

Defect Details

NC No.	7000987414
NC Date	20/02/2024
NC Submission Date	
Part No.	S2FF00802B
Part Name	GAS CAP- K1 RSA GDC CANISTER
Supplier Name & Code	100318-JAIRAJ GLOBAL
ETL Plant	1126-ETL Pantnagar
Defect Details	NOT AS PER SPECIFICATION-I/D Profile NG

1. Problem Description

Defect Description	Fitment Issue :- Air Hose Valve fitting I/D Profile N/G.
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	3200
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	agm@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	6200	0	0	0	0	6200
Check Qty	6200	0	0	0	0	6200
NG Qty	6200	0	0	0	0	6200

Action taken on NG part

Scrap	6200
Rework	0
Under Deviation	0

Containment Action

Immediate stop the supply and segregate all material which was lying in pipe line .

3. Process Flow

Process Flow Description

Material receiving- Incoming inspection- material storage- RM issue to production- Pre drying- injection molding - de-flashing- final inspection- labeling & Packing - Dispatch

4. Process Details

Process / Operation	Injection molding process
Outsource	No
Machine / Cell	injection molding machine
Machine / Cell No.	IMM 01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Material not as per grade	Check with MTC	O
Method	Machine parameter not as per OCS	Machine parameter check with OCS	O
Man	Unskilled operator	Check with Attendance sheet and skill matrix	O
Machine	Machine tonnage not as per requirement	Check with Control plan	O
Tool	Tool dimension wear	major with instrument	X

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	No
Checking Freq.	Sampling
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	ID profile of gas cap is NG
Why 2	Gas cap ID was under size
Why 3	Under size due to angle of tool pin is not as per specification
Why 4	Tool pin wear out
Why 5	
Root Cause (Occurance)	Due to tool pin was wear this problem was occurred.

Root Cause Analysis (Outflow)

Why 1	ID profile of gas cap is NG
Why 2	Not deduct at the time of setup inspection
Why 3	this dimension was not mention in setup check sheet.
Why 4	Check this dimension at the time of Lay out inspection.
Why 5	
Root Cause (Outflow)	This dimension is not checked at the time of setup. It was checked in layout only.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Check point added in tool preventive maintenance check sheet for inspect pin at the time of preventive maintenance.	Brijesh	08/03/2024		Completed
Outflow	Check point added in setup Check sheet.	Kabir	08/03/2024		Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Checkpoint added in setup approval check sheet and PDIR to check One no's of both cavity in every setup approval and PDIR.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5

10. Evidence of Countermeasure

Occurance (Before)	Tool PM Check Sheet 686_Occurance_Before.pdf
Occurance (After)	Updated Tool PM Check sheet 686_Occurance_After.pdf
Outflow (Before)	Setup Approval Check sheet 686_Outflow_Before.pdf
Outflow (After)	Updated Setup Approval Check Sheet 686_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Horizontal deploy on Gas cap BS4 Model

12. Document Review

Documents	ControlPlan, PMCheckSheet, PFMEA, InspCheckSheet
Specify Other Document	NO

13. Effectiveness Of Action

Reviewed Quantity	10000
Reason for submission	Its OK Now

