QFR No - 8000788018

Defect Details

NC No.	8000788018
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 SPATTER

1. Problem Description

Defect Description	Welding Spatter at Outer Surface
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	1000	4000
Check Qty	0	1000	0	2000	1000	4000
NG Qty	0	1	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
ALL MATERIAL TO BE RECHECKED

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 / Cell No.	1

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	WRONG MATERIAL USED	MTC VERIFIED AND FOUND OK	O
Man	UNTRAINED OPERATOR	SKILL MATRIX AVAILABLE	O
Machine	LOW/HIGHER CAPACITY MACHINE USED	MACHINE FOUND OK	O
Tool	TIP/NOZZELE WAS NOT CLEAN	NOZZEL CLEANING NOT DONE	X
Method	PROCESS SHEET WAS NOT FOLLOWED	CHECK AND FOUND OK	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	WELDING SPATTER IN PART
Why 2	WELDING PARTICALS GENERATED DURING WELDING
Why 3	WELDING WIRE STUCK IN NOZZELE
Why 4	WELDING DUST IN NOZZELE
Why 5	NOZZELE WAS NOT CLEAN
Root Cause (Occurance)	1-WELDING DUST IN NOZZELE 2-NOZZELE WAS NOT CLEAN

Root Cause Analysis (Outflow)

Why 1	DEFECTIVE PART NOT DETECT DURING INSPECTION
Why 2	PROBLEM COULD NOT DETECT DURING SAMPLING INSPECTION
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	PROBLEM COULD NOT DETECT DURING SAMPLING INSPECTION

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	NOZZELE CLEAING FREQUENCY TO BE DEFINED	NICE STEEL	01/09/2022	14/06/2022	Completed
Outflow	OPL DISPLAYED AND 100% VISUAL INSEPCTION STARTED	NICE	01/09/2022	14/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% VISUAL INSPECTION
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)	MACHINE CHECKSHEET ATTACHED 139_Occurance_Before.pdf
Occurance (After)	MACHINE CHECKSHEET ATTACHED 139_Occurance_After.pptx
Outflow (Before)	NO ANY DOCUMENTS 139_Outflow_Before.pdf
Outflow (After)	OPL ATTACHED 139_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	....

12. Document Review

Documents	PMCheckSheet, WISOP, JHCheckSheet
Specify Other Document	TRAINING RECORDS

13. Effectiveness Of Action

Reviewed Quantity	10500
Reason for submission	Reviewed quantity and found not repeated