

QA

Store Incharge

Quantity varify

inform to QA Incharge

Inform to store incharge

5 No's

NA

Every Lot

NA

Inventory report/ERP system

Visual

NA

Prototype		Pre - Lauch	Produc	ction		Key Contact / Phone: Mr. P	alak Chah/ N	for Amount Names		Date(Orig.) 22-0	7 2022	Rev Date: 17.02.2024 (Loc			
Control Plan N	Number : TPIGE/CP/03					Rey Contact / Priorie: Wr. P.	alak Silali/ N	ir. Allaliu Nagare		Date(Orig.) 22-0	7-2022	Rev Date: 17.02.2024 (Loc	cauon change)		
Part Number :	F2FA19033O REV:XD					Core Team: Palak/Piyush/ E	Bhupendra/	Anand		Customer Engi	neering Appro	val / Date (if Reqd.):			
Part Name/De	scription: Fork pipe plated	(KOPG)				Supplier / Plant Approval D	ate			Customer Quar	tity Approval	Date (if Reqd.)			
Supplier/Plant Supplier Co	t: TUBE PRODUCTS OF IND de: 101109	DIA LTD, SANAND		Ballon diagram Selal NO. Recive Material From TI Plant/WH Outer Diameter (mm) Inner Diameter (mm) VS (MPA) ELONGATION% Hardness HRC Straightness		Other Approval Date (if req	Įd.)			Other Approval	Date (if reqd.)			
					Characteristics					Methods					
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for Mfg.				Process	Spec Char. Class	Product / Process specification /	Evaluation	Sam	ple	Control Method/Erro	r Proofing	Reaction plan	Corrective Action
Number			No.		Product	Process	Oidasa	Tolerance	Measurement Technique	Size	Freq.	Record / Error Proofing	Resp.		
			1		Recive Material From TI Plant/WH										
			2		Outer Diameter (mm)			30.10 (+0.08/0.0)	OD Micrometer	5 No's	Every Lot		QA	Reject the Lot	inform to QA Incharge
			3		Inner Diameter (mm)			24 (+0.0/-0.15)	Vernier Caliper	5 No's	Every Lot		QA	Reject the Lot	inform to QA Incharge
			4		Total Length			290.5 (+1/-0)	Height Guage	5 No's	Every Lot		QA	Hold the Lot	inform to QA Incharge
			5		UTS (MPA)			863 Min	As Per RMTC		Every Lot		QA	Hold the Lot	inform to QA Incharge
10	INWARD INSPECTION	Inspection Table	6		YS (MPA)			715 Min	As Per RMTC		Every Lot	Inward Inspection Report	QA	Hold the Lot	inform to QA Incharge
10	INWARD INSPECTION	inspection rable	7		ELONGATION%			15% MIN	As Per RMTC		Every Lot	TI/GE/QA/RI/03	QA	Hold the Lot	inform to QA Incharge
			8		Hardness HRC			24-32	As Per RMTC		Every Lot		QA	Hold the Lot	inform to QA Incharge
			9		Straightness			0.08/500	As Per RMTC		Every Lot		QA	Hold the Lot	inform to QA Incharge
.			10		Surface Roughness ID			0.80 Ra	As Per RMTC		Every Lot		QA	Hold the Lot	inform to QA Incharge

Visual

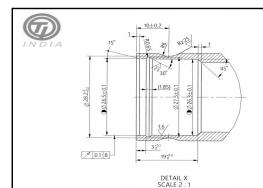
Refer to WI/RM/00

Free From Rust, Burr, Dent & Scratches & ID Fin Line

Material Storage

11

12



11

12

13

Runout caucking Side wrt to B

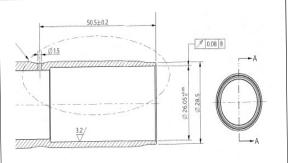
Groove Diameter

Groove Length

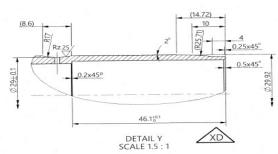
Turning Tool -Spindle RPM -2400 to 2900, Feed

rate- mm/ revolution -0.10 to 0.50 , Collet Run out -Max 0.020 mm, Hydraulic

Pressure - 28 ~ 35 Bar,Clamping pressure 15~20 kg/cm2,Insert changing frequency 400 Nos/Corner.



CONTROL PLAN



Set-up Approval

Report

Set-up Approval

/Inprocess Inspection Report

NO record

QA/Prod

QA/Prod

Reject

Check the offset and inform to Prod Incharge

Check the offset and

inform to Prod Incharge

First Piece/5

nos

First Piece/5

1nos

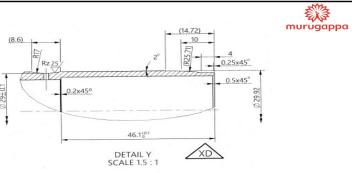
Every Hour

per shift

Dial

Vernier caliper

Vernier caliper/ Profile

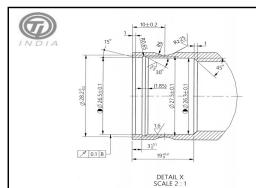


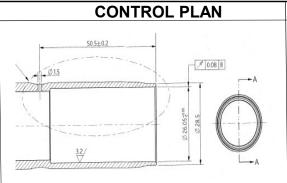
		SCALE 2.														
Prototype Control Plan I	Number : TPIGE/CP/03	Pre - Lauch	Produc	ction		Key Contact / Phone: Mr. P.	alak Shah/ I	Mr. Anand Nagare		Date(Orig.) 22-0	7-2022	Rev Date: 17.02.2024 (Lo	cation change)			
Part Number :	F2FA19033O REV:XD					Core Team: Palak/Piyush/ E	3hupendra/	Anand		Customer Engi	neering Appro	oval / Date (if Reqd.):				
Part Name/De	scription: Fork pipe plated	(KOPG)				Supplier / Plant Approval D	ate			Customer Quar	itity Approval	/ Date (if Reqd.)				
Supplier/Plan Supplier Co	t: TUBE PRODUCTS OF IND de: 101109	DIA LTD, SANAND				Other Approval Date (if req	(d.)			Other Approval	Date (if reqd	-)				
					Characteristics					Methods						
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for Mfg.	No.	Ballon	Product	Drasses	Spec Char. Class	Product / Process specification /	Evaluation	Sam	ple	Control Method/Erro	or Proofing	Reaction plan	Corrective Action	
Number			NO.	diagram Seial NO.	Product	ci		Tolerance	Measurement Technique	Size	Freq.	Record / Error Proofing Resp.				
			1		Caulking Bore Dia			Ø 26.05 (+0.05/+0.0)	Plug Gauge / Vernier Caliper	100% Inspection with Plug gauge	Every Lot	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject the Tube	Check the offset and inform to Prod Incharge	
			2		Caulking Bore Depth			46.1 +0.1/-0.0	Vernier Caliper/ Depth Gauge/PokaYoke	100% on Pokayoke at Drilling oper.	Every Lot	Set-up Approval /Inprocess Inspection Report	QA/Prod	Quarantine the Batch	Check the offset and inform to Prod Incharge	
			3		Caulcking side OD plane Turning Dia	Boring Tool -Spindle RPM		Ø 28.5	Snap Gauge	First Piece/5 nos	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject and Inform to QA Incharge	Check the offset and inform to Prod Incharg	
			4		Caulcking side OD plane Turning Length 1	-2300 to 3000 ,Feed rate - mm/ revolution -0.16 to		4	Program Control			NO record				
			5		Caulcking side OD plane Turning Length 2	- 0.70, Hydraulic Pressure- 28 ~ 35 Bar, Clamping pressure - 15~20 kg/cm2		10	Program Control			NO record				
			6		Caulcking side OD plane Turning Length 2 Radius	& Insert Changing 200 Nos/Corner		R25.71	Program Control			NO record				
	MACHINING CAULKING		7		Caulcking side OD plane Turning Length 3 Radius			14.72	Program Control			NO record				
20	SIDE	CNC Machine	8		Caulcking side OD plane Turning Length 2 Degree			2°	Program Control			NO record				
			9		Chamfer			CHF 0.5 x 45° x 0.2	Progrm Control/Visual			NO record				
			10		Chamfer			CHF 0.2 x 45° x 0.2	Progrm Control/Visual			NO record				

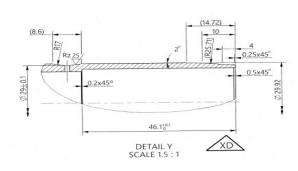
0.08 mm max

Ø 29 ± 0.1

8.6 mm



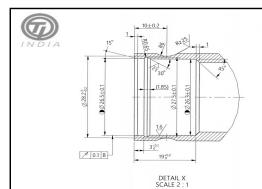


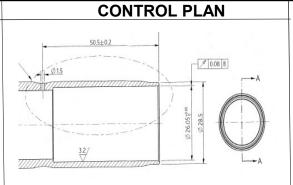


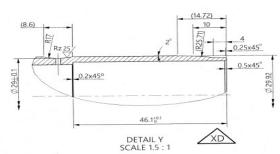
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Prototype		Production	Key Contact / Phone: Mr. P	alak Shah/ M	Ir. Anand Nagara	Date(Orig.) 22-07-2022	Rev Date: 17.02.2024 (Location change)						
Control Plan N	Number : TPIGE/CP/03			Rey Contact / Filone. Wil. F	alak Silali/ W	n. Ananu Nagare	Date(Orig.) 22-07-2022	Rev Date: 17.02.2024 (Location change)					
Part Number :	F2FA19033O REV:XD			Core Team: Palak/Piyush/	Bhupendra/ A	Anand	Customer Engineering Appro	val / Date (if Reqd.):					
Part Name/De	scription: Fork pipe plated		Supplier / Plant Approval D	ate		Customer Quantity Approval	/ Date (if Reqd.)						
Supplier/Plant: TUBE PRODUCTS OF INDIA LTD, SANAND Supplier Code: 101109				Other Approval Date (if red	qd.)		Other Approval Date (if reqd.)						
			01				Mathada						

					Characteristics					Methods							
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for Mfg.	No.	Ballon diagram	Product	Process	Spec Char. Class	Product / Process specification /	Evaluation	Sam	ple	Control Method/Erro	r Proofing	Reaction plan	Corrective Action		
			NO.	Seial NO.	Floudet	Flotess		Tolerance	Measurement Technique	Size	Freq.	Record / Error Proofing	Resp.				
			1		Clip groove inner dia			Ø 27.5 ± 0.1mm	Profile Proj. / Program control	5nos	Sample Approval	Layout Report	QA	Reject the Lot			
			2		ID boring 1	Boring Tool - Spindle RPM -2200 to 2500,	•	Ø 26.5 ± 0.1mm	Vernier Caliper	Program Controlled Dimn With Ref to 26.3 ± 0.1	Every Lot	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject the Lot	Inform the Shift Incharge		
			3		ID Boring 2	Hydraulic Pressure- 28 ~ 35 Bar, Clamping pressure - 15~20 kg/cm2 & Insert changing frequency 200	•	Ø 26.3 ± 0.1mm	Pluge gauge / Vernier Caliper	100% Inspection with Plug gauge	Every Lot	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject the Lot	Check the offset and inform to Prod Incharge		
			4		Before Clip Depth	Nos/Corner.		3 (0.1/0.0)mm	Vernier Caliper	First Piece/5 nos	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject the Lot	Check the offset and inform to Prod Incharge		
			5		Total Depth			19 (0.2/0.0)mm	Vernier Caliper	First Piece/5 nos	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject the Lot	Inform the Shift Incharge		
			6		Inner Chamfer Length and angle] [1x45°	Program Control			NO record					
30	MACHINING Clip Side	CNC Machine	7		Chamfer			1x15°	Program Control/Visual			NO record					
			8		Groove Dist			10±0.2mm	Program Control/Visual			NO record					
			9		Groove Diameter	Turning Tool - Spindle RPM -2500 to 3000, Hydraulic Pressure - 28 ~ 35 Bar, Clamping pressure - 18-20 kg/cm2 _ Feed rate - mm/ revolution -0.10 to 050, nsert changing frequency		Ø 28.2 (0.0/-0.2)mm	VernierCaliper/Snap Gauge	First Piece/5	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject	Check the offset and inform to Prod Incharge		
			10		Run Out clip side		RPM -2500 to 3000, Hydraulic Pressure - 28 ~ 35 Bar, Clamping pressure - 18-20 kg/cm2 "Feed rate - mm/ revolution -0.10 to 050,		0.1 mm	Dial	First Piece/5 nos	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject	Check the offset and inform to Prod Incharge	
			11		Roughness			,Feed rate - mm/ revolution -0.10 to 050,	,Feed rate - mm/ revolution -0.10 to 050,	,Feed rate - mm/ revolution -0.10 to 050,		1.6Ra	RA Tester	First Piece/5 nos	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod
			12		Clip width	400 Nos/Corner.		1.85 mm	Program Control			NO record					
				Clip groove angle] [30°	Program Control			NO record						
] [R0.65	Program Control			NO record							
			15		Groove Radius] [R6	Program Control			NO record					
			16		Total Length			288.3 ± 0.2	PokaYoke at Drilling Oper. / Length Gauge	100%	Every Lot	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject	Check the offset and inform to Prod Incharge		







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Prototype	Number : TPIGE/CP/03	Pre - Lauch	Produc	ction		Key Contact / Phone: Mr. Pa	alak Shah/ N	fr. Anand Nagare		Date(Orig.) 22-0	7-2022	Rev Date: 17.02.2024 (Loc	cation change)			
	F2FA19033O REV:XD					O T D. I. I. I. I. I.	N	A d		0		L Control (M.D. and):				
Part Number :	F2FA190330 REV:XD					Core Team: Palak/Piyush/ E	snupenara/	Anand		Customer Engl	neering Appro	val / Date (if Reqd.):				
Part Name/De	scription: Fork pipe plated	(KOPG)				Supplier / Plant Approval D	ate			Customer Quar	tity Approval	/ Date (if Reqd.)				
Supplier/Plant Supplier Co	: TUBE PRODUCTS OF IND de: 101109	IA LTD, SANAND				Other Approval Date (if req	d.)			Other Approval	Date (if reqd.)				
					Characteristics					Methods						
Part / Process Number	Process Name / Operation Description	Machine, Device, Jig, Tools for Mfg.	No.	Ballon diagram	Product	Process	Spec Char. Class	Product / Process specification /	Evaluation	Sam	ple	Control Method/Erro	r Proofing	Reaction plan	Corrective Action	
Number			NO.	Seial NO.	Product	Process	Olass	Tolerance	Measurement Technique	Size	Freq.	Record / Error Proofing Resp.				
40	Drilling	Drill M/c	1		Drill Dist	Drill bit frequency change after every 500 Nos tubes,		50.5 ± 0.2	Vernier Caliper	First Piece/5 nos	Every Hour	Set-up Approval /Inprocess Inspection Report	QA/Prod	Reject the Lot	inform to Prod Incharge	
			2		Drill Dia			Ø 1.5	Pin Gauge	First Piece/5 nos	Report		QA/Prod	Reject the Lot	inform to Prod Incharge	
			3		Total Length	Length Pokayoke		288.3 ± 0.2	Length Pokayoke	100%	Every Lot	POYA-YOKE daily monitoring sheet	QA/Prod	Stop / Quarantine	inform to Prod Incharge	
50	De-Burring	Deburring Fixture & brush	1		ID clean	Burr Clean		NA	Na	100%	Every Lot	NO Record	Prod	NA	NA	
60	OILING	Oiling	1		Surface Protection - Rust Preventive Oil			Free from Rust	Visual	100% Every Lo		NO Record	Prod	Rework	inform to Prod Incharge	
70	FINAL INSPECTION	Inspection Table	1		Inspection as per Sampling Plan			As per Dwg.	Visual / Mic/Plug Gauge/ Thread Gauge	Sampling Plan	Every Lot	TIGE/QA/PDI/01	QA	Stop / Quarantine	inform to Prod Incharge	

As per Packing Std

Manual

Customer Complaint Clip Side Dia. 28.2 -0.2 mm Oversize

ID oversize (Caulking side)

Caulking Depth Undersize

Tube Total Length Undersize

15 No's

Every Bin

Prepared By : - Palak Shah

Dispatch Area

80

Dispatch

Date:

05.07.2023

21.08.2023 18.09.2023

17.10.2023



Check for the Exact Qty

ved By: Anand Nagare

inform to Prod Incharge



PROCESS FMEA



PART DESCRIPTION	Failure					DATE (ORIGINAT	ΓED): 22.07.2022		REVISIO	ON NO. : 02		REV DATE : 17.02.2024		PAGE: 1 of 1				
						PROCESS RESPONSI	BILITY: Manufacturing		DOCUMENT NO. :									
Process Number / Function	Requirements	Potential Failure Mode	Potential Effect(s) of Failure	S e v	Classification	Potential Cause(s)/ Mechanism(s) of Failure	Current Process Controls Prevention	O c c	Current Process Controls Detection	D e t e	RPN	Customer Complaint	Responsibilit y & Target Date	Action Actions Taken	S e	O c	D e t	R. P. N.
		1.received raw Tube OD Oversize/ Undersize	Rejection at customer end on Grinding Line. Cannot be fitted & product will be sorted.	5		Material Mix up during visual inspection at Plant.		3	Inward Inspection	5	75			iakeii	v	ι	·	N.
	Dimesnion of Raw Tube as	2.received raw Tube Length Undersize/oversize	Causes Fitment Problem in assembly at Customer end	6		Length Cutting Setting Wrong/Mixup in Inspection		3	Inward Inspection / 100% inspection on Drilling m/c with Length detection Pokayoke.	2	36							
10 INWARD INSPECTION & STORAGE	per the drawing specification	3. Chemical / Mechanical Properties Not OK	Can be fitted but performance level reduced & product to be sorted and portion to be	6		Material Mix up/Wrong Material used		2	Cross verification with WTC of recevied.	2	24							
2.22		4. wet & Rust & Damage	Can be fitted but performance level reduced.	5		1.In Transit 2.Poor Oiling in Plant 3. Poor Packing of Boxes	1.Vehical should be fullly cover with proper tarpolin sheet 2. Deep oiling in Plant	4	Visual Inspection	2	40							
	Storage raw Material in proper Way	Rusty/ Mix-up	Can be fitted but performance level reduced.	5		1.material not kept at defined Place & Pallet. 2.FIFO not followed 3. Identification Tag Missing	1.Seperte location with pallet 2. Lot number/ Route card Identification on each lot. 3.100% tag put on all material while	4	Fixed Location for Storage Maintain Issue Regester before issue to Prod. Verify material before issue to Prod.	2	40							
		1. Caulking ID Ø 26.05 Oversize 2. Caulking ID Ø 26.05 undersize	Causes Fitment Problem in assembly at Customer end	8		Wrong Offset/tool wareout	1.Changing of Inserts as per Define frequency 2. Wear offset limit changes from 0.3 micron to 0.1 micron in Fanuic bases control	6	Set-up Approval /Inprocess Inspection Report	4	192	Caulking ID Oversize	Mr. Palak Shah 23.08.2023	Wear offset limit changes from 0.3 micron to 0.1 micron in Fanuic bases control 2. 100 % Inspection for ID Oversize with Plug Gauge 3. 100 % Inspection on Drilling PokaYoke	8	5	2	80
20 MACHINING CAULKING SIDE	Dimesnion of Machined Tube as per the drawing specification Req.	Caulking Depth Dim 46.1+0.1 mm undersize	Causes Fitment Problem in assembly at Customer end	8		Sudden M/c Stopage/ Power Failure	Quraintaine Sudden M/c Stopage/ Power Failure part	5	100 % Visual inspection on Deburring Stage	4	160	Caulking Depth Dim 46.1+0.1 mm undersize	Mr. Palak Shah 02.10.2023	Deburring tool modified with Slot made in bottom with paint for easy to Inspect. New Deburring Tool made with provision for inspection on top for Ring with Paint will not visible for Depth U/s. New detection Poka-yoke implemented on Drilling Fixture, M/c will not run if Depth Undersize Scrap the Sudden M/c Stopage/ Power Failure part	8	5	1	40
		Caulking side OD plane Turning Dia.Ø 28.5 mm O/s / U/s.	Causes Fitment Problem in assembly at Customer end	4		Wrong Offset/tool wareout	.1.Changing of Inserts as per Define frequency 2Wear offset limit changes from 0.3 micron to 0.1 micron in Fanuic bases control	5	100 % inspection on Detection Pokayoke on Drilling Fixture.	1	20							



PROCESS FMEA



PART DESCRIPTION	I : Fork Pipe Mach	ined REV:XD			DATE (ORIGINAT	TED): 22.07.2022		REVISIO	ON NO. : 02		REV DATE : 17.02.2024		PAGE: 1 of 1				
CORE TEAM : Pal					PROCESS RESPONSIE	BILITY: Manufacturing		DOCUMENT NO. :			Į.						
		Run Out clip side 0.1 mm More	Causes Fitment Problem in assembly at Customer end	6	Collet Chuck Run Out Burr in collet Tube Bend	collect and collect chuck Air cleaning after every 2hr.	5	Set-up Approval /Inprocess Inspection Report 2. 100 % Inspection at Plant	4	120							
		1.Clip side Boring ID 26.3 mm U/s & O/s 2Clip side Boring ID Ø 26.5 mm U/s & O/s 3.Clip groove inner dia Ø 27.5 ± 0.1mm U/s & O/s 4.Before Clip Depth3 (0.1/0.0)mm U/s & O/s 5. Total Depth 19 (0.2/0.0)mm U/s & O/s	Causes Fitment Problem in assembly at Customer end	8	Wrong Offset/tool wareout	1.Changing of Inserts as per Define frequency 2. Wear offset limit changes from 0.3 micron to 0.1 micron in Fanuic bases control 3. Ø 26.5 mm Program Controlled Dimn With Ref to 26.3 4.dia Ø 27.5 ± 0.1mm Program Controlled Dimn With Ref to 26.3 mm With Ref to 26.3 mm With Ref to 26.3 mm	4	1. 100% Inspection with Plug gauge for Ø 26.3mm 2. for Depth 3 mm 8t 19 mm Set-up Approval /Inprocess Inspection Report	3	96							
30 MACHINING Clip Side	Dimesnion of Machined Tube as per the drawing specification	Caulking side ID Run Out 0.08mm More	Causes Fitment Problem in assembly at Customer end	6	Collet Chuck Run Out Burr in collet Tube Bend	collect and collect chuck Air cleaning after every 2hr.	5	Set-up Approval /Inprocess Inspection Report 2. 100 % Inspection at Plant	4	120							
	Req.	Groove Diameter Ø 28.2 (0.0/-0.2)mm O/s & U/s	Causes Fitment Problem in assembly at Customer end	8	Wrong Offset/tool wareout/Tool Break	.1.Changing of Inserts as per Define frequency 2Wear offset limit changes from 0.3 micron to 0.1 micron in Fanuic bases control	5	Set-up Approval /Inprocess Inspection Report	4	160	Clip Side Dia. 28.2 - 0.2 mm Oversize	Pala Shah 22.10.23	SOP made for inspection of produced part before insert broken (if insert broken before changing frequency). Monitoring sheet made to record the Inspection status.(15 Parts of Before Insert Break) 3. 100 % part to checked with snap gauge for groove oversize.(Seprate Inspection stage added for next 3 Months)	8	3	2	48
		OD Chamfer 3x15°	Customer Dissatisfaction.	3	Collet Chuck Run Out 2.Burr in collet 3. Tube Bend	collect and collect chuck Air cleaning after every 2hr.	5	Set-up Approval /Inprocess Inspection Report 2. 100 % Inspection at Plant. 100 % Visual Inspection at final	4	60							
		Total Length 288.3 +/- 0.2 mm U/s & O/s	1) Functional Problem at customer End 2) Customer Dissatisfaction.	8	Improper Stoper resting. 2.Wrong Off set Raw tube Length U/s.	1.Wear offset limit changes from 0.3 micron to 0.1 micron in Fanuic bases control	5	100% Inspection on Sensor Pokayoke on Drilling M/c	3	120	Tube Total Length Undersize	Mr. Palak Shah 19.10.2023	Seperate 100 % Inspection with Length Gauge at Final Inspection.	8	5	2	80
40 Drilling	Dimesnion as per the drg specification	Drill Diameter U/S,O/S, Drill Missing	1) Functional Problem at customer End 2) Customer Dissatisfaction.	6	1) Tool Wear Out 2) Tool Runout	Drill change as per defined Frequency	2	1) Inprocess Inspection with Plug Gauge	3	36							
50 Deburring	Deburring ID	Burr IN ID	1) Functional Problem at customer End 2) Customer Dissatisfication	6	*	100% Deburring	2	No Recoed	3	36							



PROCESS FMEA



	rt No- F2FA19033C	REV:XD			DATE (ORIGINA				ON NO. : 02		REV DATE : 17.02.2024	PAGE: 1 of 1		
CORE TEAM : Pal	ak/Anand/Abishek				PROCESS RESPONSI	SILITY: Manufacturing		DOCUMENT NO. :						
60 Oiling	Oiling	Rust	Customer Dissatisfication	3	*	oiling 100%	2	No Recoed	3	36				
	As per drawing	Part Skipped from Final Inspection as per inspection aggrement	1) Rejection at customer end 2) Customer Dissatisfaction	6	Unskilled /New Inspector Linspector negligence	Training to Inprocess Inspector Tranning to the operator	2	1.Final Inspection Report.	3	36				
	Other Model tube mixup	Wrong Material Packed	1) Wrong part to customer 2) Customer Dissatisfaction	3	I. Improper Material handling 2.Unskilled operator	Awareness training to the operator.	3	1.Modelwise Trolly Storage, Modelwise Final Inspection Identification Colour Marking & Tag Colour.	3	27				
Packing	Packing & Dispatch as per standard	Qty Mismatch	1) Customer Dissatisfaction	3	I. Improper Material handling 2.Unskilled operator	Awareness training to the operator. Partiion Bins for Standerd Packing	3	1)Visual Inspection of Bin 2) Laoding Slip for packing	3	27				
	Customer Comp			-										
Rev-02 Location Change Prepared By:- Mr. Palak Shah									Approved E	Mar. Ama	ad Nagara			
	Palak Shah	ļ				<u> </u>	L	L		orloya				