QFR No - 7000910858

Defect Details

NC No.	7000910858
NC Date	22/04/2023
NC Submission Date	
Part No.	S2DC03102B
Part Name	INNER DUST COVER K55G
Supplier Name & Code	100990-JAIRAJ ANCILLARIES PVT LTD
ETL Plant	1116-ETL K-120 Suspension
Defect Details	BEND-found bend

1. Problem Description

Defect Description	During receipt inspection parts observed in bend condition?? Assembly fitment not possible.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	300
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	planthead.aurangabad@jairajgroup.com
Plant Head/CEO Email ID	vp@jairajgroup.com
MD Email ID	rajiv@jairajgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	5600	0	0	3000	0	8600
Check Qty	5600	0	0	3000	0	8600
NG Qty	300	0	0	10	0	310

Action taken on NG part

Scrap	310
Rework	0
Under Deviation	0

Containment Action
1. 100% inspection done at customer end & from all stages. 2. Defective parts are scrapped - 310 no`s - 27.04.2023

3. Process Flow

Process Flow Description
RM Receiving- Inward Inspection- RM Issue- Master batch mixing - Injection molding -Deflashing - Final Inspection - Packing & Labelling - PDI & Dispatch

4. Process Details

Process / Operation	Injection Molding
Outsource	No
Machine / Cell	IMM
Machine / Cell No.	IMM-07

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Process parameter sheet not followed as per CP	Verified PPS . Found ok as per control plan	O
Tool	Tool PM not done	Verified & found ok	O
Material	RM Grade is not as per specification	Verified RMTC - Found ok - PPCP	O
Method	Stacking method In-adequately followed	Verified stacking height for IDC 3102 . Observed that 2 bags are more than specified stacking height	X
Machine	Injection pressure high/low comparing as per PPS	Verified injection pressure & found ok as per PPS	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Part found bend due to stacking height weight
Why 2	Stacking height is more than defined
Why 3	In-adequate awareness about the stacking height resulting into bend
Why 4	
Why 5	
Root Cause (Occurance)	In-adequate awareness about the stacking height resulting into bend

Root Cause Analysis (Outflow)

Why 1	Bend part not detected during PDI
Why 2	Unable to detect the defect as PDI done on sampling basis only
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Unable to detect the defect as PDI done on sampling basis only

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	To check each & every bag on sampling basis during PDI	Amol Jagtap	05/05/2023		Completed
Occurance	Awareness training about stacking height	Sachin Kulkarni	05/05/2023		Completed
Outflow	OPL & Q alert to be displayed	Sachin Kulkarni	05/05/2023		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Check each & every bag on sampling basis during PDI
Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	-

10. Evidance of Countermeasure

Occurance (Before)	In-adequate Stacking height 431_Occurance_Before.jpg
Occurance (After)	Proper stacking height 431_Occurance_After.jpg
Outflow (Before)	PDI on sampling plan 431_Outflow_Before.pdf
Outflow (After)	Each & every bag checked on sampling basis during PDI 431_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	-

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity	10
Reason for submission	Corrective action parts submission.