QFR No - 8000902882

Defect Details

NC No.	8000902882
NC Date	09/12/2024
NC Submission Date	
Part No.	F2PA00202B
Part Name	BOTTOM CASE RING RE J1A
Supplier Name & Code	100990-JAIRAJ ANCILLARIES PVT LTD
ETL Plant	1117-ETL K-228/9 Suspension
Defect Details	NOT AS PER SPECIFICATION-BREAK

1. Problem Description

Defect Description	BREAK
Detection Stage	Receipt
Problem Severity	Function
NG Quantity	700
Is Defect Repeatative?	Yes
Defect Sketch / Photo	3tkupsqk0tnofazl2odnzfet.jpg

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	5000	0	0	2000	0	7000
Check Qty	5000	0	0	2000	0	7000
NG Qty	700	0	0	0	0	700

Action taken on NG part

Scrap	700
Rework	0
Under Deviation	0

Containment Action
All available material checked 100 % at ETL end and found 700 no. defective out of 5000 no. checked. All available inhouse FG material checked 100% and found no defective parts out of 2000 no. checked.

3. Process Flow

Process Flow Description
Injection Moulding & Annealing

4. Process Details

Process / Operation	Injection Moulding & Annealing
Outsource	No
Machine / Cell	IMM-09
Machine / Cell No.	IMM-09

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Man Power does not aware about this defect .	Verifed that operator , In process inspector & Final Inspector aware about this defect .	O
Material	RM Grade not as per CP .	Check with MTC & found ok as per specification	O
Machine	OCS & control plan not followed by Machine Operator .	Verified as per Cp & OCS found ok	O
Method	Annealing surface volume in tank in sufficient to dip the parts in medium.	Verified and found due to small tank top parts are getting float in medium .	X
Method	RM preheating not done	Verified as per CP & OCS found ok , As per Standard Specification	O
Machine	Barrel Temp High / Low	Verified as per Cp & OCS found ok , As per Standard Specification	O
Tool	Air trapped & air vent inefficient open	Verified the air vent and found ok	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	Parts are getting broken erratically on weld line surface.
Why 2	Parts are not getting fully dipped in annealing medium
Why 3	Due to parts are getting floated above the medium surface
Why 4	Due to Annealing tank size small , parts surface not completely annealed.
Why 5	
Root Cause (Occurance)	Due to Annealing tank size small , top parts surface not completely annealed resulting into insufficient annealing . Due to Annealing tank size small , parts surface not completely annealed resulting in breakages erratically.

Root Cause Analysis (Outflow)

Why 1	Parts are getting broken erratically on weld Line surface.
Why 2	Parts are getting skipped from Operator and Final Inspector
Why 3	After annealing process , parts are getting checked on sampling Inspection

Why 4	Lack of awareness of highlighted defect.
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	Big Annealing tank to Incorporate so that max parts are getting covered in one annealing cycle.	Ganesh Mhaske	18/12/2024	18/12/2024	Completed
Occurance	Annealing record Register monitoring started	Ganesh mhaske	18/12/2024	18/12/2024	Completed
Outflow	Awareness training given to in process inspector & Final Inspector about highlighted defect .	Amol Chidre	20/12/2024	20/12/2024	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	100% Visual Inspection for part softness after annealing.
Inspection Method	Other
Other Inspection Method	Visually
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidance of Countermeasure

Occurance (Before)	Earlier small Annealing tank does not cover part max occupancy per cycle . Parts are getting open in medium due to floating on surface at top side which may be the probable cause 1264_Occurance_Before.pptx
Occurance (After)	Now Big Size Annealing tank implemented so that max parts are covered per cycle. Annealing Monitoring record started. 1264_Occurance_After.pdf
Outflow (Before)	Earlier Parts Softness & ductility after annealing process was checked at sampling basis. 1264_Outflow_Before.pdf
Outflow (After)	Parts softness and Ductility checking with 100% Inspection with OJT to In process and Firewall Inspectors 1264_Outflow_After.pdf

11. Horizontal Deployment

Horizontal Deployment Required	No
Applicable Machine / Model / Plant	N/A

12. Document Review

Documents	WISOP, InspCheckSheet
Specify Other Document	N/A

13. Effectiveness Of Action

Reviewed Quantity	100
Reason for submission	ok