

Part Name : Adjuster (Kawasaki)

Part No : S2AB044120

PROCESS FLOW OF WELDED ADJUSTER



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Process defect of welding & Buffing



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Process Defect

Sr.no	Process sequence	Process Defect
10	Raw Material Inward	-
20	Sheet Shearing	-
30	Blanking	-
40	U Bending	-
50	First Rounding	-
60	Second Rounding	-
70	Co2 Welding (Single Spot)	Incomplete welding , Excess & less welding , Spatter , welding shift
80	Co2 Welding (Full Run)	Incomplete welding , Excess & less welding , Spatter , welding shift
90	Weld Bead Turning & Grinding	Excess & less turning , step mark , one side turning
100	Buffing	Excess buffing , Step mark ,
110	Parting & ID Chamfer	Cross parting
120	Single Notch by drill	Cross slot , drill out
130	First Flaring	-
140	Second Flaring	-
150	Restracking	-
160	OD Trimming & 8 Nos Notching	-
170	Face Deburring	-
180	Buffing	-
190	CED + Powder coating	-
200	Final Inspection	-
210	Packing	-

Rejection percent
22 %



Excess welding ,buffing step



Incomplete welding



Welding pin hole



Excess welding ,buffing step

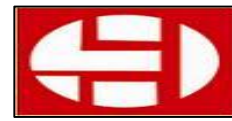


Incomplete welding ,



Welding Crack

Process defect of welding & Buffing



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Excess welding ,buffing step



Incomplete welding



Welding pin hole



Excess welding ,buffing step



Incomplete welding ,

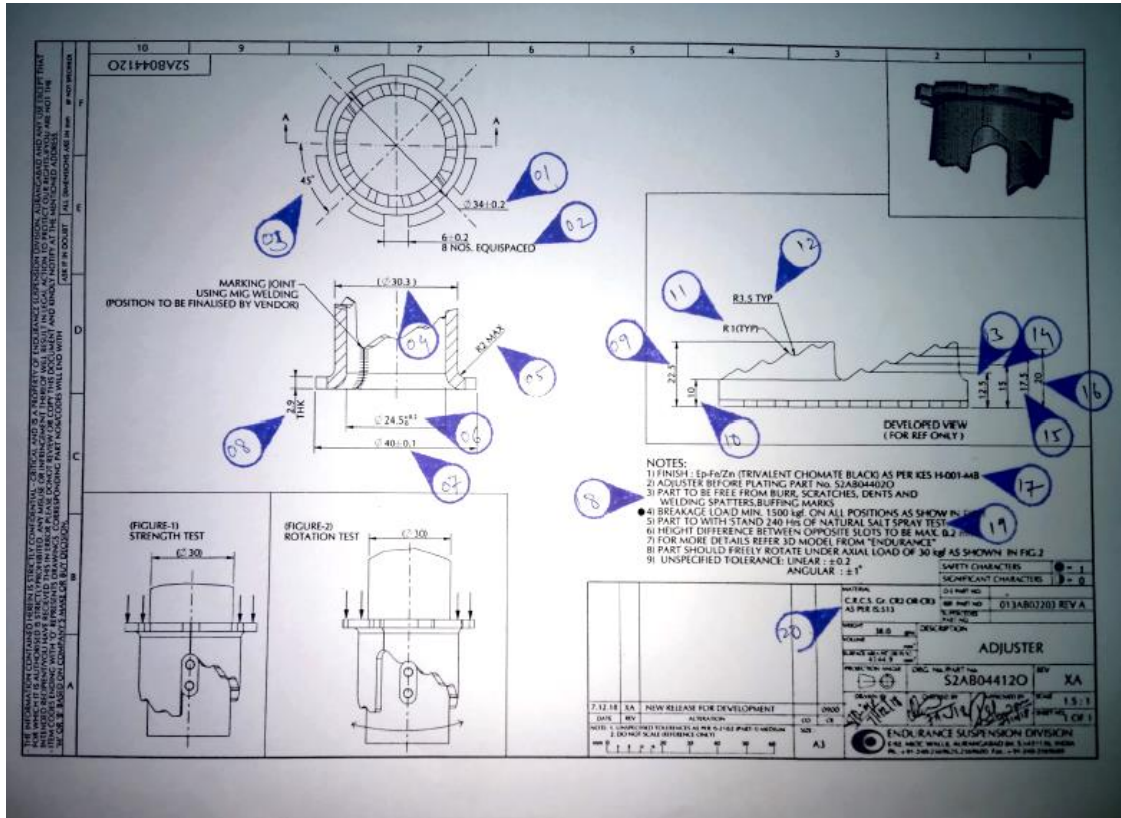


Incomplete welding ,

SAMPLE INSPECTION REPORT OF WITHOUT WELDED ADJUSTER



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SAPTAGIRI ENGINEERING PVT. LTD.	SAMPLE INSPECTION REPORT	Doc.no:SI/OA/12 Rev. no :00 Rev. Date:01.08.2017
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Part Name: Kawasaki Adjuster
Part No.: S2AB044120
Customer Part No.: S2AB044120
Model: KAWASAKI
Date: 8-Jun-23

Sr. No.	Parameter	Specification	Checking Instrument	L.C.	Observation					Remarks
					1	2	3	4	5	
1	Notch Diameter	Ø34±0.2	DVC	0.01	33.97	33.96	33.95	33.98	34.04	Ok
2	Dimension	6±0.2	DVC	0.01	5.98	6.02	6.04	6.03	5.99	Ok
3	Angle	45°±1°	Profile Projector	0.01	45.12°	45.15°	45.11°	45.13°	45.16°	Ok
4	Outer Diameter	Ø30.3±0.2	DVC	0.01	30.88	30.81	30.85	30.84	30.82	*
5	Radius	R2 Max.	Radius Gauge	—	Ok	Ok	Ok	Ok	Ok	Ok
6	Inner Diameter	Ø24.5±0.2/-0.0	DVC	0.01	24.67	24.68	24.67	24.65	24.63	Ok
7	Outer Diameter	Ø40±0.1	DVC	0.01	39.93	39.94	39.96	39.95	39.94	Ok
8	Thickness	2.9±0.2	DVC	0.01	3.01	3.02	3.04	3.02	3.01	Ok

DEVELOPED VIEW (FOR REF. ONLY)

9	Dimension	22.5±0.2	HG+Dial	0.01	22.69	22.7	22.68	22.69	22.68	Ok
10	Dimension	10±0.2	HG+Dial	0.01	10.19	10.18	10.19	10.18	10.17	Ok
11	Radius	R1 TYP	Radius Gauge	—	Ok	Ok	Ok	Ok	Ok	Ok
12	Radius	R3.5 TYP	Radius Gauge	—	Ok	Ok	Ok	Ok	Ok	Ok
13	Dimension	12.5±0.2	HG+Dial	0.01	12.69	12.65	12.68	12.69	12.67	Ok
14	Dimension	15±0.2	HG+Dial	0.01	15.2	15.19	15.18	15.17	15.18	Ok
15	Dimension	17.5±0.2	HG+Dial	0.01	17.7	17.69	17.68	17.69	17.68	Ok
16	Dimension	20±0.2	HG+Dial	0.01	20.19	20.17	20.18	20.16	20.15	Ok

DEVELOPED VIEW FOR TOP PLATE

17	Finish : EP-FE ZN (trivalent chromate black) as per KES H-001-HB	Visual	—	Supplier Pdi report attached					Ok
18	Appearance:-Part to be free from Burr,Dent, &buffing marks	Visual	—	Ok	Ok	Ok	Ok	Ok	Ok
19	SST test for 240 hrs	Lab Test	—	Under Testing					*
20	Material: C.R.C.S. Gr CR2 or CR3 as per IS 513	—	—	MTC Report Attached					Ok

Note:
Mr.Kedar Mungale Inspected By :
Mr. Nitin Wagade Approved By :

PROCESS FLOW OF WITHOUT WELDED ADJUSTER



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BENEFITS & INHOUSE REJECTION PERCENTAGES

Benefits :

- ❖ Eliminated the critical process that welding , Turning , & Buffing process
- ❖ For the welding , Turning & Buffing defects, Inhouse rejection percentages 22 % has been eliminated
- ❖ Inhouse rework for the welding spatter , Incomplete welding run , buffing step mark & notching profile completely eliminated
- ❖ Reduced the material handling & material movement from press shop to welding shop and buffing shop also.
- ❖ Breaking load improved as compared to welded part.
- ❖ Aesthetic Q requirements improved



Welded Adjuster



Without Welded Adjuster



Thanks...