

# POTENTIAL FAILURE MODE AND EFFECT ANALYSIS

Supplier(s)		Supplier Code(s)	Plant Location(s)	Design FMEA
System	Sub-System	Component		Page: 81/83
		Design / Process Responsibility :		FMEA Date (Orig.)
		Key Data:		GMN Sign: IPDC Sign:

Requirement	Potential Failure Mode	Potential Effect(s) of Failure	S	C	Potential Cause(s) / Mechanism(s) of Failure	Current Design / Process Controls Prevention	Current Design / Process Controls Detection	D	R	Recommended Action	Responsibility & Target Completion Date
Receipt of Raw material And Inspection	1.Wrong material supplied 2.Packaging Tear off	1.Delivery Failure 2.Moisture absorption by material	2	▲	1.Supplier error 2-Bags Tear off while loading & unloading	1.Check for specifications on Supplier TC as against material property data sheet. 2.Verify material as per incoming inspection standard & Sample.	Verification at receipt inspection & Visual inspection	7	25		
Storage of raw Material	1.Mixing of Material 2.Material contaminated / damage 3.FIFO System Failure	1.Part get reject 2.System failure	2	▲	1.Material stored at unsuitable location. 2.Location of material not identified.	Location of material identified as per FIFO	Material identification Tag or Material storage at defined location	7	25		
Pre Heating of Raw material	1.Less duration, 2.Less / Excess Temp.	Moulding defects (silver mark, etc.)	2	▲	Moisture in material	As per Pre-Dring Chart & Process monitoring sheet	Temp. Controller	6	25		
	1.Wrong mould loaded, 2 Clamping & Alignment not ok.	1.Wrong part produced. 2. Mould damage & material wastage.	2	▲	1.Mould identification not available. 2.Insufficient Marginover.	1.Name plate use in every mould 2. Skill matrix of marginover.	Visual	7	25		
	Moisture	Part get rejected & scrapped	2	▲	Over-ent, temp high, injection speed high, locking pressure less	1-Training to packers & skill matrix of packers. 2-Packing std. increased.	100% checking by operator	7	25		
	Air Bubbles	Part get rejected & scrapped	2	▲	Over-ent, temp high, injection speed high, locking pressure less	1-Training to packers & skill matrix of packers. 2-Packing std. increased.	100% checking by operator	7	25		
	Band	Part get rejected & scrapped	2	▲	1) Mis handling 2) Poor packing std.	1-Training to packers & skill matrix of packers. 2) Shrinkage not increased	100% checking by operator	7	25		

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**G Psacharopoulos**



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### **Table of Contents Fmea 4th Edition**

1. Understanding the eBook Fmea 4th Edition
  - The Rise of Digital Reading Fmea 4th Edition
  - Advantages of eBooks Over Traditional Books
2. Identifying Fmea 4th Edition
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Fmea 4th Edition
  - User-Friendly Interface
4. Exploring eBook Recommendations from Fmea 4th Edition
  - Personalized Recommendations
  - Fmea 4th Edition User Reviews and Ratings

- Fmea 4th Edition and Bestseller Lists
- 5. Accessing Fmea 4th Edition Free and Paid eBooks
  - Fmea 4th Edition Public Domain eBooks
  - Fmea 4th Edition eBook Subscription Services
  - Fmea 4th Edition Budget-Friendly Options
- 6. Navigating Fmea 4th Edition eBook Formats
  - ePub, PDF, MOBI, and More
  - Fmea 4th Edition Compatibility with Devices
  - Fmea 4th Edition Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Fmea 4th Edition
  - Highlighting and Note-Taking Fmea 4th Edition
  - Interactive Elements Fmea 4th Edition
- 8. Staying Engaged with Fmea 4th Edition
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Fmea 4th Edition
- 9. Balancing eBooks and Physical Books Fmea 4th Edition
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Fmea 4th Edition
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Fmea 4th Edition
  - Setting Reading Goals Fmea 4th Edition
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Fmea 4th Edition
  - Fact-Checking eBook Content of Fmea 4th Edition
  - Distinguishing Credible Sources

13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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