

Defect Details

NC No.	7000991752
NC Date	02/03/2024
NC Submission Date	
Part No.	520DZ00212
Part Name	FORK BOLT K60-(DS181012)
Supplier Name & Code	101263-SINGLA PRECISION SCREWS
ETL Plant	1126-ETL Pantnagar
Defect Details	SALT SPRAY TEST FAIL-Plating Peel - Off SST fail in 24 Hours

1. Problem Description

Defect Description	Plating Peel - Off SST fail in 24 Hours
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	2000
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality@singlaprecision.com
Plant Head/CEO Email ID	quality@singlaprecision.com
MD Email ID	aditya@singlaprecision.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2000	0	0	0	0	2000
Check Qty	2000	0	0	0	0	2000
NG Qty	2000	0	0	0	0	2000

Action taken on NG part

Scrap	0
Rework	2000
Under Deviation	0

Containment Action

100% LOT VERIFICATION BY SST AND PLATED PART MOVED IN CURING AREA AFTER PLATING

3. Process Flow

Process Flow Description

1-R/M 2-TRUAB OPERATION 3-PUNCHING ,4-TRG GRINDING 5-ROLLING ,6-PLATING 7-FINAL INSPECTION , 8 FINAL INSPECTION 9-PACKING

4. Process Details

Process / Operation	PLATING
Outsource	No
Machine / Cell	PLATING
Machine / Cell No.	TANK NO-05

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	RM GRADE AND SIZE NOT OK	VALIDATION ANF FOUND OK	O
Method	LOT WISE SST NOT CHECKED	VALIDATION ANF FOUND NOT OK	X
Man	UNAWARENESS OF OPERATOR	VALIDATION AND FOUND OPERATOR SKILL LEVEL OK	O
Tool	N/A	N/A	O
Machine	MACHINE TANK NOT CLEAN AS PER PLAN	VALIDATION AND FOUND NOT OK	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	SST METHOD
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	As samp

7. Root Cause Analysis (Occurance)

Why 1	SALT SPRAY TEST FAIL-Plating Peel - Off SST fail in 24 Hours
Why 2	CLEANING NOT PROPERLY DONE
Why 3	IN ANODIC CLEANING CURRENT NOT FLOWING PROPERLY.
Why 4	CONTACT POINT FOUND LOOSE .THEREFORE, PROPER CURRENT NOT GET TO PARTS.
Why 5	SCHEDULE MADE FOR ALL CONTACT POINT TO BE CHECK ON WEEKLY BASIS.
Root Cause (Occurance)	IN ANODIC CLEANING CURRENT NOT FLOWING PROPERLY. DUE TO LOOSE CONTACT POINT . THEREFORE, PROPER CURRENT NOT GET TO COMPONENTS SO CLEANING WAS NOT PROPER. .

Root Cause Analysis (Outflow)

Why 1	SALT SPRAY TEST FAIL-Plating Peel - Off SST fail in 24 Hours
Why 2	LOT WISE SST PLAN NOT PREPARED
Why 3	AS PER PLAN SST NOT DONE LOT WISE
Why 4	
Why 5	
Root Cause (Outflow)	SST PLAN LOT WISE NOT PREPARED

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	CLEANING NOT PROPERLY DONE	GANESH MAURYA	20/03/2024	19/03/2024	Completed
Outflow	LOT WISE SST PLAN PREPARED CHECK SHEET	Mr GANESH MAURYA	20/03/2024	19/03/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	SST CHECKING PLAN NOT EFFECTIVE
Inspection Method	Other
Other Inspection Method	SST REPORT
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	LOT WISE

10. Evidence of Countermeasure

Occurance (Before)	SALT TEST REPORT UPDATE 708_Occurance_Before.pdf
Occurance (After)	PLATING THIKNESS REPORT UPDATE 708_Occurance_After.pdf
Outflow (Before)	SST PLAN NOT EFFECTIVE 708_Outflow_Before.xlsx
Outflow (After)	LOT WISE SST REPORT PREPARED 708_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	ALL PLATING PART

12. Document Review

Documents	InspCheckSheet
Specify Other Document	SST PLAN UPDATE

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	SST requirement is 168hrs for White Rust & 480hrs for Red Rust, But the plan which you have attached the Red Rust hours mentioned as 400hrs. Secondly Third Party SST Testing done for only 240hrs. Third as the Frequency of your SST is 6 months, then what will be the method to ensure Plating is OK or Not of each lot.

