



Problem Analysis Specification

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07 January 2019

E/PDA40-CS602eΩ

710-23-P465912B

**Problem
Statement:
Panels have
rough patches.**

**Some panels on
some presses
All panels on
all presses**

**More than 60
or less than
30 sq. mm.**

Albatross Drone Panels A, B, C, D, F, G

**In shallow draw,
flat, and
straight areas**

19 May, 8:24
(Press 3)

**Most panels on
most presses**

**Rough patches
(spots/cracks)**

19 May

9:40 at Press 6

**Between 8:25
and 9:29 at Press
4; 9:31 and after
at Press 4**

**Sporadically at
Press 3**

Dodo Panels, Phoenix Panels

**Sporadically,
periodically, or
continuously at
Presses 4 and 6**

**19 May, between
7:00 and 8:23
(Press 3)**

**Periodically,
continuously, or
single occurrence
at Press 3**

**In the corners,
tightest curves**

**Spots/cracks—
Between 30
and 60 sq. mm.**

9:30 at Press 4

**NMD on trend in
size**

**—More or
less than 12%
rejected on
Press 6**

Albatross Drone Panel E

**Panel—both
sides**

NMD

At Press 5

Out-of- dimension specifications

**On concave
side of deep
draw curves**

NMD

**Ridges,
pinholes,
pockmarks**

**Stable—6 of 7
panels on 3 of 4
presses**

**Between 6 April
and 18 May**

**More or less
than 33% of
panels rejected
over the course
of the day**

Panels

**Between 8:25
and 9:39 at Press
6; 9:41 and after
at Press 6**

**8:25-8:42; 8:44-9:01;
9:03-9:20; 9:22-9:29;
9:31-9:46; 9:48-10:09;
10:11-10:16; 10:18-
10:27; after 10:29 at
Press 3**

**NMD on trend
in number of
instances**

At presses

NMD

**—More or
less than 14%
rejected on
Press 4**

At Presses
3, 4, 6

**In deep draw
areas, on
convex side
of curves**

**Increasing,
decreasing**

**After 1st
stamping**

**—14% rejected
on Press 4**

**Rough
spots/tiny
surface cracks**

**—12% rejected
on Press 6**

**During
production**

**Before stamping,
after 3-4
stampings**

**Panel—one side
only**

**At the test
facility**

**—33% rejected
on Press 3**

Albatross Panels

**8:43, 9:02, 9:21,
9:30, 9:47, 10:10,
10:17, 10:28 at
Press 3**

**NMD on number
of spots/cracks
per panel**

In inventory

**Before
production**

In the factory

Struts, Nose Cones

**—More or
less than 33%
rejected on
Press 3**

**Up to 33% of
panels rejected
over the course
of the day**

**Single
occurrence at
Presses 4 and 6**