QFR No - 8000884330

Defect Details

NC No.	8000884330
NC Date	26/07/2024
NC Submission Date	
Part No.	F2AV00302B
Part Name	BELLOW-B104B
Supplier Name & Code	101023-FORES ELASTOMECH INDIA PVT. LT
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-CUT MARK , FLOW MARK

1. Problem Description

Defect Description	Cut mark
Detection Stage	Inprocess
Problem Severity	Aesthetic
NG Quantity	4
Is Defect Repeatative?	Yes
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	1500	0	0	0	0	1500
Check Qty	1500	0	0	0	0	1500
NG Qty	1	0	0	0	0	1

Action taken on NG part

Scrap	1
Rework	0
Under Deviation	0

Containment Action
Sorted all customer end & Fores end quantity

3. Process Flow

Process Flow Description
RM - Mixing- Moulding - Final Inspection - Packing

4. Process Details

Process / Operation	Moulding
Outsource	No
Machine / Cell	Cell no-1
Machine / Cell No.	Machine

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Tool	Less material flow in cavity	leakage in mould cavity.	X
Material	Wrong compound used	Found match with control plan & production report. Checked one month data & found okay	O
Man	Un skill Inspector	Skill level verified found L3 & Required L3	O
Method	Mix up during packing	Offline packing	X
Machine	Process parameter of moulding not followed	Found matched with control plan & automatic PLC control	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	Flow mark
Why 2	Less material flow in cavity
Why 3	leakage in mould cavity.
Why 4	Mould plate parallelism not okay
Why 5	
Root Cause (Occurance)	Mould plate parallelism not okay

Root Cause Analysis (Outflow)

Why 1	Flow mark
Why 2	Skipped from Fores quality
Why 3	Not checked part mixed in okay part after quality inspection
Why 4	Offline box packing
Why 5	
Root Cause (Outflow)	Offline box packing

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Mould leakage removed by making plate parallelism okay.	Ravi	11/07/2024	26/06/2024	Completed
Outflow	`Online packing implemented	Pande	25/08/2024	15/07/2024	Completed

9. Inspection Method After Customer Complaint

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

10. Evidance of Countermeasure

Occurance (Before)	Mould parallelism Not okay 971_Occurance_Before.pdf
Occurance (After)	Mould parallelism okay 971_Occurance_After.pdf
Outflow (Before)	Offline packing 971_Outflow_Before.jpg
Outflow (After)	Online packing 971_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	Cell no 1

12. Document Review

Documents	
Specify Other Document	OPL

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	OK