification, where applicable; d) perform first-off/last-off part validation, as applicable; where appropriate, first-off parts should be retained for comparison with the last-off parts; where appropriate, last-off-parts should be retained for comparison with first-off parts in subsequent runs; e) retain records of process and product approval following set-up and first-off/last-off part validations.

Statement of nonconformity

Process of verify job set-ups is not effective

Objective evidence

During audit production plastic injection for product Lens Head Lamp model 700 P on machine No. 1 (1250T), It was observed that verification job set ups was not conducted such as :
- Standard temperature barrel No. 1 was 285 ± 10 °C, however actual temperature was 270 °C
- Standard pressure injection No. 3 was 95 ± 10 Bar and pressure injection No. 4 was 105 ± 10 Bar, however actual pressure injection No. 3 was 120 Bar and pressure injection No. 4 was 130 Bar

Justification for classification

It was minor finding because measuring product has been conducted effectively such as 100% visual inspection. Other verification job-set up has been cconducted effectively with sampling product Lamp Assy, Day Time Running RL/LH model D55L on machine No. 2

Adi Koesoema	08.Oct.2021	**This document is valid without a signature**
Auditor´s name	**Audit closing meeting date**	

To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation

Missing required

Root cause analysis

Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result

Missing required

Systemic corrective actions, including timing and responsible person

Missing required

Evidence of implementation

Missing required

Action taken to verify effective implementation of corrective actions

Missing required

Submission(s)

Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required

Nonconformity 10

To be completed by the CB auditor

NC header

NC identification no.	10 of 10
Standard	IATF 16949:2016
Classification	minor
Due date max. 60 days	07.Dec.2021
Nonconformity observed in process	Plastic Moulding Injection – shift 1 & 2 included Pengendalian Produk Tidak Sesuai/Suspect Product management
Standard clause	8.3.5.2 Manufacturing process design output
Requirement	The organization shall document the manufacturing process design output in a manner that enables verification against the manufacturing process design inputs. The organization shall verify the outputs against manufacturing process design input requirements. The manufacturing process design output shall include but is not limited to the following: a) specifications and drawings; b) special characteristics for product and manufacturing process; c) identification of process input variables that impact characteristics; d) tooling and equipment for production and control, including capability studies of equipment and process(es); e) manufacturing process flow charts/layout, including linkage of product, process, and tooling; f) capacity analysis; g) manufacturing process FMEA; h) maintenance plans and instructions; i) control plan (see Annex A); j) standard work and work instructions; k) process approval acceptance criteria; l) data for quality, reliability, maintainability, and measurability; m) results of error-proofing identification and verification, as appropriate; n) methods of rapid detection, feedback, and correction of product/ manufacturing process nonconformities.

Statement of nonconformity

Develop control plan is not effective

Objective evidence

During audit production plastic injection for product Lamp Assy, Day Time Running RL/LH model D55L for customer ADM, It was observed that there is measuring weighting after process plastic injection, however this process was not defined on control plan

Justification for classification

It was minor finding because measuring product has been conducted effectively such as 100% visual inspection. Process FMEA was defined for measuring weighting process. Other control plan has been reviewed effectively with sampling product Lens Head Lamp model 700 P

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Auditor´s name	**Audit closing meeting date**	

To be completed by the organization

Correction (Containment) action, including timing and responsible person:

Missing required

Evidence of implementation
Missing required

Root cause analysis
Missing required

Does the root cause impact other similar processes or products?	Missing required

Root cause result
Missing required

Systemic corrective actions, including timing and responsible person
Missing required

Evidence of implementation
Missing required

Action taken to verify effective implementation of corrective actions
Missing required

Submission(s)	
Missing required	Missing required
Organizations representative	date

To be completed by the CB

Date reviewed	Missing required
Reviewer decision	Missing required
Reviewer comments	Missing required
Reviewer name	Missing required