

Defect Details

NC No.	8000788019
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	SHADE VARIATION-SHADE VARIATION

1. Problem Description

Defect Description	Shade Variation i.e. Heavy Blueness observed
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	200
Is Defect Repeative?	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	500	1000	1000	1000	3500
Check Qty	0	500	1000	1000	1000	3500
NG Qty	0	0	0	500	0	500

Action taken on NG part

Scrap	0
Rework	500
Under Deviation	0

Containment Action

RE-PLATING DONE IN ALL SUSPECTED MATERIAL

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	PLATING
Outsource	Yes
Machine / Cell	PASSIVATION TANK
Machine / Cell No.	PASSIVATION TANK

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	WRONG MATERIAL USED	MATERIAL OK AS PER DRAWING	O
Tool	TOOL WEAR OUT	TOOL FOUND OK	O
Method	PASSIVATION TIME WAS LESS	PROCESS CHECKSHEET	X
Man	UNTRAINED OPERATOR	SKILL MATRIX AVAILABLE	O
Machine	MACHINE CAPACITY NOT OK	CAPACITY OK AS PER DEFINED	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	CHEMICAL ANALYSIS
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	AS PER

7. Root Cause Analysis (Occurance)

Why 1	PASSIVATION COLOUR CHANGED
Why 2	PASSIVATION NOT DONE AS PER REQUIERMENT
Why 3	PASSIVATION TIME WAS LESS
Why 4	LOT REMOVED FROM TANK BEFORE REQUIERD TIME
Why 5	MANUAL CONTROL
Root Cause (Occurance)	PASSIVATION TIME WAS LESS

Root Cause Analysis (Outflow)

Why 1	WRONG PASSIVATION PARTS DISPATCHED
Why 2	BOTH PASSIVATION PARTS PASSED BY FINALMINSPECTOR
Why 3	LIMIT SAMPLES WAS NOT DEFINED
Why 4	
Why 5	
Root Cause (Outflow)	MASTER SAMPLE WAS NOT AVAILABLE

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	PLC LINE IMPLEMENTED FOR ALL PARAMETER CONTROLLING LIKE TIME , TEMP ETC	NICE	24/05/2022	15/05/2022	Completed
Outflow	SAMPLE PROVIDED TO FINAL INSPECTION TEAM FOR COLOUR VARATION	NICE	22/05/2022	15/05/2022	Completed
Occurance	PASSIVATION TIME FROZEN	NICE STEEL IND	01/11/2022	15/05/2022	Inprocess

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	BEFORE - PROCESS/LINE PICTURE ATTACHED 140_Occurance_Before.jpg
Occurance (After)	AFTER-PROCESS/LINE PICTURE ATTACHED 140_Occurance_After.jpg
Outflow (Before)	BEFORE - CP FILE ATTACHED 140_Outflow_Before.pdf
Outflow (After)	AFTER-CP FILE ATTACHED 140_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO APPLICABLE

12. Document Review

Documents	ControlPlan
Specify Other Document	NOT REQUIRED

13. Effectiveness Of Action

Reviewed Quantity	0
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Reason for submission

Problem Analysis Fact Verification observation to be written in details. Also Occurrence side why why analysis side caus and action are not adequate. Flow side Countermeasuers are not taken and Documents reviewed and updated are not adequate.