

## Change Request Details - CM/23-24/0432

<b>Name of the Supplier</b>	SANJAY TECHNO PRODUCTS PVT LTD.(100118)
<b>Name of the Change Initiator</b>	Mr. Sudhir Damale
<b>Request Date</b>	May 17, 2023
<b>Proposal For</b>	New Change
<b>Proposed Changes</b>	Dies, Tooling change
<b>Process Route Change Details</b>	
<b>Description of Proposed Change</b>	Tool Duplication Pad Separator 4 mm 520QT00302.

### Part Details related with change

ETL Plant	Customer	Part No.	Proposed Saving
1159,1156,1120,	BAL,	520QT00302,	

<b>Current Details (Before)</b>	1. There are heavy flashes on inside & outside periphery, ejector pins in all cavities that need to be removed. 2.We have observed that the existing tool life has exceeded 23.50L Lack shots, (Exceeded life of 5 Lack Shots.)
<b>Trigger for the Change</b>	1. We recently faced a fitment issue with a mating part from ETL E71. The observed thickness was 4.60-4.63 against Spec. 4.7±0.1 mm, which is within spec. but closer to the lower spec. This causes loose fitments with the mating part, and this dimension affects the main function of this component. Unfortunately, correction was not feasible in the existing tool. 2. It is critical to de-flashing on corner of parting line, chances of part damaged are much more during de-flashing.
<b>Proposed Details (After)</b>	1.Maintained part thickness in upper side of the tolerances, Now perfect fitment with the mating part. 2.Now all cavities are free from flash, No need to de-flashing.
<b>Proposed Benefits of the Change</b>	Quality Improvement
<b>Current Status</b>	Inprocess
<b>Status Updated By</b>	700254
<b>Status Update Date</b>	Jul 25 2023 2:43PM

### Implementation Plan

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Activity	Target Date	Responsibility	Status
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### Reference Files

File For	File Name
Reference File	<a href="#">View File</a>
Reference File	<a href="#">View File</a>
Reference File	<a href="#">View File</a>
Reference File	<a href="#">View File</a>

### Activities For Final Approval

Activity	Answer	Responsibility	ETL Remarks	Supplier's Remarks	Final Remarks	Status	Plant	Department
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Samples required	Yes	Supplier				Pending	1159	PlantQA
Assembly trial required	Yes	ETL				Pending	1159	PlantQA
Testing and validation required	Yes	ETL	Trial done & sample approved.			Pending	1159	PlantQA
PPAP documents required	Yes	Supplier				Pending	1159	PlantQA
Customer approval required	Yes	Supplier				Pending	1159	PlantQA
Samples required	Yes	Supplier				Pending	1156	PlantQA
Assembly trial required	Yes	Supplier				Pending	1156	PlantQA
Testing and validation required	Yes	Supplier				Pending	1156	PlantQA
PPAP documents required	Yes	Supplier				Pending	1156	PlantQA

## Approval Process History

Role	Employee	Request Status	Comments	Updated On	Status
SQA	302090 - Atul Khoche	Concept Approved	Concept approved, subjected to samples approval and PPAP approval by Plant QA	May 30 2023 6:07PM	
Sourcing	301640 - Shrikant Muley	Concept Approved	Conceptually approved, PI go ahead for sample approval	Jun 6 2023 11:40AM	
PlantQA	851720 - Pravin Kulkarni	Concept Approved	Samples found OK & approved at assembly level.	Jun 8 2023 2:35PM	1159
PlantQA	700254 - Dinesh De	Concept Approved	Conceptually OK. But need flow CMR procedure before run the die in production	Jul 25 2023 2:43PM	1156
PlantQA	854881 - Omprakash Sunkawar	Pending For Conceptual Approval			1120
PlantQA	855352 - Ravi Nawkar	Pending For Conceptual Approval			1120