

Defect Details

NC No.	7000842036
NC Date	13/06/2022
NC Submission Date	
Part No.	F2DZ08810B
Part Name	K0PG FORK BOLT
Supplier Name & Code	101037-SHREE PATEL INDUSTRIES
ETL Plant	1136-ETL Suspension Sanand
Defect Details	SALT SPRAY TEST FAIL-SALT SPRAY TEST FAIL

1. Problem Description

Defect Description	SST Failed within 192 Hours i.e. Heavy Red rust observed within 192 Hours. Also plating uncover observed during sampling i.e. plating uncover found in 4 Nos parts out of 10 Nos parts.
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	2592
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

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

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3000	0	0	0	0	3000
Check Qty	3000	0	0	0	0	3000
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action

Hold the material at final inspection and 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

Process / Operation	Plating
Outsource	Yes
Machine / Cell	Plating Tank
Machine / Cell No.	Tank No-01

5. Problem Analysis

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

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

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

Root Cause Analysis (Outflow)

Why 1	Heavy rust observed during SST at customer end.
Why 2	Inspector not detected dull plated part during final inspection .
Why 3	Inspector was not aware about the defect.
Why 4	No inspection std available at final inspection station.
Why 5	
Root Cause (Outflow)	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) . Material send for SST testing , result awaited	Pradeep Tripathi	17/06/2022		Pending
Outflow	1)Training provided to the final inspector about the problem and inspection std.	Pradeep Tripathi	17/06/2022		Pending

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	WI 174_Occurance_Before.xlsx
Occurance (After)	WI 174_Occurance_After.xlsx
Outflow (Before)	Sampling Plan 174_Outflow_Before.xls
Outflow (After)	Sampling Plan 174_Outflow_After.xls

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	No

12. Document Review

Documents	WISOP
Specify Other Document	Sampling Plan

13. Effectiveness Of Action

Reviewed Quantity	
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