

POTENTIAL FAILURE MODE AND EFFECT ANALYSIS

Supplier :		Supplier Code :		Plant Location :		Design FMEA	
Part Name :	Sub-System :	Component :				Page : 81/83	File :
		Design / Process Responsibility :				FMEA Date (Orig.) :	Ver :
		Key Dates :				60% Sign :	File :
						80% Sign :	File :

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.Champing & 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-pick, 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-pick, 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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