

## Defect Details

<b>NC No.</b>	8000790667
<b>NC Date</b>	13/06/2022
<b>NC Submission Date</b>	
<b>Part No.</b>	550MB07702
<b>Part Name</b>	SPACER TUBE - VE (115.5)
<b>Supplier Name &amp; Code</b>	100756-BLUE STAR ENGINEERS
<b>ETL Plant</b>	1116-ETL K-120 Suspension
<b>Defect Details</b>	EXCESS MATERIAL-GATE MARK ON FACE

## 1. Problem Description

<b>Defect Description</b>	In Spacer tube (550MB07702) observed with excess high point at gate position & face parallism observed up to 0.3 mm against requirement of 0.1mm.
<b>Detection Stage</b>	Inprocess
<b>Problem Severity</b>	Function
<b>NG Quantity</b>	1000
<b>Is Defect Repeatative?</b>	No
<b>Defect Sketch / Photo</b>	<a href="#">qixcy22tqjkdv3zlpjwrlqg.pdf</a>

## Supplier Communication Details

<b>Quality Head Email ID</b>	kakade.dnyaneshwar@sanghavigroup.co
<b>Plant Head/CEO Email ID</b>	prabhune.girish@sanghavigroup.co.in
<b>MD Email ID</b>	sanghavi.rajesh@sanghavigroup.co.in

## 2. Stock Details &amp; action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
<b>Total Qty</b>	20000	0	0	5000	0	25000
<b>Check Qty</b>	20000	0	0	5000	0	25000
<b>NG Qty</b>	1000	0	0	0	0	1000

## Action taken on NG part

<b>Scrap</b>	0
<b>Rework</b>	1000
<b>Under Deviation</b>	0

## Containment Action

Gate cutting.

## 3. Process Flow

## Process Flow Description

1)Raw Material Receiving & Storing - 2)Predrying/Pre Heating - 3)Injection moulding - 4)Deflashing & degating - 5)Final Inspection - 6)Packing & Storing - 7)Logistics and transport.

## 4. Process Details

<b>Process / Operation</b>	Injection Moulding Process
<b>Outsource</b>	No
<b>Machine / Cell</b>	Injection Moulding Machine
<b>Machine / Cell No.</b>	IMMH1017

## 5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Ineffective training	Gate point issue present in defect list	X
Tool	Gate point provided at improper place.	Functional issues observed due to gate point.	X

## 6. Inspection Method Analysis (Current)

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

## 7. Root Cause Analysis (Occurance)

<b>Why 1</b>	Gate point issue observed resulting in funtional issue.
<b>Why 2</b>	Gate point mark observed at face due tool wear out.
<b>Why 3</b>	Tool wear out due to maintenance delay.
<b>Why 4</b>	Tool wear out faster than expected
<b>Why 5</b>	Gate point provided at sensitive point as compared to function of part.
<b>Root Cause (Occurance)</b>	Gate point provided at sensitive point as compared to function of part.

## Root Cause Analysis (Outflow)

<b>Why 1</b>	Gate point issue observed resulting in funtional issue.
<b>Why 2</b>	Degating Issue was not detected.
<b>Why 3</b>	Ineffective Training.
<b>Why 4</b>	
<b>Why 5</b>	
<b>Root Cause (Outflow)</b>	Ineffective Training

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Change in gate point position	Sarang Chandak	04/07/2022	30/06/2022	Completed

## 9. Inspection Method After Customer Complaint

<b>Change In Inspection System</b>	Yes
<b>Change Details</b>	100% visual inspection with Marking(Blue marker)
<b>Inspection Method</b>	Other
<b>Other Inspection Method</b>	visual
<b>Check Point at Final Inspection</b>	Yes
<b>Checking Freq.</b>	100%
<b>Sampling</b>	No
<b>Sample Size</b>	1000

## 10. Evidence of Countermeasure

<b>Occurance (Before)</b>	Three plate mould(Point Gate) <a href="#">173_Occurance_Before.jpg</a>
<b>Occurance (After)</b>	Two plate Mould(Tab gate) <a href="#">173_Occurance_After.jpg</a>
<b>Outflow (Before)</b>	Defect list <a href="#">173_Outflow_Before.xlsx</a>
<b>Outflow (After)</b>	Defect list change <a href="#">173_Outflow_After.xlsx</a>

## 11. Horizontal Deployment

<b>Horizontal Deployment Required</b>	No
<b>Applicable Machine / Model / Plant</b>	n

## 12. Document Review

<b>Documents</b>	PMCheckSheet
<b>Specify Other Document</b>	n

## 13. Effectiveness Of Action

<b>Reviewed Quantity</b>	1000
<b>Reason for submission</b>	Completed.