QFR No - 8000788831

Defect Details

NC No.	8000788831
NC Date	25/05/2022
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	NOT AS PER LIMIT SAMPLE-SHORT SHOT

1. Problem Description

Defect Description	Short shot
Detection Stage	Inprocess
Problem Severity	Function
NG Quantity	13
Is Defect Repeatative?	No
Defect Sketch / Photo	3jd0wsglcjllsqocql1hxmsz.jpg

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	1000	0	0	1000	0	2000
Check Qty	1000	0	0	1000	0	2000
NG Qty	32	0	0	0	0	32

Action taken on NG part

Scrap	32
Rework	0
Under Deviation	0

Containment Action
100 % Stock verify at Fores End .

3. Process Flow

Process Flow Description
Rubber & Chemical - Inward inspection - Rubber Mixing - Hardness inspection - Moulding - Visual inspection - Standard packing & Dispatch .

4. Process Details

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

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Mold temperature less or more	PLC controlled if parameter not okay found then machine stop	X
Man	Skipped from inspection	Inspector not aware	O
Machine	Curing Time Less or more	PLC controlled if parameter not okay found then machine stop	X
Material	Material sequence not followed at Intermix in Mixing department	Error proofing system for chemical weighing , so there is no chances of variation in chemical weight	X
Material	Wrong material used	Last six month hardness data verified found okay	X

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Short Mould
Why 2	weak joint in rubber to rubber
Why 3	Material Flow is less in mold cavity
Why 4	material Flow Not uniform for all cavity .
Why 5	Carbon deposition in mold cavity .
Root Cause (Occurance)	Carbon Deposition in mold cavity .

Root Cause Analysis (Outflow)

Why 1	Short mold
Why 2	Skip from inspection
Why 3	Inspector not aware about potential failure
Why 4	
Why 5	
Root Cause (Outflow)	Inspector not aware about potential failure .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Q gate Implement at Inspection stage (200 % inspection start for one month .	Amar Patil .	25/05/2022	20/05/2022	Completed
Occurance	Clean the Mould (remove all carbon)	Mr Zukle	25/05/2022	19/05/2022	Completed
Occurance	Mold cleaning frequency Increase	Mr Zukle	25/05/2022		Pending
Outflow	100 % Marking start an ID of part for One month .	Mr Shinde	25/05/2022	19/05/2022	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Mold unclean (carbon deposition observed in mold cavity) . 148_Occurance_Before.xlsx
Occurance (After)	Clean the Mold . Dirt cleaning frequency increase from three month to Two month . 148_Occurance_After.pdf
Outflow (Before)	Inspector not aware & Insufficient training. 148_Outflow_Before.png
Outflow (After)	Training given to Inspector . 200 % inspection start for one month . Inspection marking start for one month . 148_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	N/A

12. Document Review

Documents	
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	0

Reason for submission	1. Fact Verification and Jud. are not aligned. Also detail statement to be given in fact verification 2. Root cause occurenec side Why 5 statement are not clear, detaile clear statement to be written. Just mold unclean could not be root cause. 3. Outflow side root cause not identified. Why inspector are not aware about potential failure?? 4. System side cause must be identified in Why 5. 5. Countermeasure are not adequate i.e. no training given to perator, No OPL was displayed etc. 6. Q-gate implemented at FI stage, how it could be a root cause while already Visual inspection done at FI stage. If previously visual inspection not done then how operator unawarness could be root cause of outflow. 7. All relevant documents for all causes and actions are not attached. All evidences must be attached to confirm action and root cause. Zip file can be uploaded. Hence Upload multiple files in compressed form. 8. Horizontal deployment is yes but machine detailes not mentioned. it should be mentioned. 9. All updated documents must be reflect in section number 12.