QFR No - 7000873898

Defect Details

NC No.	7000873898
NC Date	02/11/2022
NC Submission Date	
Part No.	533BW00102
Part Name	BUMP STOP
Supplier Name & Code	101023-FORES ELASTOMECH INDIA PVT. LT
ETL Plant	1126-ETL Pantnagar
Defect Details	DAMAGES-Flashes and cut marks

1. Problem Description

Defect Description	Flash and cut mark
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	1140
Is Defect Repeatative?	Yes
Defect Sketch / Photo	1y2tfrc3sjh55rzkgshxu2me.jpg

Supplier Communication Details

Quality Head Email ID	malani.pritam@foresgroup.com
Plant Head/CEO Email ID	singh.barinder@foresgroup.com
MD Email ID	swamy.pj@foresgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	20000	0	0	8000	0	28000
Check Qty	1140	0	0	8000	0	9140
NG Qty	1140	0	0	44	0	1184

Action taken on NG part

Scrap	1184
Rework	0
Under Deviation	0

Containment Action
100 % sorting done at M/s ETL End with third party & also sorting done at Fores End.

3. Process Flow

Process Flow Description
Rubber & Chemical - Inward inspection - Rubber Mixing - Hardness inspection - Moulding - Visual inspection - Standard packing & Dispatch.

4. Process Details

Process / Operation	Rubber Moulding
Outsource	No
Machine / Cell	Moulding
Machine / Cell No.	Moulding

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Less or more temperature	PLC control / Machine stop if parameter not okay	O
Material	Wrong material used	We have checked hardness data last six month & found okay	O
Tool	Mould tool not okay	Mould leakage	X
Machine	Less or more curing time .	PLC control / Machine stop if parameter not okay	O
Man	Skipped from inspection .	NG parts found at customer End .	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	4000

7. Root Cause Analysis (Occurance)

Why 1	During deflashing operation .
Why 2	Difficult to deflashing due to thick flash
Why 3	Material flow not uniform due to mould leakage .
Why 4	Mold parallelism not okay .
Why 5	Mold tool PM frequency is Less .
Root Cause (Occurance)	Mold tool PM frequency is Less .

Root Cause Analysis (Outflow)

Why 1	Flash & cut mark on part .
Why 2	NG part found at customer end .
Why 3	Inspector not aware .
Why 4	
Why 5	
Root Cause (Outflow)	Inspector not aware .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Training & awareness given to inspector. OPL display at inspection stage .	Mr Amar	15/10/2022	14/10/2022	Completed
Occurance	Mould PM frequency Increase .	Mr Ravi	11/10/2022	11/10/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Visual inspection .
Inspection Method	Other
Other Inspection Method	Visual inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	4000

10. Evidance of Countermeasure

Occurance (Before)	Mould Leakage . 298_Occurance_Before.pdf
Occurance (After)	Blue matching done & mould parallelism found okay. Mould PM frequency Increase from 7000 shots to 5000 Shots . 298_Occurance_After.pdf
Outflow (Before)	inspector not aware . 298_Outflow_Before.pdf
Outflow (After)	Training & awareness given to inspector. OPL display at inspection stage. 298_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable for all Bumps stop parts .

12. Document Review

Documents	InspCheckSheet
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	1
Reason for submission	Found OK