QFR No - 8000788189

Defect Details

NC No.	8000788189
NC Date	20/05/2022
NC Submission Date	
Part No.	550GA01502
Part Name	DUST SEAL Ø41_SFN
Supplier Name & Code	101055-FREUDENBERG-NOK PRIVATE LIMITE
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-DEFORMED PARTS

1. Problem Description

Defect Description	DUST SEAL TOP AREA DEFORMED
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	3
Is Defect Repeatative?	Yes
Defect Sketch / Photo	jq1zd3jwbvlx5fndf34ouof2.pptx

Supplier Communication Details

Quality Head Email ID	manpreet.rahi@fst.com
Plant Head/CEO Email ID	Vishal.Inge@fst.com
MD Email ID	anand.thiagarajan@fst.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	35000	45000	0	60000	0	140000
Check Qty	35000	45000	0	60000	0	140000
NG Qty	6	4	0	0	0	10

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action
100% reverification of parts for seal deformation

3. Process Flow

Process Flow Description
Moulding - Trimming- Visual Inspection - Packing

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Low Curing Time	PLC Controlled	X
Machine	Mould opening delay time	Yes	O
Machine	Less Mould Temperature	PLC Controlled	X

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	Curing observed in dust seal at lip area
Why 2	Mould temperature reduces in mould @ corner cavity
Why 3	Possibility observed of mould opening time delay after moulding process
Why 4	Inadequate controlling mechanism for mould delay time in moulding process
Why 5	
Root Cause (Occurance)	Inadequate controlling mechanism for mould delay time in moulding process

Root Cause Analysis (Outflow)

Why 1	Curing in dust seal lip area not detected @FNI
Why 2	Skipped by operator during inspection
Why 3	Operator negligence
Why 4	
Why 5	
Root Cause (Outflow)	Skipped by operator during inspection due to Operator negligence

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Mould delay time controlling mechanism in moulding process, Feasibility to be checked	FNI	10/06/2022	10/06/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	100% inspection with gauge for available stock verification
Inspection Method	Other
Other Inspection Method	NA
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Inadequate controlling mechanism for mould delay time in moulding process 132_Occurance_Before.pdf
Occurance (After)	Mould delay time controlling mechanism provided in moulding machine 132_Occurance_After.pdf
Outflow (Before)	Curing defect was not defined in matrix at final stage 132_Outflow_Before.pdf
Outflow (After)	Visual defect matrix updated for curing at dust lip at final inspection stage. 132_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NA

12. Document Review

Documents	WISOP
Specify Other Document	Defect Matrix

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	Parts found ok in 3 lot monitoring