

## Defect Details

<b>NC No.</b>	7000828626
<b>NC Date</b>	29/03/2022
<b>NC Submission Date</b>	
<b>Part No.</b>	F2DZ08810B
<b>Part Name</b>	K0PG FORK BOLT
<b>Supplier Name &amp; Code</b>	101037-SHREE PATEL INDUSTRIES
<b>ETL Plant</b>	1136-ETL Suspension Sanand
<b>Defect Details</b>	SALT SPRAY TEST FAIL-SST Failed in 48 Hours

## 1. Problem Description

<b>Defect Description</b>	SST Failed i.e. Heavy White Rust formation observed at part within 48 Hours against the 72 Hours No White Rust formation.
<b>Detection Stage</b>	Receipt
<b>Problem Severity</b>	Function
<b>NG Quantity</b>	2159
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	quality_spi@rediffmail.com
<b>Plant Head/CEO Email ID</b>	planthead_spi@rediffmail.com
<b>MD Email ID</b>	rspatel_spi@rediffmail.com

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	3000	0	0	0	0	3000
<b>Check Qty</b>	3000	0	0	0	0	3000
<b>NG Qty</b>	1	0	0	0	0	1

## Action taken on NG part

<b>Scrap</b>	1
<b>Rework</b>	0
<b>Under Deviation</b>	0

## Containment Action

Hold the material at final inspection & plating.

## 3. Process Flow

## Process Flow Description

10.Incoming RM 20. Traub Turning 30. CNC 1st set up 40. CNC 2nd set up 50. Plating 60. Inspection 70. Packing & Dispatch

## 4. Process Details

<b>Process / Operation</b>	Plating
<b>Outsource</b>	Yes
<b>Machine / Cell</b>	Plating M/C
<b>Machine / Cell No.</b>	Plating M/C No.-1

## 5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Passivation bath tank	During process verification passivation bath tank capacity found change	O
Material	Plating Passivation	During process verification plating passivation pH found drop	O

## 6. Inspection Method Analysis (Current)

<b>Inspection Method</b>	Gauge
<b>Other Inspection Method</b>	
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	Sampling
<b>Sampling</b>	No
<b>Sample Size</b>	05

## 7. Root Cause Analysis (Occurance)

<b>Why 1</b>	Heavy rust observed during SST at customer end.
<b>Why 2</b>	Plating passivation found improper .
<b>Why 3</b>	Passivation PH Drop
<b>Why 4</b>	Passivation tank found leakage & replaced with new one with increased capacity (20 Ltr to 25 ltr)
<b>Why 5</b>	Daily passivation top up chemical was fixed as per 20 ltr bath tank.(50gm/ltr)
<b>Root Cause (Occurance)</b>	Passivation tank found leakage & replaced with new one with increased capacity (20 Ltr to 25 ltr)

## Root Cause Analysis (Outflow)

<b>Why 1</b>	Heavy rust observed during SST at customer end.
<b>Why 2</b>	Inspector not detected dull plated part during final inspection .
<b>Why 3</b>	Inspector was not aware about the defect.
<b>Why 4</b>	No inspection std available at final inspection station
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	No inspection std available at final inspection station

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	1.Daily passivation top up chemical maintain as per new bath tank (From 1.0 ltr to 1.25 ltr) 2. Top coated chemical also maintain as per new bath tank (From 1.0 ltr to 1.25 ltr) . 3. Material send for SST testing , result awaited	Pradeep tripathi	17/06/2022		Pending

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	No
<b>Change Details</b>	No
<b>Inspection Method</b>	Gauge
<b>Other Inspection Method</b>	
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	Sampling
<b>Sampling</b>	No
<b>Sample Size</b>	05

## 10. Evidance of Countermeasure

<b>Occurance (Before)</b>	WI <a href="#">32_Occurance_Before.xlsx</a>
<b>Occurance (After)</b>	WI <a href="#">32_Occurance_After.xlsx</a>
<b>Outflow (Before)</b>	Sampling Plan <a href="#">32_Outflow_Before.xls</a>
<b>Outflow (After)</b>	Sampling Plan <a href="#">32_Outflow_After.xls</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	No
<b>Applicable Machine / Model / Plant</b>	No

## 12. Document Review

<b>Documents</b>	WISOP
<b>Specify Other Document</b>	Sampling Plan

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	
<b>Reason for submission</b>	

