

Defect Details

NC No.	8000826937
NC Date	21/04/2023
NC Submission Date	
Part No.	S1AB00612B
Part Name	ADJUSTER PLATED
Supplier Name & Code	100782-NICE STEEL INDUSTRIES
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	WELDING NOT OK-WELDING IMPROPER(WELDING FULLY NOT DONE)

1. Problem Description

Defect Description	K0PG Adjuster improper welding (gap) issue
Detection Stage	Inprocess
Problem Severity	Safety
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	fu2bupllcnyrk2unwi3od0jq.xlsx

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	1000	1000	0	3000	1000	6000
Check Qty	1000	1000	0	3000	1000	6000
NG Qty	0	0	0	2	1	3

Action taken on NG part

Scrap	0
Rework	3
Under Deviation	0

Containment Action

All material segregated and training provided to all concern person

3. Process Flow

Process Flow Description

10 RECEIVING INSPECTION 20 STORAGE 30 BLANKING 40 1st BENDING (`U` BENDING) 50 FINAL BENDING (ROUNDING) 60 MIG WELDING 70 FLAIRING 1st 80 FLAIRING 2nd 90 ID SIZING 100 SIDE GRINDING & BUFFING 110 BROACHING 120 HEAD GRINDING 130 OUTSIDE MOVEMENT FOR PLATING 140 STORAGE & RQC INSP. OF PLATED MATERIAL 150 FINAL INSPECTION 160 PACKING & DISPATCH

4. Process Details

Process / Operation	MIG WELDING
Outsource	No
Machine / Cell	WELDING MACHINE
Machine / Cell No.	1,2,3

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	WRONG MATERIAL USED	MATERIAL TEST REPORT AVAILABLE	O
Man	UNSKILL MANPOWER - WEDLER	SKILL MATRIX AVAILABLE	O
Method	SOP NOT FOLLOWED	INPROCESS RECORDS AVAILABLE	O
Machine	MACHINE PARAMETER NG	CHECK AND FOUND NG	X

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	VISUAL

7. Root Cause Analysis (Occurance)

Why 1	WELDING NOT PROPERLY DONE IN PART (WELDING NG)
Why 2	MATERIAL NOT PROPERLY REACHED AT LOCATION (IN GAP 0.80MM TO 1.35 MM)
Why 3	WEDLING MATERIAL NOT MELT AS REQUIRED
Why 4	CURRENT WAS LOW
Why 5	MALFUNCTION OF MACHINE AT RUNNING TIME DUE TO RELAY IMPROPER WOKRING
Root Cause (Occurance)	MALFUNCTION OF MACHINE AT RUNNING TIME DUE TO RELAY IMPROPER WOKRING

Root Cause Analysis (Outflow)

Why 1	DEFECTIVE PART PASSED AT CUSTOMER END
Why 2	DEFECT COULD NOT DETECT DURING INSPECTION
Why 3	DEFECT IN ID AND ID COVERD DURING GAUGE INSPECTION
Why 4	
Why 5	
Root Cause (Outflow)	DEFECT IN ID AND ID COVERD DURING GAUGE INSPECTION

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	QUALITY GATE IMPLEMENTED	NICE STEEL IND	23/04/2023	22/04/2023	Completed
Occurance	RELAY CHANGED AND RELAY TO BE CHECKED EVERY YEAR DURING PREVE NTIVE MAINTENACE	NICE STEEL IND	23/04/2023	22/04/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	QUALITY GATE IMPLEMENTED
Inspection Method	Other
Other Inspection Method	OPL DISPLAYED
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	PM CHECKSHEET BEFORE 417_Occurance_Before.pdf
Occurance (After)	PM CHECKSHEET AFTER CHECKPOINT ADDED 417_Occurance_After.pdf
Outflow (Before)	TRAINING RECORDS 417_Outflow_Before.jpg
Outflow (After)	TRAINING RECORDS 417_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	CHECKPOINT IMPLEMENTED FOR ALL WELDING MACHINES

12. Document Review

Documents	PMCheckSheet, WISOP
Specify Other Document	PM CHECKSHEET UPDATE

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	Reviewed 500 numbers found ok

