QFR No - 8000874634

Defect Details

NC No.	8000874634
NC Date	16/05/2024
NC Submission Date	
Part No.	550HH02302
Part Name	O-RING - K7
Supplier Name & Code	100131-KAMAL RUBPLAST IND PVT LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	FITTMENT NOT OK.-DIMN. 3.5 +0.1 UNDERSIZE

1. Problem Description

Defect Description	DIMN. 3.5 +0.1 UNDERSIZE
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	40000
Is Defect Repeatative?	No
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	santosh.s@kamalrub.com
Plant Head/CEO Email ID	kamalrub@gmail.com
MD Email ID	Danish.g@kamalrub.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	40000	0	0	1000	0	41000
Check Qty	40000	0	0	1000	0	41000
NG Qty	40000	0	0	0	0	40000

Action taken on NG part

Scrap	0
Rework	40000
Under Deviation	0

Containment Action
The subject item has been shifted to the other plant of Kamal. The part does not belong to Endurance . This will ensure further mix up is not happening .

3. Process Flow

Process Flow Description
Raw Material Receving > Weighing > Mixing (Kneader & Open Mixer) > Lab Testing > Strip Cutting > Moulding > Deflashing > Final inspection(100% Visual) > Packing > PDIR > Dispatch

4. Process Details

Process / Operation	As above
Outsource	No
Machine / Cell	JRD Semi Automatic
Machine / Cell No.	P-24

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Look Like Similier	Checked with Go-Nogo gauge	X
Method	Similier Part Handling not define	Similier Part Handling already define	O
Machine	Machine running Condition not OK	Machine running Condition found - OK	O
Tool	Tool identification number not define	Tool identification number already define	O
Material	Material not as per Grade	Check Material Grade material Ok as per lab test Report.	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Thickness of O Ring 3.5+0.1 (Significant parameter) under size
Why 2	Due to mix of similar dimension Part
Why 3	Part produce at same place
Why 4	
Why 5	
Root Cause (Occurance)	Similar Part produce at same place

Root Cause Analysis (Outflow)

Why 1	Thickness of O Ring 3.5+0.1 (Significant parameter) Mix with Similar Dimension Part
Why 2	Identification Mis match
Why 3	Due to Similar dimension
Why 4	Location not defined
Why 5	
Root Cause (Outflow)	Location not defined

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	The subject item has been shifted to the other plant of Kamal	S. K. Singh	15/05/2024	15/05/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visual Inspection and as per sample basis checked by Go-Nogo gauge.
Inspection Method	Other
Other Inspection Method	Go-Nogo Gauge
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	500

10. Evidance of Countermeasure

Occurance (Before)	PPT Slide No. 01 811_Occurance_Before.pptx
Occurance (After)	PPT Slide No.02 811_Occurance_After.pptx
Outflow (Before)	PPT 811_Outflow_Before.pptx
Outflow (After)	PPT 811_Outflow_After.pptx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Model

12. Document Review

Documents	ControlPlan, PFMEA, WISOP
Specify Other Document	WI

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	5. Problem Analysis - Need to cover all 4M 8. Countermeasure (Occurrence , Outflow & System side Actions) - Need out flow side and system side actions