

Change Request Details - CM/23-24/0442

Name of the Supplier	SANGKAJ STEEL LTD(100189)
Name of the Change Initiator	Mr. N.R. Pardeshi
Request Date	Jun 29, 2023
Proposal For	New Change
Proposed Changes	Addition/Deletion of process stage, Change in process parameters /Process flow sequence, Manufacturing process route change
Process Route Change Details	Manufacturing the part through Cold Forging Instead of Bar Route.
Description of Proposed Change	Manufacturing the part through cold Forging and Subsequent threading operation by Thread Rolling. Fork Bolt K8 Part No.: F2DZ009120, Previously manufactured through Bar Route & Threading Operation on CNC. There was problem of the Part fitment due to Threading not ok. As threading done on CNC, Variation in thread Major Diameter caused the variation in threading. In the Proposed change, threading will be done with Thread Rolling & the Pre-Roll Diameter for the thread rolling is maintained in t

Part Details related with change

ETL Plant	Customer	Part No.	Proposed Saving
1117,	BAL,	F2DZ009120,	

Current Details (Before)	Part Manufacturing through Bar Route & Threading operation on CNC.
Trigger for the Change	For FY22-23, Total Rejection 71 Nos for M33X1-6H Threading Not OK.
Proposed Details (After)	Manufacturing Part through Cold Forging & Threading operation by Thread Rolling.
Proposed Benefits of the Change	Quality Improvement
Current Status	Inprocess
Status Updated By	855273
Status Update Date	Aug 21 2023 11:46AM

Implementation Plan

Activity	Target Date	Responsibility	Status

Reference Files

File For	File Name
Current Details (Before)	View File

Activities For Final Approval

Activity	Answer	Responsibility	ETL Remarks	Supplier's Remarks	Final Remarks	Status	Plant	Department
Samples required	Yes	Supplier	To ensure fitment trial at assembly			Pending	1117	PlantQA

Assembly trial required	Yes	ETL	To ensure fitment trial at assembly		Pending	1117	PlantQA
PPAP documents required	Yes	Supplier	Complete PPAP document required		Pending	1117	PlantQA

Approval Process History

Role	Employee	Request Status	Comments	Updated On	Status
Sourcing	301640 - Shrikant Muley	Resend	We understand your CMR for quality issue for threading & now you are shifting form CNC threading to thread rolling but the purpose of cold forging in not understand. Always welcome for VAVE & definitely there is cost reduction form bar rout to cold forging which is additional benefits with quality improvement. Also we don't not understand reason of CNC threading q issue. Revert back with details.	Jun 30 2023 3:55PM	
SQA	302090 - Atul Khoche	Resend	1. Supplier needs to provide the details regarding quality improvement, I.e., which defect will be improved and how much? 2. Needs to confirm that suppliers identified the cold forge defect and reaction plan has been initiated . Needs to share these details along with FMEA. 3. Productivity improvement details.	Jul 31 2023 11:32AM	
PlantQA	855273 - Rajkumar Maindarkar	Concept Approved	Risk assessment need to be submitted for comparison of old and new process through PFMEA. Statistical data required for variation in new process.	Aug 21 2023 11:46AM	1117
R&D	850852 - Pramod Kulkarni	Pending For Conceptual Approval			1117
Sourcing	856030 - Prasad Upadhye	Pending For Conceptual Approval			
SQA	854396 - Amit Bhalerao	Pending For Conceptual Approval			