



# Improvement Details Of Surface Coated Parts

# Details of implementation



SAPTAGIRI INDUSTRIES

Material Description	Part Number	Reason for rejection	Probable Causes for rejection	Root cause for rejection	Cause side Actions which are taken to eliminate the rejection	Inspection Side action	Implementation date/ month
Powder coated parts		Bubble mark	Oil content presence on the parts		After phosphating drier installed	Phosphating sample panel made 100 % verification of phosphating parts	03-12-2022
		Bubble mark	Excess powder spray	Due to manual ,operator sprayed by double or excess at specific area of the parts	Trained operator deploy Skilled matrix made by stage wise		03-12-2022
		Bubble mark	Final inspection not done as per limit sample	-	-	Limit sample made 100 % final inspection carry out	03-12-2022
Powder coated parts		Pin hole	Oil content presence on the parts	Phosphating not adequate	After phosphating drier installed	Phosphating sample panel made 100 % verification of phosphating parts	10-10-2022
		Pin hole	Excess powder spray	Due to manual operator sprayed by double or excess	Trained operator deploy Skilled matrix made by stage wise		10-10-2022
Powder coated parts		Over coat	Excess part loading	Less space in between two parts	Jig loading SOP made Part wise jig provided		12-10-2022
		Over coat	Powder not charge ( Earthing missing )	Due to manual operation	Trained operator deploy Skilled matrix made by stage wise		12-10-2022

# Details of implementation



SAPTAGIRI INDUSTRIES

Material Description	Part Number	Reason for rejection	Probable Causes for rejection	Root cause for rejection	Cause side Actions which are taken to eliminate the rejection	Inspection Side action	Implementation date/ month
Powder coated parts		Shade variation/ Uncover	Batch to batch powder shade variation	Gloss level variation	Batch wise segregation done with verification of powder shade , *Batch wise small amount of qty used for the sample production if it is ok as per Q requirement and does not observed any issue so will continue the same . *It's method started	100 % inspection	12-09-2022
		Shade variation/ Uncover	Baking temperature less or excess	Variation in baking temperature	Baking temperature validated by TTR Baking temperature set by PLC controller	Baking temperature verified by Daily process check sheet	12-09-2022
Powder coated parts		Dust	After phospheting dust on the parts	Dust sticks on the phospheting parts	After phospheting part clean by lead free hand gloze & medicotton	100 % inspection	15-09-2022
		Dust	Dust particle in powder	Some of powder boxes observed dust	If powder filter some how other defect will come that is white sparkle	(Already trial done )	16-09-2022
		Dust	Environmental dust particle	Environmental dust particle	Powder coating area covered Shop floor cleaned every time Jig cleaning / Burning done on daily basis		18-09-2022

## Details of implementation



SAPTAGIRI INDUSTRIES

Material Description	Part Number	Reason for rejection	Probable Causes for rejection	Root cause for rejection	Actions which are taken to eliminate the rejection	Inspection Side action	Implementation date/ month
Powder coated parts		Scratches mark/ line mark/ Dent mark	Rough handling at part unloading stage	Rough handling	Part unloading area identified Part unloading SOP make		08-10-2022
		Scratches mark/ line mark/ Dent mark	For storing used box instead of bin	Using boxes for internal material handling	Bin provided for internal material handling		08-10-2022
		Scratches mark/ line mark/ Dent mark	Used Polly bag instead off new paper for Dust shell rapping	Polly bag used for dust shell rapping	Paper rapping started for dust shell		08-10-2022
		Scratches mark/ line mark/ Dent mark	Material movement stop from Samarth Ent. To Saptagiri Eng. After powder coating		Material movement reduced, from Samarth Ent. To Saptagiri Eng. After powder coating		11-11-22
		Scratches mark/ line mark/ Dent mark	Final inspection carry out at Saptagiri Ind.		Final inspection started at Samarth Ent. Instead of Saptagiri Ind.		11-11-22
		Scratches mark/ line mark/ Dent mark	No Limit sample made		Limit sample make and sign of by customer		11-11-22
		Scratches mark/ line mark/ Dent mark	While transport for packing boxes of dust shell rub with the box's partition and generated rubbing mark ( At that time used plastic Polly bag )	While transport for packing boxes of dust shell rub with the box's partition and generated rubbing mark ( At that time used plastic Polly bag )	News paper rapped with dust shell and packed with partition boxes for supplies		15-12-22
		Scratches mark/ line mark/ Dent mark	Boxes' staple pin contact with powder coated dust shell while transport and generated scratches mark	Boxes' staple pin contact with powder coated dust shell while transport and generated scratches mark	Boxes' staple pin covered by additional box paper to avoided contact with each other dust shell and staple pin		18-12-22

# Details of implementation at final inspection



SAPTAGIRI INDUSTRIES

## Q gate

## Model wise separate inspection table



## Material Input & Out put area allotted





*Thanks...*