QFR No - 7001065590

Defect Details

NC No.	7001065590
NC Date	19/10/2024
NC Submission Date	
Part No.	S3KJ00202B
Part Name	REBOUND STOP
Supplier Name & Code	100990-JAIRAJ ANCILLARIES PVT LTD
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	NOT AS PER SPECIFICATION-I/D STEP SPE=12.50+0.10STPIN 12.50 N.PAS

1. Problem Description

Defect Description	NOT AS PER SPECIFICATION-I/D STEP SPE=12.50+0.10 STD PIN 12.50 NOT PASS
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	10000
Is Defect Repeatative?	No
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	50000	0	0	2500	0	52500
Check Qty	50000	0	0	2500	0	52500
NG Qty	10200	0	0	428	0	10628

Action taken on NG part

Scrap	10628
Rework	0
Under Deviation	0

Containment Action
All available material checked 100 % at ETL end and found 10200 no. defective out of 50000 no. checked. All available inhouse FG material checked 100% and found 428 no. defective parts out of 2500 no. checked.

3. Process Flow

Process Flow Description
Injection Moulding

4. Process Details

Process / Operation	Injection Moulding
Outsource	No
Machine / Cell	Injection Moulding Cell
Machine / Cell No.	IMM-01

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	OCS & control plan not followed by Machine Operator	Verified as per CP & OCS found ok , as per standard specification	X
Tool	Mould Cooling Time High/low	Checked with CP & OCS and found OK as per specification	X
Machine	Barrel Temperature High/Low	Checked with CP & OCS and found OK as per specification	X
Material	RM Grade not as per CP	Check with MTC & found ok as per specification.	X
Man	Man Power does not aware about this defect .	Slight change in ID shift not identified by Process & final Inspector	O
Method	Checking method for OD checking	Verified as per CP/OCS and found checking method adequate for ID/OD Checking	X
Tool	Mould Cooling Water flow rate at Cooling Outlet	Verified as per Tool PM checksheet and found as per specification	X
Tool	Core & cavity centre not matched.	Verified as per tool design and found ID centre shift	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Defective parts are introduced. (Ie Step in ID)
Why 2	Due to mould core half loose observed with respect to cavity half.
Why 3	Due to one Non operator Guide pin loosen in Core half.
Why 4	Core & cavity half centre not matched.
Why 5	
Root Cause (Occurance)	Core & cavity half centre not matched.

Root Cause Analysis (Outflow)

Why 1	Defective parts are skipped from final inspection
Why 2	Part dimensionally check on sampling basis
Why 3	Operator not aware of this defect of step formation in ID.

Why 4	On job training not given to Operator
Why 5	Operator awareness of this defect is not evident
Root Cause (Outflow)	Operator awareness of this defect is not evident

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Mould check sheet follow before LPA / FPA.	Mr Ganesh Mhaske	24/10/2024	24/10/2024	Completed
Occurance	Verified the Guide Pins & Clamps during mould change over process.	Mr Ganesh Mhaske	24/10/2024	24/10/2024	Completed
Outflow	Defect matrix to display on work station.	Mr Sandip Rode	26/10/2024	25/10/2024	Completed
Outflow	On the job training given to In process & Firewall operator.	Mr Sandip Rode	26/10/2024	25/10/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Inspection at firewall through Plug Gauge.
Inspection Method	Gauge
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Mould Loading Unloading WI not evident for Core Cavity Alignment . 1174_Occurance_Before.pdf
Occurance (After)	Training Record to Machine as well as In process Inspection Operator for Step Formation in ID. 1174_Occurance_After.pdf
Outflow (Before)	Training Record and awareness not evident to final Inspection Operator for Step formation in ID. 1174_Outflow_Before.pdf
Outflow (After)	Inspection standard made for final Inspector & Operator awareness 1174_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Rebound Stop S3KJ00302O

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, InspCheckSheet
Specify Other Document	NIL

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	NO ID STEP OBSERVRED.