

Defect Details

NC No.	7001001044
NC Date	28/03/2024
NC Submission Date	
Part No.	53BKZ00102
Part Name	RUBBER BUSH
Supplier Name & Code	101023-FORES ELASTOMECH INDIA PVT. LT
ETL Plant	1136-ETL Suspension Sanand
Defect Details	DIMETER UNDERSIZE-OD undersize

1. Problem Description

Defect Description	OD 24.3+0.3/-0.3 observed undersize 23.70 mm.
Detection Stage	Receipt
Problem Severity	Fitment
NG Quantity	17500
Is Defect Repeatative?	No
Defect Sketch / Photo	

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	17500	40000	0	0	0	57500
Check Qty	17500	40000	0	0	0	57500
NG Qty	10	0	0	0	0	10

Action taken on NG part

Scrap	9
Rework	0
Under Deviation	0

Containment Action

100 % sorting of Fores stock

3. Process Flow

Process Flow Description

Material inward then forward to mixing department after that forward to molding process after that final inspection to standard packing.

4. Process Details

Process / Operation	Moulding
Outsource	No
Machine / Cell	Hyd 250 T
Machine / Cell No.	250 T

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	buffing process	Buffing process at parting line	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Venier
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

7. Root Cause Analysis (Occurance)

Why 1	OD undersize
Why 2	OD undersize on parting line
Why 3	undersize at parting line de-flash portion
Why 4	OD undersize due to buffing process at parting line
Why 5	
Root Cause (Occurance)	OD undersize due to buffing process at parting line

Root Cause Analysis (Outflow)

Why 1	OD undersize
Why 2	Skipped from Inspection
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Skipped from Inspection

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Buffing process removed.	Fores	10/04/2024		Pending

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Training given to Inspector & OPL displayed.
Inspection Method	Other
Other Inspection Method	vernier
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	50

10. Evidence of Countermeasure

Occurance (Before)	Parting line De-flashing by buffing wheel 728_Occurance_Before.jpg
Occurance (After)	De-flashing process removed. 728_Occurance_After.jpg
Outflow (Before)	OD inspection at sampling basis 728_Outflow_Before.jpg
Outflow (After)	OD inspection at sampling basis, Sampling Quantity increase. 728_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Rubber bush

12. Document Review

Documents	
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	