

B	C	D	E	F	G	H	I	J	K	L	M	N	O	P
140	Trivalent Passivation	1		Conc. Of Trivalent Passivation	M	60 - 80 gm / ltr		Chemical Analysis		Daily	Check sheet	Yes		
		2		PH of Solution	M	1.8 - 2.2		PH Meter		At Start / 4 Hrs.	Check sheet	Yes		
		3		Temp. of Solution	M	30 - 50 °C		Temp Controller		Verify at Start			No	In Case Report Indicates Zinc Conc. >15000 ppm Discarding Frequency to be reviewed
		4		Dip Tim	M	30 - 60 Sec.		Timer		Verify at Start			No	
		5		Discard		After Zinc Reaches 15000 ppm Iron reaches 250 ppm		Aas Test		Every 10 Days	Lab Record	Yes		
		6		Appearance	M			Visual						

BEFORE- CONCENTRATION WAS 60-80gm/ltr

140	Trivalent Passivation	1		Conc. Of Trivalent Passivation	M	90 - 110 gm / ltr		Chemical Analysis		Daily	Check sheet	Yes		
		2		PH of Solution	M	1.8 - 2.2		PH Meter		At Start / 4 Hrs.	Check sheet	Yes		
		3		Temp. of Solution	M	30 - 50 °C		Temp Controller		Verify at Start			No	In Case Report Indicates Zinc Conc. >15000 ppm Discarding Frequency to be reviewed
		4		Dip Tim	M	30 - 60 Sec.		Timer		Verify at Start			No	
		5		Discard		After Zinc Reaches 15000 ppm Iron reaches 250 ppm		Aas Test		Every 10 Days	Lab Record	Yes		
		6		Appearance	M			Visual						

AFTER- CONCENTRATION is increased 90-110 gm/ltr

PART NAME :- ADJ KOPGAREA:- ASSEMBLY
PROBLEM:-PLATING PASSIVATION NG

MY CHECK POINT
FOR INPROCESS

APPROVED BY:-

VARIFIED BY:-

MADE
BY:-

Mr. Subodh
Upadhyay

Mr. Nimit
Prakash

Mr. Nimit Prakash

CHECK POINT

FOR INSPECTION :-

- 1-पार्ट में नीला प्लेटिंग नहीं होना चाहिये
- 2-पार्ट को विसुअल चेक करे गलत पार्ट आगे नहीं जाना चाहिए

नोटरू

खराब पीस मिलने पर उसे रेड बिन में रखे -
किसी भी अनियमित परिस्थिति में तुरंत
सुपरवाइजर को सूचित करे

PHOTOGRAPH EXAMPLE



NG



OK

S.NO	TRAINING NEED	NAME /DEPT	PLANNED MONTH	TO BE PROVIDED BY	DATE OF TRAINING	EFFECTIVENESS VERIFICATION & FOLLOW UP
	<p>Plating passivation Issue at Supplier end</p> <p><u>In process:-</u> Con. of passivation Before - 60-80 gm/Ltr. After - 90-110 gm/Ltr</p> <p><u>Final Inspection</u> Part - 100% की जाँच करिए।</p> <p>100% की जाँच करिए।</p>	<p>Balendar Bal Devender D Kjendar- 2019 Sushil S SUKHAR- 2019</p>	-	Dr. S. S. S.	2/6/2022	