

Defect Details

NC No.	7001083193
NC Date	19/12/2024
NC Submission Date	
Part No.	S2FF00802B
Part Name	GAS CAP- K1 RSA GDC CANISTER
Supplier Name & Code	100827-SANJAY TECHNOPLAST PVT.LTD.
ETL Plant	1126-ETL Pantnagar
Defect Details	DIMETER UNDERSIZE-DIA. 38.0 OD UNDERSIZE

1. Problem Description

Defect Description	O/D 38.0 mm UNDERSIZE :- Gas Cap Side Leakage issue
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	2700
Is Defect Repeatative?	No
Defect Sketch / Photo	r5lpxjqnsj3bzlhlwtydmnl.png

Supplier Communication Details

Quality Head Email ID	qa.hodstplpn@sanjaygroup.in
Plant Head/CEO Email ID	praveen.singh@sanjaygroup.in
MD Email ID	accounts.pn@sanjaygroup.in

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	3200	0	0	25000	0	28200
Check Qty	3200	0	0	25000	0	28200
NG Qty	2700	0	0	2000	0	4700

Action taken on NG part

Scrap	4700
Rework	0
Under Deviation	0

Containment Action

1-100 % inspection done at Customer end . 2- Accumulated material inspection at STPL end . 3-OPL Display 4-Sampling inspection increase -

3. Process Flow

Process Flow Description

M Inspection-RM Storage-Pre-Heating-Inj. Moulding-Deflashing-PDI-Packing-Logistics

4. Process Details

Process / Operation	Injection Moulding
Outsource	Yes
Machine / Cell	Moulding
Machine / Cell No.	FM110

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Injection holding time less	Verify with SPPS, Injection Holding time found less	O
Machine	Screw Position Less	Verify with SPPS material screw position found less due to shrinkage observed	O
Method	Inspection check point not defined	Dia 38 +/-0.1 mm not aided in PDI Reports	O
Method	Improper slider matching	Visual	X
Man	Unskilled Inspector	Dedicate inspector is available for inspection as per skill level	X
Machine	Barrel temprature low	Verify with SPPS Barrel temprature found low	O

6. Inspection Method Analysis (Current)

Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	10

7. Root Cause Analysis (Occurance)

Why 1	Leakage issue Observed in Gas cap
Why 2	OD under size Specification -Dia 38 ±0.1 Observation -37.73 mm
Why 3	Injection holding time & screw position less
Why 4	
Why 5	
Root Cause (Occurance)	Injection holding time & screw position less

Root Cause Analysis (Outflow)

Why 1	Leakage issue Observed in Gas cap
Why 2	Not deduct during Pre-dispatch Inspection
Why 3	Check Point was not defined in PDI inspection Check sheet for OD 38 ±0.1 mm
Why 4	
Why 5	
Root Cause (Outflow)	Check Point was not defined in PDI inspection Check sheet for OD 38 ±0.1 mm .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	1-Injection holding time increase 2-Barrel temperature increase 3-Injection Screw Position increase	Mr .Jitendar	10/01/2025	29/12/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Check Point Defined in Pre-Dispatch Inspection Reports for OD 38 ±0.1 mm 100 % inspection .
Inspection Method	Instrument
Other Inspection Method	
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	10

10. Evidence of Countermeasure

Occurance (Before)	Unskilled Operator Unskilled Inspector 1282_Occurance_Before.pdf
Occurance (After)	1-Training Provided to Operators. 2-One Point Lesson Displayed 1282_Occurance_After.jpg
Outflow (Before)	Injection holding time less Barrel temperature low Screw Position Less 1282_Outflow_Before.jpg
Outflow (After)	1-Injection holding time increase 2-Barrel temperature increase 3-Injection Screw Position increase 1282_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Gas Cap BS 4

12. Document Review

Documents	ControlPlan, PFMEA, WISOP, JHCheckSheet, AuditCheckSheet, ProcessFlowChart, InspCheckSheet
Specify Other Document	OPL ,OJT

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	

