

Defect Details

NC No.	8000875383
NC Date	24/05/2024
NC Submission Date	
Part No.	S2DC06502B
Part Name	INNER DUST COVER (L=86)
Supplier Name & Code	100990-JAIRAJ ANCILLARIES PVT LTD
ETL Plant	1118-ETL E-92,93 Suspension
Defect Details	EXCESS MATERIAL-MATIRAL DEFT

1. Problem Description

Defect Description	Do Spot
Detection Stage	Receipt
Problem Severity	Safety
NG Quantity	1140
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	planthead.aurangabad@jairajgroup.com
Plant Head/CEO Email ID	vp@jairajgroup.com
MD Email ID	rajiv@jairajgroup.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	2600	0	0	985	0	3585
Check Qty	2600	0	0	985	0	3585
NG Qty	1140	0	0	48	0	1188

Action taken on NG part

Scrap	1188
Rework	0
Under Deviation	0

Containment Action

Checked 100 % parts available at ETL line & in stores on 25.5.2024. Also checked 100 % stock available at inhouse FG stores on 25.5.2024

3. Process Flow

Process Flow Description

Receipt of Material, Inward inspection, Storage, Material issue, Master batch mixing, Injection molding, Deflashing & Inspection, Final Inspection, Packaging & labelling, Pre dispatch Inspection, Dispatch

4. Process Details

Process / Operation	Injection Moulding
Outsource	No
Machine / Cell	Injection Moulding Cell
Machine / Cell No.	IMM-07

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Method	Sampling inspection	Verified & found that visual defects are checked on sampling basis at FI	X
Man	Awareness lacking about the defect	Verified that operator, In process inspectors & final inspectors lacks the awareness about the defe	X
Machine	Injection speed is high	Verified as per C.P.& OCS found OK as per standard specification	O
Machine	Barrel Temp low/High	Verified as per C.P.& OCS found OK as per standard specification	O
Machine	Back pressure is low	Verified as per C.P. & OCS found OK as per standard specification	O
Method	RM preheating not done	Verified as per CP & OCS found that preheating not required	O
Material	RM grade not OK	Checked with MTC and found OK as per specification	O
Tool	Air trapped / Air vent inefficient	Verified mold vent condition on punch side and found rust /dirt inside air vents are not clean	X
Machine	Machine not working in OK condition	Verified and found that Machine working in OK condition	O

6. Inspection Method Analysis (Current)

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

7. Root Cause Analysis (Occurance)

Why 1	Bubbles observed on the part surface
Why 2	Air not coming out of the mold during molding process
Why 3	Air trapped inside the system during the process
Why 4	Air vents are not fully open/ cleaned
Why 5	Cleaning done during PM is not effective
Root Cause (Occurance)	Air vent cleaning done during PM is not effective

Root Cause Analysis (Outflow)

Why 1	Bubbles observed on the part surface
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Why 2	Defective part skipped from operator & inspectors
Why 3	Less awareness of operator & inspectors about the defect
Why 4	Point not added in In-process inspection check sheet, set up approval report & Inspection standard sheet
Why 5	
Root Cause (Outflow)	Less awareness of operator & inspectors about the defect

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Air vent cleaning done by chemical WD-40	Mr. Ganesh Mhaske	30/05/2024		Completed
Occurance	During PM of mold, air vent cleaning by chemical WD-40 is now introduced to enhance the effectiveness of cleaning ,point added in mold PM check sheet	Sandeep Roday	30/05/2024		Completed
Outflow	Point added in In-process check sheet, Set up approval report, Control Plan, PFMEA	Sandeep Roday	31/05/2024		Completed
Outflow	Training provided to operator & inspectors about the defect through OPL & Inspection standard sheet	Sandeep Roday	30/05/2024		Completed

9. Inspection Method After Customer Complaint

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

10. Evidence of Countermeasure

Occurance (Before)	Air vent cleaning not by chemical in Mould PM check sheet 819_Occurance_Before.png
Occurance (After)	Air vent cleaning by chemical point added in Mould PM check sheet 819_Occurance_After.png
Outflow (Before)	Point of Bubble checking not addressed in Inspection standard check sheet 819_Outflow_Before.png
Outflow (After)	Point of Bubble checking addressed in Inspection standard check sheet & OPL displayed 819_Outflow_After.png

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	ControlPlan, PMCheckSheet, PFMEA, InspCheckSheet
Specify Other Document	Set up Approval Repo

13. Effectiveness Of Action

Reviewed Quantity	10000
Reason for submission	no any concern observed after action taken.