

# Process FMEA

Revision 18.0 15/01/2024

|   |              |                                      |  |  |                               |                        |                    |
|---|--------------|--------------------------------------|--|--|-------------------------------|------------------------|--------------------|
| Customer<br>KASAI UK  |              | Customer Part No.<br>Various         |  |  | Org. Date<br>10/04/2019       | Page<br>1 of 13        |                    |
| Supplier<br>Thier & CO  | Code<br>1111 | Supplier Part No.<br>Various         |  |  | Dwg. Rev.<br>N/A              | Key Date<br>27/06/2017 | FMEA No.<br>003    |
| Part Name<br>KASAI UK GENERIC INJECTION   |              | Process Responsibility<br>Joe Bloggs |  |  | Application/Model Year<br>N/A |                        |                    |
| Core Team<br>Sophia Johnson, Marcus Rodriguez, Emily Patel, Xavier Chang, Ethan Khan, Olivia Nguyen, Caleb Gomez, Ava Smith |              |                                      |  |  | Prepared By<br>Joe Bloggs     |                        | Date<br>15/01/2024 |

| Process Function / Requirements                           | Potential Failure Mode                   | Potential Effect(s) of Failure           | S<br>e<br>v | C<br>l<br>a<br>s<br>s | Potential Cause(s) / Mechanisms of Failure   | O<br>c<br>c<br>u<br>r | Current Process Controls Prevention   | Current Process Controls Detection                                   | D<br>e<br>t<br>e<br>c | R.<br>P.<br>N. | Recommended Action(s) | Responsibility & Target Completion Date | Action Results |             |             |             |                |
|---|--|--|-------------|-----------------------|--|-----------------------|---|--|-----------------------|----------------|-----------------------|---|----------------|-------------|-------------|-------------|----------------|
|   |  |  |             |                       |  |                       |   |  |                       |                |                       |   | Actions Taken  | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
| Material feed<br><br>Correct material supplied to machine | Incorrect material grade supplied to IMM | Does not meet customer test requirements | 9           |                       | Incorrect material loaded into Silo  | 1                     | Material loading procedure:<br>Cross check of delivery paperwork against silo signage<br>Cross check of paperwork against ID tag on transport | Opening of silo coupling by KUK operative after all checks completed | 3                     | 27             | None required         | 24/03/2018                              |                |             |             |             |                |
|   |  |  |             |                       | Incorrect material supplied from Silo following request from Production                              | 1                     | CMF (Central Material Feed) matrix (ST084 / IJ123)  | Toolchange buy-off (IJ010)   | 7                     | 63             | None required         | 24/03/2018                              |                |             |             |             |                |
|   |  |  |             |                       | Incorrect material Octabin supplied to CMF   | 1                     | Stores warehouse location board   | CMF / Drier lane layout  | 8                     | 72             | None required         | 24/03/2018                              |                |             |             |             |                |
|   |  |  |             |                       | Incorrect Octabin material supplied through CMF following request from Production                    | 1                     | CMF matrix (ST084 / IJ123)  | Toolchange buy-off (IJ010)   | 7                     | 63             | None required         | 24/03/2018                              |                |             |             |             |                |
|   |  |  |             |                       | Incorrect material supplied via Octabin (direct feed into machine) following request from Production | 1                     | Stores warehouse location board   | Visual confirmation (SOS GEN)  | 8                     | 72             | None required         | 24/03/2018                              |                |             |             |             |                |

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| <b>Part Name</b><br>KASAI UK GENERIC INJECTION   |                     |                                     | <b>Process Responsibility</b><br>Joe Bloggs |  |                                  | <b>Application/Model Year</b><br>N/A |                           |
| <b>Core Team</b><br>Sophia Johnson, Marcus Rodriguez, Emily Patel, Xavier Chang, Ethan Khan, Olivia Nguyen, Caleb Gomez, Ava Smith |                     |                                     |   |  | <b>Prepared By</b><br>Joe Bloggs |                                      | <b>Date</b><br>15/01/2024 |

| Process Function / Requirements  | Potential Failure Mode  | Potential Effect(s) of Failure               | S<br>e<br>v | C<br>l<br>a<br>s<br>s | Potential Cause(s) / Mechanisms of Failure  | O<br>c<br>c<br>u<br>r | Current Process Controls Prevention            | Current Process Controls Detection          | D<br>e<br>t<br>e<br>c | R.<br>P.<br>N. | Recommended Action(s)   | Responsibility & Target Completion Date | Action Results                                   |             |             |             |                |
|--|-------------------------|--|-------------|-----------------------|---|-----------------------|--|---|-----------------------|----------------|---|---|--|-------------|-------------|-------------|----------------|
|  |                         |  |             |                       |   |                       |  |   |                       |                |   |   | Actions Taken                                    | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
| Injection moulding<br><br>Fully formed components meeting all customer appearance & dimensional specification. | Flash on trim part      | Poor Appearance - Does not meet requirements | 6           |                       | Injection pressure / speed too high (2)<br><br>Mould temperature too high (2)<br><br>Damage to bed-off area (2)     | 2                     | Start-up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 84             | Specify on SOS / ISOS potential areas of flash & the correct procedure for removal        | Engineering Dept N/A                    |  |             |             |             |                |
|  | Short shot on trim part | Poor Appearance - Does not meet requirements | 6           |                       | Injection time / pressure / speed too low (2)<br><br>Mould temperature too low (2)<br><br>Hold pressure too low (2) | 2                     | Start-up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 84             | Investigate use of machine parameters to control shot weight                              | Engineering Dept N/A                    | No parameters capable of controlling shot weight | 6           | 2           | 7           | 84             |
|  |                         |  |             |                       |   |                       |  |   |                       |                | Investigate installation of camera system into downstream machinery                       | Engineering Dept N/A                    | Camera unable to detect due to ambient light     | 6           | 2           | 7           | 84             |
|  |                         |  |             |                       |   |                       |  |   |                       |                | Modification of holding nests (where applicable) to highlight areas of last point of fill | Engineering Dept N/A                    |  |             |             |             |                |
|  |                         |  |             |                       |   |                       |  |   |                       |                | Specify care point on SOS / ISOS for last point of fill                                   | Engineering Dept N/A                    |  |             |             |             |                |

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| <b>Part Name</b><br>KASAI UK GENERIC INJECTION   |                     |  | <b>Process Responsibility</b><br>Joe Bloggs |                         |                                  | <b>Application/Model Year</b><br>N/A |                           |
| <b>Core Team</b><br>Sophia Johnson, Marcus Rodriguez, Emily Patel, Xavier Chang, Ethan Khan, Olivia Nguyen, Caleb Gomez, Ava Smith |                     |  |   |                         | <b>Prepared By</b><br>Joe Bloggs |                                      | <b>Date</b><br>15/01/2024 |

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|                                 |                                       |  |             |                       |   |                       |  |   |                       |                |                       |   | Actions Taken  | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
|                                 | Sink mark on 'A' surface of trim part | Poor Appearance - Does not meet requirements | 6           |                       | Mould temperature too high<br><br>Injection pressure too low<br><br>Hold pressure to low<br><br>Fill rate / speed too low | 1                     | Start-up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 | Gate splay                            | Poor Appearance - Does not meet requirements | 6           |                       | Mould temperature too low<br><br>Gate size too small<br><br>Injection pressure too high<br><br>Fill rate / speed too high | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 | Orange peel effect                    | Poor Appearance - Does not meet requirements | 6           |                       | Mould temperature too low<br><br>Injection pressure too low<br><br>Fill rate / speed too low                              | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |

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| <b>Part Name</b><br>KASAI UK GENERIC INJECTION   |                     |                                     | <b>Process Responsibility</b><br>Joe Bloggs |  |                                  | <b>Application/Model Year</b><br>N/A |                           |
| <b>Core Team</b><br>Sophia Johnson, Marcus Rodriguez, Emily Patel, Xavier Chang, Ethan Khan, Olivia Nguyen, Caleb Gomez, Ava Smith |                     |                                     |   |  | <b>Prepared By</b><br>Joe Bloggs |                                      | <b>Date</b><br>15/01/2024 |

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|                                 |                        |  |             |                       |   |                       |  |   |                       |                |                       |   | Actions Taken  | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
|                                 | Pigment dispersion     | Poor Appearance - Does not meet requirements | 6           |                       | Gate size too small<br><br>Back pressure too low<br><br>Screw speed too low<br><br>Fill rate / speed too fast                         | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 | Burn marks             | Poor Appearance - Does not meet requirements | 6           |                       | Injection pressure too high<br><br>Contamination<br><br>Fill rate / speed too high  | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 | Gloss level            | Poor Appearance - Does not meet requirements | 6           |                       | Mould temerature too low<br><br>Injection pressure too low<br><br>Fill rate / speed too low<br><br>Poor venting<br><br>Use of release | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |

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| Part Name<br>KASAI UK GENERIC INJECTION   |              | Process Responsibility<br>Joe Bloggs |  |  | Application/Model Year<br>N/A |                        |                    |
| Core Team<br>Sophia Johnson, Marcus Rodriguez, Emily Patel, Xavier Chang, Ethan Khan, Olivia Nguyen, Caleb Gomez, Ava Smith |              |                                      |  |  | Prepared By<br>Joe Bloggs     |                        | Date<br>15/01/2024 |

| Process Function / Requirements | Potential Failure Mode                                   | Potential Effect(s) of Failure               | S<br>e<br>v | C<br>l<br>a<br>s<br>s | Potential Cause(s) / Mechanisms of Failure   | O<br>c<br>c<br>u<br>r | Current Process Controls Prevention            | Current Process Controls Detection          | D<br>e<br>t<br>e<br>c | R.<br>P.<br>N. | Recommended Action(s) | Responsibility & Target Completion Date | Action Results |             |             |             |                |
|---------------------------------|--|--|-------------|-----------------------|--|-----------------------|--|---|-----------------------|----------------|-----------------------|---|----------------|-------------|-------------|-------------|----------------|
|                                 |  |  |             |                       |  |                       |  |   |                       |                |                       |   | Actions Taken  | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
|                                 |  |  |             |                       | agent  |                       |  |   |                       |                |                       |   |                |             |             |             |                |
|                                 | Delamination   | Poor Appearance - Does not meet requirements | 6           |                       | Mould temperature too low<br><br>Gate size too small<br><br>Fill rate / speed too high   | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 | Dimensionally incorrect - trim parts too small / too big | May not fit to vehicle                       | 5           |                       | Injection pressure / speed too low / high<br><br>Mould temperature too low / high<br><br>Hold pressure too low / high<br><br>Cooling time too low / high | 2                     | Master setting sheet                           | 1st / Last off                              | 4                     | 40             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 |  |  |             |                       | Incorrect material loaded to machine (Grade)   | 1                     | Master setting sheet                           | Teamleader buy-off                          | 7                     | 35             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 |  |  |             |                       |  |                       | CMF Control matrix                             | 1st off / Last off                          | 4                     | 20             | None required         | 24/03/2018                              |                |             |             |             |                |
|                                 | Poor weld lines  | Poor Appearance - Does not meet requirements | 6           |                       | Mould temperature too low<br><br>Gate size too   | 1                     | Start up procedure<br><br>Master setting sheet | Visual inspection<br><br>Teamleader buy-off | 7                     | 42             | None required         | 17/03/2018                              |                |             |             |             |                |

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|  |                        |  |             |                       |  |                       |  |   |                       |                |   |   | Actions Taken  | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
|  |                        |  |             |                       | small<br>Injection pressure too low<br>Fill rate too low<br>Poor venting   |                       |  |   |                       |                |   |   |                |             |             |             |                |
|  | Contamination          | Poor Appearance - Does not meet requirements | 6           |                       | Material hang-up in barrel, nozzle or tool   | 2                     | Production running method                  | Visual inspection<br>Teamleader buy-off | 7                     | 84             | Review running method to minimise colour change         | Prod Control Dept<br>19/02/2020         |                |             |             |             |                |
|  |                        |  |             |                       |  |                       | Purge procedure (IJ 010)                   | Visual inspection<br>Teamleader buy-off | 7                     | 84             | Check correct purge material being used for application | Production Dept<br>19/02/2020           |                |             |             |             |                |
|  | Gas mark               | Poor Appearance - Does not meet requirements | 6           |                       | Mould venting poor (2)<br>Poor melt flow (1)<br>Injection speed too fast (2)<br>Insufficient material drying (2) | 2                     | Start up procedure<br>Master setting sheet | Visual inspection<br>Teamleader buy-off | 7                     | 84             | None required   | 26/06/2020                              |                |             |             |             |                |
| De-mould<br>Part removal from mould utilising robot & end of arm tooling | 'A' face damage        | Poor Appearance - Does not meet requirements | 6           |                       | EOAT damaged   | 1                     | Operator critical checks (IJ 010)          | Visual inspection<br>Teamleader buy-off | 7                     | 42             | None required   | 19/02/2020                              |                |             |             |             |                |
|  | Distortion / damage    | May not fit to vehicle                       | 6           |                       | EOAT damaged   | 1                     | Operator critical checks (IJ 010)          | Visual inspection<br>Teamleader         | 7                     | 42             | None required   | 19/02/2020                              |                |             |             |             |                |

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|   |                                  |  |             |                       |  |                       |                                     |   |                       |                |                             |   | Actions Taken                             | S<br>e<br>v | O<br>c<br>c | D<br>e<br>t | R.<br>P.<br>N. |
|   |                                  |  |             |                       |  |                       |                                     | buy-off                                 |                       |                |                             |   |   |             |             |             |                |
|   | Contamination                    | Poor Appearance - Does not meet requirements | 6           |                       | Incorrect suction cup material             | 2                     | EOAT design                         | Visual inspection<br>Teamleader buy-off | 7                     | 84             | Review suction cup material | Engineering Dept<br>19/02/2020          | Material changed from silicone to nitrile | 6           | 1           | 7           | 42             |
| Gate / Sprue removal  | Not removed or partially removed | Does not meet customer test requirements     | 9           |                       | Operation not performed to specification   | 1                     | Process instruction                 | Visual inspection<br>Teamleader buy-off | 7                     | 63             | None required               | 14/02/2020                              |   |             |             |             |                |
| Cutting of sprue at gating area to correct depth leaving no sharp edges | Under cut                        | May not fit to vehicle                       | 6           |                       | Operation not performed to specification   | 1                     | Process instruction                 | Visual inspection<br>Teamleader buy-off | 7                     | 42             | None required               | 14/02/2020                              |   |             |             |             |                |
|   | Sharp edge                       | Does not meet customer test requirements     | 9           |                       | Operation not performed to specification   | 1                     | Process instruction                 | Visual inspection<br>Teamleader buy-off | 7                     | 63             | None required               | 14/02/2020                              |   |             |             |             |                |

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|  |  |  |  |  |  |  |  |  |  | <b>Approved By</b><br>Joe Bloggs | <b>Date</b><br>15/01/2024 |
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