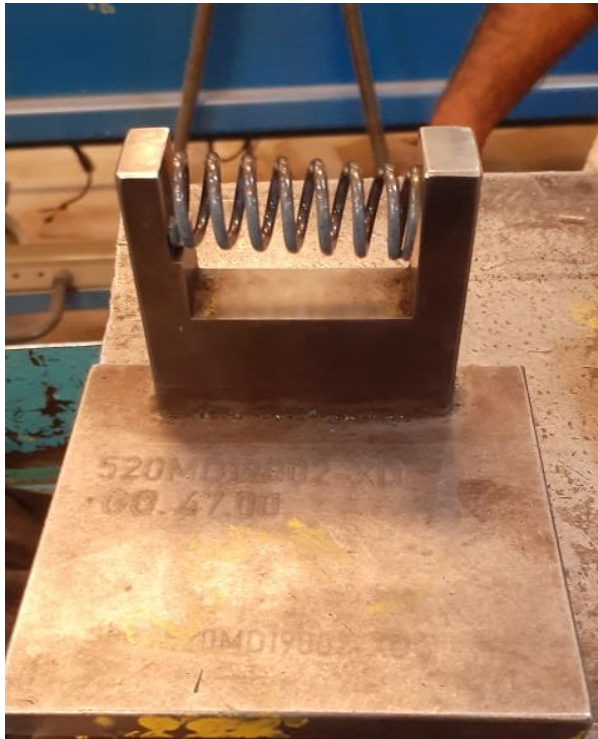
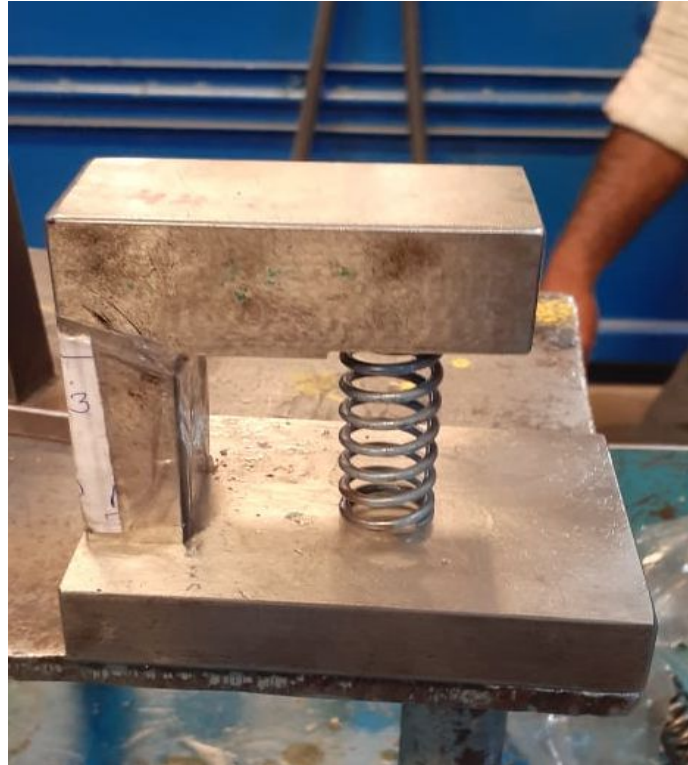


SS&SS		Cause analysis & 8D report								
Plant :-	Aurangabad	(To use for all Internal, Sub-supplier and for customer complaints (in case of no customer specific SOF))								
Part Name / Number / IC ;		520MD19002 / FCLS60353/ 4 Plate Vave Spring				Date :		8/3/2022		
Customer;		Endurance Technologies Ltd				Affected Qty. :		Lo O/s : 10 Mixup : 200		
Part produced by (Name of the Cell/Plant/Supplier/Sub-supplier) :-			ARGB			Input from ( Final/in process/Audits/Customer)		Customer End		
A	PROBLEM BRIEF;		Free Length Over Size							
B	CFT (if applicable / TL- Process/cell) :					Traceability				
	Name	Dept	Designation	Contact No	WO	1983941				
	Sreenivasulu	Plant Head	Plant Head	7030910891	Dt./Shift	14.07.2022 / G				
	Ravikumar	QA	Quality Head	7030910893	Qty Produced	33126				
	Pravin Chavan	Prod	Porduction Head	8383803937	Changes /Abnormal if any during shift (from records) :-					
	Shivkumar	QA	Engineer	8999835232						
C	Emergency actions									
	sl no	Stock at	OK Qty	Rej Qty	Disposition	sl no	Stock at	OK Qty	Rej	Disposition
	1	RMS	0	0		4	Transit	0	0	
	2	WIP	0	0		5	Customer	2990	10	Observed length Over size at Customer end.
	3	FGS	0	0		6	Supplier end	0	0	
D	Interim Containment action/s (Action/s that required to be taken on fresh production before implementing CAPA at Mfg., QA / Transit / Stores etc)									
	Action			By			Action			By
	After Receipt a complaint 100 % inspection done found ok			QA & Dispatch			Implemented Red Bins with lock system at each 100 % inspection table			QA & Prod
D	Root Cause									
	Occurance				Detection / Escape		Occurrence RC due to ( Tick appropriate) ;			
Why 1	Due to Length Variations from Coiling.				As per Drg. total tolence used for gauge made		Man	✓	Moment & Handling (Trolley/Bins/Boxes/Layout etc)	
Why 2	Due to Air Pressure length variation Occures				Unskilled Inspector		Machine		Mgmt Control (Eg. missed checks by super/Mgr etc)	
Why 3							Method (Mfg.)	✓	Measurement	
Why 4							Material (RM)		Measuring aids	
Why 5							Material ( Tools/Fixture/Gage) etc		Environment	
E	CAPA									
SI.No	CA			Tgt	By	Status	PA (/systemic action ; Tick appropriates)			
1	Plan for Length Variations tool set up in Coiling Stage			Inprocess	TM	OK	WO		FMEA	
2	75% tolerance used for New gauge & IN 19002 Horizontal Gauge Made			Competed	QA	OK	Machine set card		L2 Procedure	
3	Implemented Double sampling plan for 3-4 lots during final inspection stage.			Implemented	Prod	OK	1st Off		Layout	
4	Simmillar type of spring Packing polybag change to avoid Mixup issue.			Implemented	Prod	OK	PMC		Pokayoke	
5							WI/W.Std	✓		
6							CP			
F	Horizontal deployment									
If yes applicable IC / Process / Plant / Cell :-	FCLS60353			Implemented	Y	Planned & Track separately	Y	Communicated	Y	Others
G	Verification of CAPA									
Checked by (QA) name/Sign ;	Mr Shivkumar		Approved by (QA chief) Verified By :			Mr.Ravikumar				

## Improvements in Gauge



100% Drg. Tolerance used for Gauge Manufacturing,  
Skilled Inspector need for Insepction.



Gauge Design Changed and 75% Tolerances used for  
Gauge manufacturing

## Improvements in Gauge



Before there is White polyabag used for Simillar spring



Packing polybag Color change for White to Brown (19002) to avoid Mixup issue.