QFR No - 8000788017

Defect Details

NC No.	8000788017
NC Date	19/05/2022
NC Submission Date	
Part No.	S1AB00612B
Part Name	ADJUSTER PLATED
Supplier Name & Code	100782-NICE STEEL INDUSTRIES
ETL Plant	1136-ETL Suspension Sanand
Defect Details	WELDING NOT OK-WELDING BLOW HOLE AT OD SURFACE

1. Problem Description

Defect Description	Blow Hole at OD Surface (Above the welding area)
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	pebw2vym4iu2pqxmtsmh5bjd.png

Supplier Communication Details

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

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	1000	0	2000	2000	5000
Check Qty	0	1000	0	2000	2000	5000
NG Qty	0	0	0	0	5	5

Action taken on NG part

Scrap	5
Rework	0
Under Deviation	0

Containment Action
ALL MATERIAL SEGREGATED

3. Process Flow

Process Flow Description
10- RECEIVING INSPECTION 20- STORAGE 30-BLANK 40- U-BENDING 50-ROUNDING 60-WELDING 70- FLARING 80- ID SIZING 90-SIDE GRINDING 100-BROACHING 110-HEAD GRINDING & BUFFING 120- OUT SIDE MOVEMENT FOR PLATING 130-STORAGE & RQC OF PLATED MATERIAL 140-FINAL INSPECTION 150-PACKING & DISPATCH

4. Process Details

Process / Operation	WELDING
Outsource	No
Machine / Cell	WELDING MACHINE
Machine / Cell No.	MC NO-1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	TOOL WORN OUT	TOOL OK	O
Method	NOZZEL WAS NOT CLEAN	GASS FLOW IMPROPER	X
Man	UNTRAINED OPREATOR	SKILL MATRIX	O
Machine	UNDER/OVER CAPACITY MACHINE USED	FOUND CAPACITY WAS OK	O
Material	WRONG MATERIAL/GRADE USED	MATERIAL FOUND OK	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	WELDING NOT DONE IN PART
Why 2	WELDING UNFILL
Why 3	PIN HOLES ON TO AREA
Why 4	GAS NOT PROPERLY FLOW
Why 5	NOZZEL CLEANING FRQUENCY WAS NOT DEFINED
Root Cause (Occurance)	NOZZEL CLEANING FRQUENCY WAS NOT DEFINED

Root Cause Analysis (Outflow)

Why 1	DEFECTIVE PARTS COULD NOT DETECT DURING FINAL INSPECTION
Why 2	INSPECTOR WAS NOT AWAR ABOUT THE DEFECT
Why 3	PROBLEM FOUND FIRST TIME
Why 4	
Why 5	
Root Cause (Outflow)	INSPECTOR WAS NOT AWAR ABOUT THE DEFECT

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	NOZZEL CLEANING FRQUENCY TO DEFINED	NICE STEEL IND	01/06/2022	01/06/2022	Completed
Outflow	LIMIT SAMPLES TO BE PROVIDED FOT OK AND NG	NICE STEEL IND	01/06/2022	01/06/2022	Completed
Outflow	ONE POINT LESSON UPDATED	NICE STEEL IND	01/06/2022	01/06/2022	Completed
Outflow	TRAINING PROVIDED TO ALL CONCERN PERSON	NICE STEEL IND	01/06/2022	01/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% VISUAL INSPECTION STARTED
Inspection Method	Other
Other Inspection Method	VISUAL
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	VISUAL

10. Evidance of Countermeasure

Occurance (Before)	NA 138_Occurance_Before.jpg
Occurance (After)	NOZZALE CLEANING FRQUENCY DEFINED 138_Occurance_After.pdf
Outflow (Before)	NA 138_Outflow_Before.jpg
Outflow (After)	1-TRAINING PROVIDED TO ALL 2- OPL DISPLAYED 138_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	ControlPlan, WISOP
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	6000

Reason for submission	Verified qty of 6000 Nos by 100% inspection and found effective.