

Defect Details

NC No.	7000922404
NC Date	14/06/2023
NC Submission Date	
Part No.	520KZ03002
Part Name	BUSH (PLASTIC)
Supplier Name & Code	101135-JAIRAJ ANCILLARIES PVT LTD
ETL Plant	1136-ETL Suspension Sanand
Defect Details	EXCESS MATERIAL-flashes ,Visual defects

1. Problem Description

Defect Description	Excess Flashes on material (visual defects).
Detection Stage	Receipt
Problem Severity	Aesthetic
NG Quantity	1834
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	quality.sanand@jairajgroup.com
Plant Head/CEO Email ID	qms@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	15000	0	0	3000	0	18000
Check Qty	15000	0	0	3000	0	18000
NG Qty	1834	0	0	21	0	1855

Action taken on NG part

Scrap	1855
Rework	0
Under Deviation	0

Containment Action

1. 100 % inspection done at ETL end. Checked all material from all stages 2. Defective parts are scrapped - 1855 qty - 16.06.2023

3. Process Flow

Process Flow Description

RM Receiving - Inward Inspection - RM Issue to production - Pre-heating - Injection Molding - Degating - Final Inspection - Packing & Identification - PDI & Dispatch

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Process parameter not followed as per OCE/CP	Verified process parameter sheet . found ok as per control plan	O
Material	RM Grade is not as per specification	Supplier RMTC verified - RM found ok (TPU)	O
Machine	Injection pressure/speed low (lower than the specified limit)	Verified injection pressure & speed as per PPS , found ok	O
Man	In-adequate knowledge of product defect	Verified skill evaluation . Found operator is having in-adequate knowledge about the defect	X
Tool	Tool cavity wear out	Verified tool. Found two cavities out of 16 found wear out resulting uneven flash	X

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	0

7. Root Cause Analysis (Occurance)

Why 1	Excess flash observed at ID side
Why 2	two cavity found wear out resulting into uneven flash
Why 3	In-adequate awareness about the mold polishing while moisture is present
Why 4	
Why 5	
Root Cause (Occurance)	In-adequate awareness about the mold polishing while moisture is present

Root Cause Analysis (Outflow)

Why 1	Excess flash observed at ID side
Why 2	Part is skipped to customer by operator
Why 3	Operator is having inadequate awareness about defect
Why 4	
Why 5	

Root Cause (Outflow)

Operator is having inadequate awareness about defect

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Part to be incorporated on quality gate for 200% inspection	Sachin K	17/07/2023	17/07/2023	Completed
Occurance	Mold polishing to be done as per defined frequency in procedure	Ganesh M	24/06/2023	24/06/2023	Completed
Outflow	On job training to be given to operator about part defect & it's checking criteria	Sachin K	24/06/2023	24/06/2023	Completed
Outflow	100% inspection of thickness by using Vernier caliper before dispatch	Amol C	09/10/2023		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% inspection at both injection molding stage & final inspection stage
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)	Mold cavity wear 482_Occurance_Before.jpg
Occurance (After)	PM Done 482_Occurance_After.pdf
Outflow (Before)	OPL & Q-alert 482_Outflow_Before.pdf
Outflow (After)	On job training record 482_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	-

12. Document Review

Documents	ControlPlan, PMCheckSheet, WISOP
Specify Other Document	-

13. Effectiveness Of Action

Reviewed Quantity

5

Reason for submission

Excess Flashes in bush (plastic)