QFR No - 8000831275

Defect Details

NC No.	8000831275
NC Date	01/06/2023
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-IMPROPER WELDING (GAP) , EXTRA WELDING P

1. Problem Description

Defect Description	adjuster welding issues (improper welding (gap))
Detection Stage	Receipt
Problem Severity	Safety
NG Quantity	6036
Is Defect Repeatative?	No
Defect Sketch / Photo	25w4rf2t3qmac05lbmkjdpe3.gif

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	2000	2000	1000	1000	0	6000
Check Qty	2000	2000	1000	1000	0	6000
NG Qty	5	8	0	0	0	13

Action taken on NG part

Scrap	0
Rework	13
Under Deviation	0

Containment Action
100% VISUAL INSPECTION TO BE DONE

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	WELDING
Outsource	No
Machine / Cell	MIG WELDING MACHINE
Machine / Cell No.	MACHINE NO 6,7

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	NOZZELE TIP WAS NOT CLEAN	TIP CLEANIN G FREQUENCY WAS DEFINED	O
Man	UNTRAINED OPERATOR	OPERATOR WAS UNDER TRIAL	X
Method	SYATEM WAS NOT DEFINED FOR HANDLING OF OPERATOR TRIAL PARTS	PART FOUND NG DURING OPERATOR TRIAL	X
Material	MIG WIRE DIA WAS UNDER SIZE/ OVER SIZE	MIG WIRE DIA WAS OK AS PER DEFINED	O
Machine	MACHINE WAS NOT OK	MACHINE 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	IS:2500

7. Root Cause Analysis (Occurance)

Why 1	WELDING CRACK IN PART
Why 2	WELDING MATERIAL NOT FILL COMPLETELY IN THE GAP
Why 3	OPERATOR WAS SEMISKILLED
Why 4	OPERATOR WAS UNDER TRIAL
Why 5	
Root Cause (Occurance)	1-OPERATOR WAS UNDER TRIAL 2- SYSTEM WAS NOT DEFINED TO HANDLING THE OPERATOR TRIAL PARTS

Root Cause Analysis (Outflow)

Why 1	OK & NG PART MIXUP
Why 2	SYSTEM WAS NOT DEFINED TO HALDING THE OPERATOR TRIAL PARTS
Why 3	
Why 4	
Why 5	

Root Cause (Outflow)	SYSTEM WAS NOT DEFINED TO HALDING THE OPERATOR TRIAL PARTS

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	100% VISLA INSPECTION TE BE STARTED	NICE	06/06/2023	06/06/2023	Completed
Occurance	LOCATION TO BE DEFINED FOR OPERATOR TRIAL PARTS	NICE	06/06/2023	06/06/2023	Completed
Occurance	OPERATOR OBSERVATION SYSTEM TO BE STARTED DURING TRIAL PERIOD	NICE	06/06/2023	06/06/2023	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	NO ANY WELDING AREA FOR UNDER TRIAL WELDER 463_Occurance_Before.jpg
Occurance (After)	WELDING AREA MADE FOR UNDER TRIAL WELDER 463_Occurance_After.jpg
Outflow (Before)	NO ANY SEPRATE AREA FOR OPERATOR TRIAL PARTS 463_Outflow_Before.jpg
Outflow (After)	AREA MADE FOR OPERATOR TRIAL PARTS 463_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	OTHER WELDING PART - BOTTOM ACK

12. Document Review

Documents	WISOP
Specify Other Document	WI & OPL

13. Effectiveness Of Action

Reviewed Quantity	500
Reason for submission	