QFR No - 8000884639

Defect Details

NC No.	8000884639
NC Date	30/07/2024
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

1. Problem Description

Defect Description	Adjuster improper welding defects issue
Detection Stage	Receipt
Problem Severity	Safety
NG Quantity	1386
Is Defect Repeatative?	Yes
Defect Sketch / Photo	nukwu5cfxpybz1b4adopzotb.jpg

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	0	0	2000	1000	4000
Check Qty	1000	0	0	2000	1000	4000
NG Qty	10	0	0	50	10	70

Action taken on NG part

Scrap	0
Rework	70
Under Deviation	0

Containment Action
1- Stock checked at Nice end . 2- Training provided to inspection team about visual defects 3- Quality gate implemented to control the out flow of parts. 4-One point lesson displayed at quality table .

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 REROUNDING 120 BROACHING 130 HEAD GRINDING 140 OUTSIDE MOVEMENT FOR PLATING 150 STORAGE & RQC INSP. OF PLATED MATERIAL 160 FINAL INSPECTION 170 PACKING & DISPATCH

4. Process Details

Process / Operation	WELDING
Outsource	No
Machine / Cell	MIG WELDING
Machine / Cell No.	10,11

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	UNSKILLED MANPOWER WAS DEPUTED AT WELDING	SKILLED MANPOWER WAS AVAILABLE AND SKILL MATRIX VERIFIED	O
Material	WRONG MATERIAL USED	MTC VERIFIED	O
Machine	HIGHER/LOWER CAPACITY MACHINE USED	MACHINED VERIFIED AND FOUND OK	O
Tool	Gap of Joint is over size	Gap not maintained during rounding	X
Method	PROCESS PARAMETER CHANGED	CHECKED AND FOUND OK	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Part crack at one side from gap due to One side welding was not proper in part gap
Why 2	One side welding was over fill and other side was uneven welding
Why 3	Gap of Joint is over size
Why 4	Gap not maintained during rounding
Why 5	Error in Rounding operation
Root Cause (Occurance)	1-Gap of Joint is over size 2-Error in Rounding operation

Root Cause Analysis (Outflow)

Why 1	Defective part passed at customer end
Why 2	Defective part not detected by inspector
Why 3	Inspector was not followed the WI
Why 4	
Why 5	

Root Cause (Outflow)	Defective part not detected by inspector

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	200% inspection started	Nice Steel Ind.	31/07/2024	01/08/2024	Completed
Occurance	Die design changed and now Gap to be provided in tapper in die	Nice Steel	01/08/2024	01/08/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	200% visual inspection started
Inspection Method	Other
Other Inspection Method	200%
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	200%

10. Evidance of Countermeasure

Occurance (Before)	Tool design 980_Occurance_Before.png
Occurance (After)	Tool design 980_Occurance_After.png
Outflow (Before)	NO DOCUMENT 980_Outflow_Before.png
Outflow (After)	OPL 980_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NOT APPLICABLE

12. Document Review

Documents	WISOP
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	1000

Reason for submission	still we are receiving the welding issues