

## Defect Details

<b>NC No.</b>	8000786395
<b>NC Date</b>	05/05/2022
<b>NC Submission Date</b>	
<b>Part No.</b>	S1AB00612B
<b>Part Name</b>	ADJUSTER PLATED
<b>Supplier Name &amp; Code</b>	100782-NICE STEEL INDUSTRIES
<b>ETL Plant</b>	1136-ETL Suspension Sanand
<b>Defect Details</b>	BUFFING DEFECT-BUFFING STEP, PLATING DEFECTS,

## 1. Problem Description

<b>Defect Description</b>	Buffing Defects like Buffing Step, Buff Cut mark, Heavy Buffing Lines
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Aesthetic
<b>NG Quantity</b>	105
<b>Is Defect Repeatative?</b>	Yes
<b>Defect Sketch / Photo</b>	

## Supplier Communication Details

<b>Quality Head Email ID</b>	ppc.nice@batragroup.biz
<b>Plant Head/CEO Email ID</b>	ho.nice@batragroup.biz
<b>MD Email ID</b>	hitesh@batragroup.biz

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

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	1000	1000	1000	1000	1000	5000
<b>Check Qty</b>	1000	1000	1000	1000	1000	5000
<b>NG Qty</b>	0	1	1	1	0	3

## Action taken on NG part

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

## Containment Action

ALL MATERIAL SEGREGATED BT NICE STEEL IND.

## 3. Process Flow

**Process Flow Description**

10- BLANK 20- U BENDING 30- ROUNDING 40- WELDING 50- FLAIRING 60- ID SIZING 70 -SIDE(OD) GRINDING 80-BROACHING 90-HEAD GRINDING 100- PLATING(OUT SOURCE) 110-RECEIPT FROM PLATING 120-FINAL INSPECTION 130- PACKING & DISPATCH

**4. Process Details**

<b>Process / Operation</b>	70 -SIDE(OD) GRINDING
<b>Outsource</b>	No
<b>Machine / Cell</b>	70 -SIDE(OD) GRINDING
<b>Machine / Cell No.</b>	GRINDING

**5. Problem Analysis**

Type	Possible Cause	Fact Verification	Jud
Material	WRONG MATERIAL USED	MATERIAL VERIFIED AND FOUND OK	O
Machine	MACHINE UNDER OR OVER CAPACITY	MACHIN CAPACITY WAS OK	O
Man	UNTRAINED OPERATOR	OPREATOR WAS SKILLED	O
Method	UTTING FORCE WAS UNEVEN	WELDING BEAD NOT REMOVED IN UNIFORM SHAPE	X
Tool	WRONG BELT USED	BELT FOUND OK	O

**6. Inspection Method Analysis (Current)**

<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	VISUAL
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

**7. Root Cause Analysis (Occurance)**

<b>Why 1</b>	STEP OBSERVED ON FACE OUTER DIA
<b>Why 2</b>	WELDING BEAD WAS NOT GRIND IN UNIFORM SHAPE
<b>Why 3</b>	WELDING BEAD NOT REMOVED PROPERLY
<b>Why 4</b>	CUTTING FORCE WAS NOT IN PROPER WAY
<b>Why 5</b>	OPERATOR NEGLIGENCE
<b>Root Cause (Occurance)</b>	WELDING BEAD WAS NOT GRIND IN UNIFORM SHAPE

**Root Cause Analysis (Outflow)**

<b>Why 1</b>	STEP OBSERVED IN PARTS AT CUTOMER END
<b>Why 2</b>	PROBLEM COULD NOT FOUND DURING INSPECTION
<b>Why 3</b>	THIS PROBLEM WAS OBSERVED FIRST TIME
<b>Why 4</b>	SAMPLE WAS NOT AVAILABLE
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	THIS PROBLEM WAS OBSERVED FIRST TIME

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	TRAINING PROVIDED TO OPREATOR FOR OD BUFFING	NICE STEEL IND	10/05/2022	21/07/2022	Completed
Outflow	SAMPLE PROVIDED FOT VISUAL INSPECTION	NICE STEEL IND.	10/05/2022	21/07/2022	Completed
Outflow	TRAINING PROVIDED TO ALL CONCERN PERSON	NICE STEEL IND	10/05/2022	21/07/2022	Completed
Occurance	OPL DISPLAYED AT SHOP FLOOR FOR AWARENESS	NICE STEEL IND	10/05/2022	21/07/2022	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	100% visual inspection started
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	INSPECTOR DEFINED
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	100%

## 10. Evidance of Countermeasure

<b>Occurance (Before)</b>	NA <a href="#">86_Occurance_Before.jpg</a>
<b>Occurance (After)</b>	1-TRAINING PROVIDED TO ALL CONCERN PERSON 2- OPL DISPLAYED 3- SAMPLE PROVIDED <a href="#">86_Occurance_After.pdf</a>
<b>Outflow (Before)</b>	NA <a href="#">86_Outflow_Before.jpg</a>
<b>Outflow (After)</b>	1-TRAINING PROVIDED TO ALL CONCERN PERSON 2- OPL DISPLAYED 3- SAMPLE PROVIDED <a href="#">86_Outflow_After.pdf</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	Yes
<b>Applicable Machine / Model / Plant</b>	ALL ADJUSTER

## 12. Document Review

<b>Documents</b>	WISOP
<b>Specify Other Document</b>	NA

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	7500
<b>Reason for submission</b>	Found Ok in Reviewed Qty.

