

As require documents for revise drawing



SAPTAGIRI INDUSTRIES

*Part Name : Adjuster ( RE-J1C)*

*Part No : S2AB041070*

# Process defect of welding & Buffing



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## WELDED PROCESS FLOW

## WITHOUT WELDED PROCESS FLOW

Process Constant of Welded adjuster

OPN. NO.	OPERATION	OPN. NO.	OPERATION
10	Raw Material Inward	10	Raw Material Inward
20	Sheet Shearing	20	Sheet Shearing
30	Blanking	30	Blanking
40	U Bending	40	1st Draw
50	First Rounding	50	2nd Draw
60	Second Rounding	60	3rd Draw
70	CO2 Welding (Single Spot)	70	4th Draw
80	Co2 Welding (Full Run)	80	Restracking
90	Weld Bead Turning & Grinding	90	Piercing
100	Buffing	100	Trimming
110	Parting & ID Chamfer	110	Notching
120	Single Notch	120	Face Deburring
130	First Flaring	130	Buffing
140	Second Flaring	140	CED+ Powder Coating
150	Restracking	150	Final Inspection
160	OD Trimming & 8 nos Notching	160	Packing/storing
170	Face Deburring		
180	Buffing		
190	CED+ Powder Coating		
200	Final Inspection		
210	Packing/storing		

Sr.no	Process sequence	Process Defect
10	Raw Material Inward	-
20	Sheet Shearing	-
30	Blanking	-
40	U Bending	-
50	First Rounding	-
60	Second Rounding	-
70	Co2 Welding ( Single Spot )	Incomplete welding , Excess & less welding , Spatter , welding shift
80	Co2 Welding ( Full Run )	Incomplete welding , Excess & less welding , Spatter , welding shift
90	Weld Bead Turning & Grinding	Excess & less turning , step mark , one side turning
100	Buffing	Excess buffing , Step mark ,
110	Parting & ID Chamfer	-
120	Single Notch	-
130	First Flaring	-
140	Second Flaring	-
150	Restracking	-
160	OD Trimming & 8 Nos Notching	-
170	Face Deburring	-
180	Buffing	-
190	CED + Powder coating	-
200	Final Inspection	-
210	Packing	-

# Process defect of welding & Buffing



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Excess welding ,buffing step



Incomplete welding



Welding pin hole



Excess welding ,buffing step



Incomplete welding ,

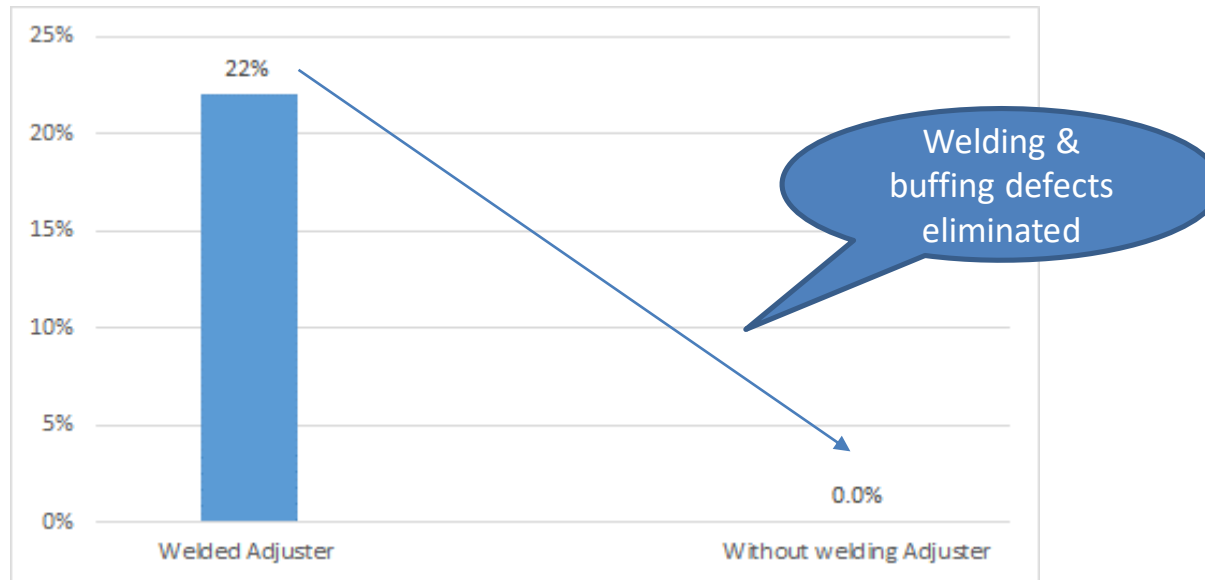


Incomplete welding ,

# Rejection & Rework percentages of both processes



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Welded Adjuster



Without Welded Adjuster



*Thanks...*