

SAGAR SPRINGS PVT LTD

Date 17.10.2022

Sub : Analysis of rejection samples received of
F1GN011020/XE

Part No : F1GN011020/XE

Complaint Details : -Total length undersize/Oversize

Specified Total length : - 211.40 – 219.40 mm

Observed :-210.37 mm

Complaint Details : -Total length oversize

Observed :-224.10 mm, 258.23 /235.54 /236.14 mm

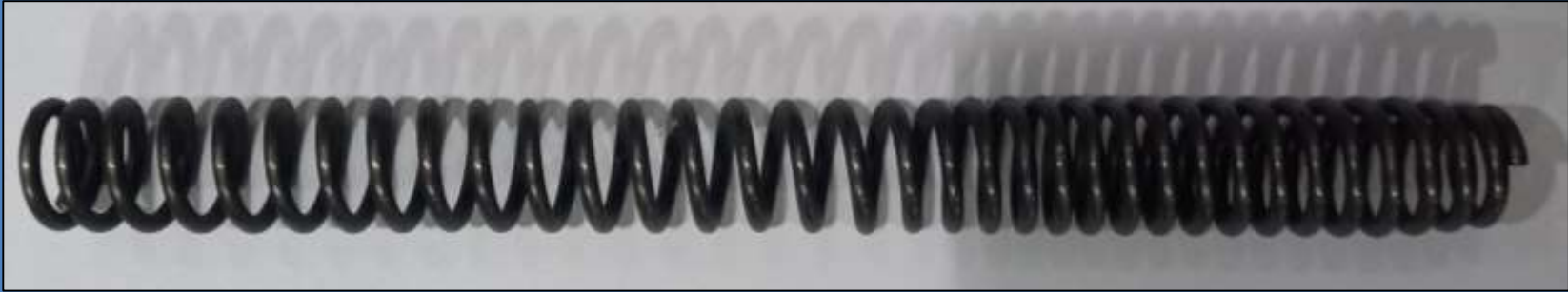
Rejection sample received from ETL-Sanand Dt : 17.10.2022

Total No : 6 nos



Rejection Tag		REVISED
E & T, SANAND		DATE
Date & Shift :-	6/10/2022	
Inspector/Operator Name :-	Jayesh	
Machine/Supplier Name :-	Sagar Spring	
Part Name & No :-	Main Spring	Model :- 186
Rejection Reason :-	High o/s	Qty :- 6
Operator's Signature	Supervisor's Signature	

Spring Defective Sample No 1



Sample Observation

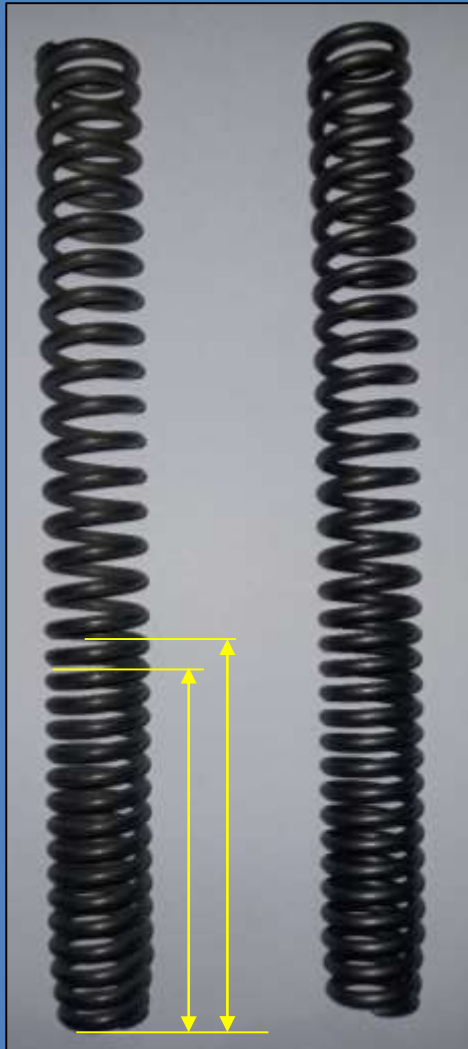
- Spring is Unground.
- Total Length is 237.50 mm
- No of Total Coil – 34.60 coil

SSPL Spring Observation

- SSPL – Total length – 221.90 mm
- No of Total Coil – 33.75

Final Observation : Spring received model is not in SSPL production history

Spring Defective Sample No 2



Spring sample 2
from ETL



SSPL Spring

Sample Observation

- Total Length is 223.80 mm
- Distance of 15 coil – 83.80 mm
- Distance of 16 coil – 89.50 mm
- No of Total Coil – 33.75 coil

SSPL Spring Observation

- Total Length is 221.00 mm
- Distance of 15 coil – 79.60 mm
- Distance of 16 coil – 85.50 mm
- No of Total Coil – 33.75 coil

5springs reading

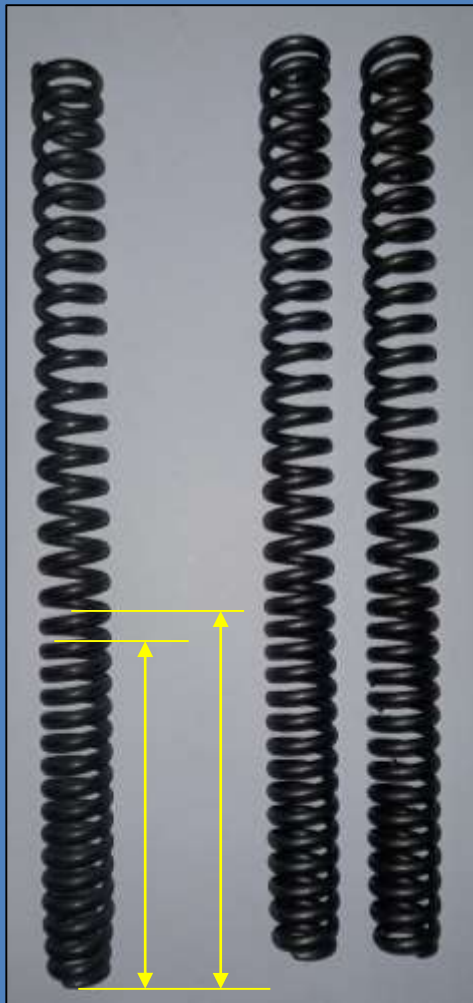
- Distance of 15 coil – 80.00, 79.38, 79.12, 79.45, 79.90
- Distance of 16 coil – 85.95, 84.73, 84.80, 85.15, 85.50

Final Observation : Spring received is not of SSPL

SSPL Spring

Spring sample
2 from ETL

Spring Defective Sample No 3, 4



Spring sample 3-4 from ETL



SSPL Spring

Sample Observation – 3

- Total Length is 218.10 mm
- Distance of 15 coil – 83.70 mm
- Distance of 16 coil – 89.97 mm
- No of Total Coil – 33.50 coil

Sample Observation – 4

- Total Length is 217.20 mm
- Distance of 15 coil – 84.80 mm
- Distance of 16 coil – 90.14 mm
- No of Total Coil – 33.50 coil

SSPL Spring Observation

- Total Length is 217.90 mm
- Distance of 15 coil – 80.55 mm
- Distance of 16 coil – 85.95 mm
- No of Total Coil – 33.75 coil

5springs reading

- Distance of 15 coil – 80.12, 79.30, 79.80, 79.70, 79.63
- Distance of 16 coil – 86.60, 85.30, 85.70, 85.76, 85.79

Final Observation : Spring received is not of SSPL.

SSPL Spring

Spring sample 3-4 from ETL

Spring Defective Sample No 5-6



Sample Observation

- Spring found is of Total Length – 240.00 and 240.90 mm
- No of Total Coil – 36.75 and 36.75

SSPL Spring Observation : Spring found is another model.

Final Observation : Spring found is of other model is of SSPL . Defect is model mix up

ACTION TAKEN FOR MODEL MIX UP

O.P.L (One Point Lesson)

Basic Knowledge:	Improvement Case: ✓	Trouble Shooting Case:
OPL Theme: To avoid mix up problem in front fork spring	Lesson No: 154	Date: 17.10.2022

Before



After



Impact : Earlier during model change Oil tank and spring holding bucket not check properly as a result spring of other model get mixed

Corrective Action: Oil tank and spring holding bucket to be check thoroughly whether it is emptied and no other spring is present inside it.

THANKS