QFR No - 8000834573

Defect Details

NC No.	8000834573
NC Date	26/06/2023
NC Submission Date	
Part No.	538LT00112
Part Name	SILENT BLOCK PLATED
Supplier Name & Code	101023-FORES ELASTOMECH INDIA PVT. LT
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	DAMAGES-SHORTMOLDING:4NO,CHAMFERO/D DAMAGE:275NO

1. Problem Description

Defect Description	SHORT MOLDING & CHAMFER O/D DAMAGE
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	279
Is Defect Repeatative?	No
Defect Sketch / Photo	

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	28000	0	0	35000	0	63000
Check Qty	28000	0	0	35000	0	63000
NG Qty	279	0	0	10	0	289

Action taken on NG part

Scrap	289
Rework	0
Under Deviation	0

Containment Action
100 % Sorting done at customer end at ETL With special marking . 100 % Sorting done at M/s Fore End with Special identification on Box .

3. Process Flow

Process Flow Description
Receiving the material - (Inspect the Raw material , Inspect the insert, Inspect the Outer - Compound Batch - Moulding - Deflashing -Plating - Visual inspection - ID & Height inspection - Bond testing - Packaging -Dispatch.

4. Process Details

Process / Operation	Moulding
Outsource	No
Machine / Cell	Moulding
Machine / Cell No.	INJ-250T

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Material	Wrong material used	verified the last six month data of hardness & Found okay	O
Machine	Weak joint of in metal to rubber.	NG part verify & Found not okay .	X
Tool	Tool not as per requirement .	Verified the tool as per PM inspection sheet & Found okay .	O
Man	Skipped from inspection	Inspection method not okay	X
Method	Insert & Outer loading method not oaky	verified the loading fixture & Found okay	O
Machine	Less or more temperature	verified the data for temperature & found okay .	O
Machine	Less or more cure time	verify the parameter & found okay .	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Short Moulding
Why 2	less material flow in mould cavity tool
Why 3	material gate flow point broken by previous shot gate .
Why 4	Gate is being broken from both end due to design constraint.
Why 5	
Root Cause (Occurance)	Gate is being broken from both end due to design constraint.

Root Cause Analysis (Outflow)

Why 1	Skipped form inspection.
Why 2	defect not detect in inspection stage .
Why 3	difficult to inspect this defect.
Why 4	inspection method not okay.
Why 5	

Root Cause (Outflow)	inspection method not okay.

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Gate point will check in every shot on rubber pad or part.	Mr Zukle	26/06/2023	26/06/2023	Completed
Outflow	Visual inspection will start on magnified glass With white background on table .	Mr motilal .	26/06/2023	22/06/2023	Completed
Occurance	Training given to operator .	Mr Zukle	26/06/2023	26/06/2023	Completed
Outflow	Awareness & training given to inspector	Mr motilal	26/06/2023	26/06/2023	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	No
Change Details	N/A
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)	1.Gate is being broken from both end due to design constraint. 497_Occurance_Before.docx
Occurance (After)	1.Gate point will check in every shot on rubber pad or part. 2.Training given to operator. 3.opl display at operation stage. 497_Occurance_After.pdf
Outflow (Before)	inspection method not okay. 497_Outflow_Before.pptx
Outflow (After)	1.Visual inspection will start on magnified glass With white background on table . 2.Opl display at inspection stage . 3.training & awareness given to inspector 497_Outflow_After.jpg

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Applicable for all part

12. Document Review

Documents	WISOP
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	
Reason for submission	