

Defect Details

NC No.	8000886662
NC Date	12/08/2024
NC Submission Date	
Part No.	F2GA02302B
Part Name	PROTECTION COVER-XF1D1-XF1C1
Supplier Name & Code	100990-JAIRAJ ANCILLARIES PVT LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-DUST MARK

1. Problem Description

Defect Description	Dust Mark
Detection Stage	Customer End
Problem Severity	Aesthetic
NG Quantity	694
Is Defect Repeatative?	No
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	14000	0	0	1000	0	15000
Check Qty	14000	0	0	1000	0	15000
NG Qty	694	0	0	35	0	729

Action taken on NG part

Scrap	729
Rework	0
Under Deviation	0

Containment Action

100 % inspection at final & firewall workstation with identification mark on it .

3. Process Flow

Process Flow Description

Injection Moulding

4. Process Details

Process / Operation	Injection Moulding
Outsource	No
Machine / Cell	IM-04
Machine / Cell No.	IM-4

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Machine	Barrel Temp High / Low	verified as per Cp & OCS found ok , As per Standard Specification	O
Tool	Air trapped & air vent inefficient open	verifie Air vent blocked due to carbon deposit on air vent surface	X
Man	Man Power does not aware about this defect .	verified that operator , In process inspector & Final Inspector does not about this defect .	X
Material	RM Grade not as per CP .	Check with MTC & found ok as per specification	O
Method	Sampling Inspection	verified & Found that Defect are checked on sampling basis At FI	X
Machine	OPS & control plan not followed by Machine Operator .	verified as per CP & OCS found ok , As per standard specification	O
Method	RM preheating not done	Verified as per CP & OCS found ok , As per Standard Specification	O

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	5

7. Root Cause Analysis (Occurance)

Why 1	Dust marks due to air trapped in tool erratically while injection .
Why 2	Air vent blocked due to carbon deposit formed on air vent surface
Why 3	Carbon deposit formed due to un periodic cleaning during production
Why 4	Air vent cleaning done during Production is not effective .
Why 5	
Root Cause (Occurance)	.Air vent cleaning done during Production is not effective .

Root Cause Analysis (Outflow)

Why 1	Dust mark observed on part surface .
Why 2	Defective part skipped from operator & final Inspector .
Why 3	Lack of Awareness of Highlighted defect .
Why 4	
Why 5	

Root Cause (Outflow)

Lack of Awareness of Highlighted defect .

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

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Occurance	Air vent cleaning increased from 25 pieces to 15 pieces .	Sandeep Roday	17/08/2024	02/09/2024	Completed
Outflow	Awareness training given to in process inspector & Final Inspector about highlighted defect .	Sandeep Roday	19/08/2024	02/09/2024	Completed
Occurance	Air vent cleaning done by Chemical WD -40 .	Ganesh Mahske	16/08/2024	02/09/2024	Completed
Outflow	Check Point Added in PM sheet & CP & FMEA updated for the same	Sandeep Roday	21/08/2024	02/09/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visual Inspection at final stage for Dust Mark
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)	Air Vent cleaning not By chemical in mould pm check sheet . 1018_Occurance_Before.xlsx
Occurance (After)	PM check Sheet After correction . 1018_Occurance_After.pdf
Outflow (Before)	Dust Mark check point not address in inspection standard . 1018_Outflow_Before.pdf
Outflow (After)	Dust mark check point add in inspection standard . 1018_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	NO

12. Document Review

Documents	PMCheckSheet, WISOP, InspCheckSheet
Specify Other Document	Q alert .

13. Effectiveness Of Action

Reviewed Quantity	50
Reason for submission	ok