QFR No - 8000785994

Defect Details

NC No.	8000785994
NC Date	05/05/2022
NC Submission Date	
Part No.	520GA00202
Part Name	MODIFIED DUST SEAL 30DIA HTA
Supplier Name & Code	100109-HI TECH ARAI PVT LIMITED
ETL Plant	1146-ETL Suspension Narasapura
Defect Details	FITTMENT NOT OK.-INSERT MATERIAL NOT AVAILABLE

1. Problem Description

Defect Description	Dust seal with out insert material
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	1
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	balamurugan.sb@hitecharai.com
Plant Head/CEO Email ID	sukumar@hitecharai.com
MD Email ID	spm32@hotmail.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	0	0	0	6400	0	6400
Check Qty	0	0	0	6399	0	6399
NG Qty	0	0	0	1	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
The Parts are additionally checked before dispatch

3. Process Flow

Process Flow Description
Moulding--> Deflashing-->Trimming--> Air Cleaning-->100% VI-->Air Cleaning-->Audit Inspection-->Packing-->Dispatch

4. Process Details

Process / Operation	Moulding
Outsource	No
Machine / Cell	NA
Machine / Cell No.	NA

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	The Visual Inspection Skipped	The Operator skipped the part without press and check	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	The metal insert was missed to load in the cavity during moulding.
Why 2	Manual loading of shells in the cavity during moulding.
Why 3	Molding operator not noticed the shell missing in cavity before mold closing.
Why 4	The metal insert after Loading to the cavity not visible.
Why 5	
Root Cause (Occurance)	The Verification of Metal Insert after Loading to cavity is not Viable.

Root Cause Analysis (Outflow)

Why 1	Seal without metal insert not detected before dispatch.
Why 2	Need additional detection control to ensure metal insert moulded with seal.
Why 3	
Why 4	
Why 5	
Root Cause (Outflow)	Need additional detection control to ensure metal insert moulded with seal.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status

Occurance	Molding operator provided additional training.	HTA	22/04/2022	22/04/2022	Completed
Outflow	Metal Insert(Shell) Poka Yoke system introduced in Trimming process.	HTA	22/04/2022	22/04/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	NA
Inspection Method	Other
Other Inspection Method	NA
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	n=5

10. Evidance of Countermeasure

Occurance (Before)	The Verification of Metal Insert after Loading to cavity is not Viable. 87_Occurance_Before.pdf
Occurance (After)	Molding operator provided additional training. 87_Occurance_After.pdf
Outflow (Before)	In Trimming Process earlier there is no metal checking sensor available 87_Outflow_Before.pdf
Outflow (After)	Metal Checking sensor implemented in the trimming process to avoid outflow of without metal insert part. 87_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	Part No. 520GA00202

12. Document Review

Documents	PokayokeCheckSheet
Specify Other Document	Training Record

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	