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 ;	F2GN12502O/Main Spring RE J1D/FFFS60192	**Date :**	**03.04.2023**
Customer;	ENDURANCE TECHNOLOGIES LIMITED.	**Affected Qty. :**	185 No's
Part produced by (Name of the Cell/Plant/Supplier/Sub-supplier) ;-	ARGB	Input from (Final/in process/Audits/Customer)	Customer

A **PROBLEM BRIEF;** Parallesim Observed 2 mm against the spec of 1 mm max

B **CFT (if applicable / TL- Process/cell) :**

Name	Dept	Designation	Contact No
Deepak Machani	Plant Head	Plant Head	9822008852
Sreenivasulu	Prod	Porduction Head	7030910891
Ravikumar	QA	Quality Head	7030910893
Shivkumar	QA	Engineer	8999835232

Traceability

WO	2113233
Dt./Shift	22/03/2023 / G.
Qty Produced	4752 No's

Changes /Abnormal if any during shift (from records) ;-

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	700	185	Parallelism (e2) found out of Specification
3	FGS	1500	0	Rework for All Material	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
Action	QA & Prod	Internal Stock verified and Found 10:1 parts Parallelism out of specification all parts rework done for parallelism	QA & Prod

D **Root Cause**

	Occurance		Detection / Escape	Occurrence RC due to (Tick appropriate) ;			
Why 1	Spring Parallelism outof specification found		100% inspection & Correction stage not effectively carried out for Both end	Man	✓	Moment & Handling (Trolley/Bins/Boxes/Layout etc)	
Why 2	In grinding Process Operator remove spring before complete of cycle		Final inspection Carried as per sampling plan.	Machine		Mgnt Control (Eg. missed checks by super/Mgr etc)	
Why 3	Due to new operator			Method (Mfg.)	✓	Measurement	
Why 4				Material (RM)		Measuring aids	
Why 5				Material (Tools/Fixture/Gage) etc		Environment	

E **CAPA**

Sl.No	CA	Tgt	By	Status	PA (/systemic action ; Tick appropriates)			
1	In Grinding operation Instruction given to Operator part will not be remove before compleation of Cycle Stop.	Completed	Prod	Ok	WO		FMEA	
2	Instruction given to Opeartor, Check Spring Both ends grinding operation is done propely - OJT Provided	Completed	Prod	Ok	Machine set card		L2 Procedure	
3	Awarness given to Inspection stage bigger OD Spring for Both end Spring should be stand - OJT Provided	Completed	QA	Ok	1st Off		Layout	
4	OPL and WI dispaly at Correction Stage	Completed	QA	Ok	PMC		Pokayoke	
5	After Correction hourly basis e2 parameter Inspection Started and monitoring once in hours	Completed	QA	Ok	WI/W.Std	✓		
6					CP			

F **Horizontal deployment**

If yes applicable IC / Process / Plant / Cell ;-	FF Cell	Implemented	Y	Planned & Track separately		Communicated	Others	✓

G **Verification of CAPA**

Checked by (QA) name/Sign ;	Mr. Shivkumar Fartade	Approved by (QA chief) Verified By :	Mr. H Ravikumar

Stumpp Schuele & somappa springs Pvt,Ltd.	DOC NO: ARGB - WI -03
WORK INSTRUCTIONS FOR CHECKING SQUARENESSe1,PARALLELISMe2,WAVYNESS & 100%FREE LENGTH:	REV NO : 01
	DATE : 03.04.2023

Fig.01

Fig.02

Fig.03

Fig.04

SQUARENESS e1 & WAVYNESS CORRECTION:

Scrag the Springs Before Checking Squareness,Parallelism,Wavyness and Freelength In The Hydrolic Press.

Roll The Scragged Spring On The Surface Plate For Checking Bend Or Wavy ness on Spring as shown in Fig 03.

Remove The Bend In The Spring By Manually.

Check The Gap B/W Spring and Surface plate body By Rolling The Spring By Touching The Body of The Surface plate As Shown In Above Fig 01.

Continue The Same Process For Other Scragged Springs For e1 Correction Operation.

PARALLELISM e2:

After Squarenes & Wavyness correction Done On The Scragged Spring Chech the Spring Parallelism By Standing The Spring Vertically On The Surface Plate Vertically stand from Both ends for Bigger Spring OD.

Open the 2 - 3 Coils Equally & Slightly With the help of Arbour Press For Adjusting The Standing of springs as Shown in Fig 03.

100% FREE LENGTH CORRECTION:

Adjust The Free length Gauge As Per Drawing specification with the help of DVC Or Standard Length Gauge.

Check The Springs In Setted Length Gauge as shown in Fig 04.

If Free length Is Less Than The Drg Specification Or Not Qualifying The Length Gauge Make The Necessary Correction.

Prepared By: Mr. Shivkumar Fartade

Approved By: Mr.Ravi Kumar

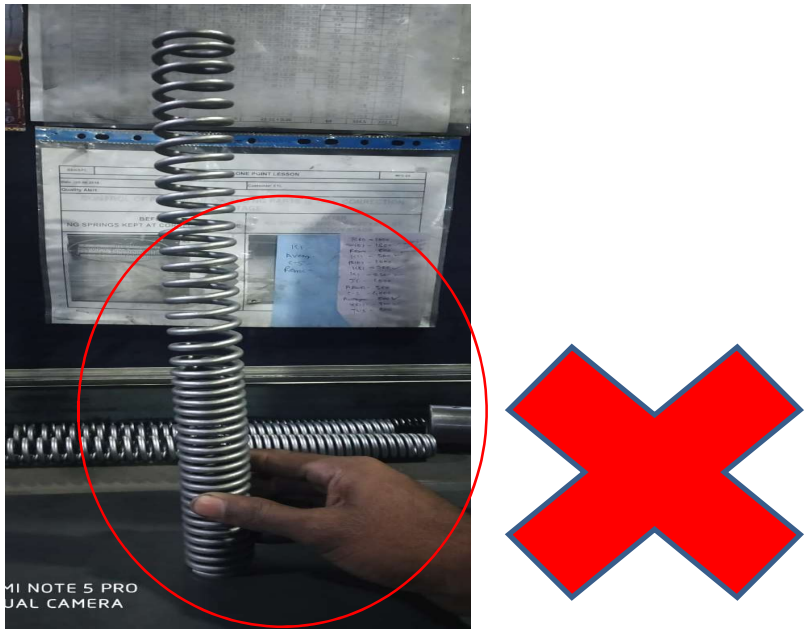
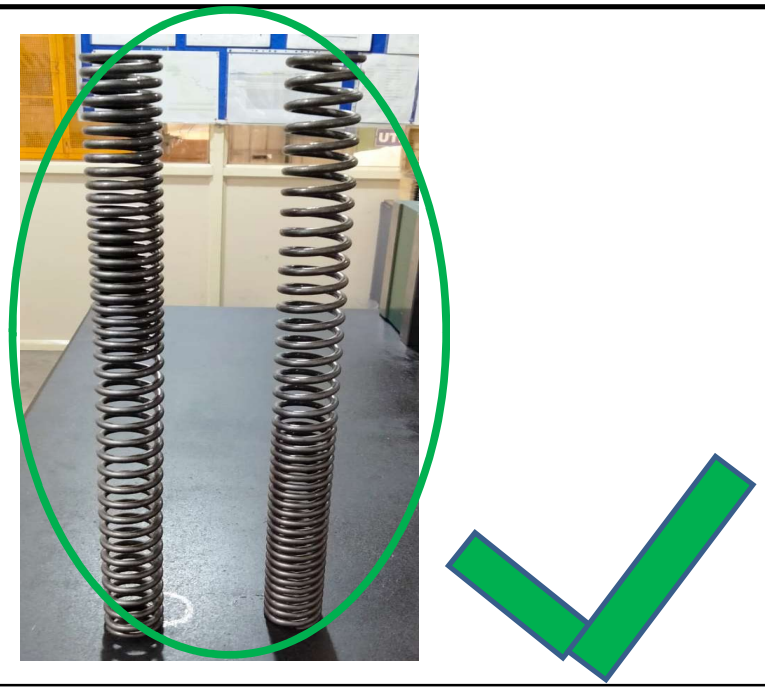
SSSSPL	QUALITY ALERT / ONE POINT LESSON	ARGB -SS

Date : 03.04.2023	Customer: ETL

Quality Alert:

VISUAL CONTROL FOR MAIN SPRING

PROBLEM: Parallelism e2 not ok

NOT OK	OK
	
Surface प्लेट वर स्प्रिंग्स सरळ उभा राहत नाही	स्प्रिंग्स surface प्लेट दोन्ही बाजूने सरळ उभा असावी. (Open & Close End)

STUMPP, SCHUELE & SOMAPPA SPRINGS PVT. LTD.

Training attendance Sheet

Training Programme: Customer Complaints Awareness

Venue : Front Fork C211

Faculty : Mr Shivkumar

Date : 03/04/2023

Time : 10.0AM to 11.0AM

Contents of the Training

Main Spring 21D - Quality issue (Parallelism Not ok, Grinding Surface Not ok)

Sr.No.	NAME	EMP/Token no.	Department	Signature
1	Narayan Shinde	600900	F.F	Narayan
2	Yogesh Jeren	625	F.F.	[illegible]
3	रवि	452	FF	Ravi
4	Surendaya	31	F.F	[illegible]
5	Shankar Fadat	28	F.F.	Fadat
6	Aasef Shaikh	27	F.F.	A.shaikh
7	Saineeth S. Valegh	83245	Q.A	[illegible]
8	Atul R. Kale	71681	Q.A.	A.Kale
9				
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QR-FR-017C 01

Stumpp Schuele & Somappa Springs Pvt,Ltd.

IN-PROCESS INSPECTION REPORT

Customer:Endurance techonologies Ltd. **Main Spring** **Date :** 03/04/2023

Part name / no.	Time	Parallelism	Parameter	Observation 1	2	3	4	5	Remark
JID	8.0 AM	1.0mm	Open side	0.8	0.7	0.6	0.5	0.5	Ok
			Close side	0.7	0.6	0.7	0.7	0.6	Ok
		390+4	Free Length	391.13	392.5	391.78	391.43	391.51	Ok
		35.5±0.2	OD	35.59					Ok
690 SMC	9.0 AM	1.0mm	Open side	0.7	0.6	0.8	0.6	0.7	Ok
			Close side	0.8	0.7	0.7	0.8	0.6	Ok
		450±2.0	Free Length	451.64	451.7	451.88	450.76	451.89	Ok
		43.2±0.2	OD	43.15					Ok
KT06	10.0 AM	0.7mm	Open side	0.5	0.45	0.6	0.4	0.5	Ok
			Close side	0.6	0.5	0.65	0.5	0.6	Ok
		345±2.0	Free Length	344.1	344.6	344.6	345.4	345.26	Ok
		37.0±0.3	OD	37.11					Ok
			Open side						
			Close side						
			Free Length						
			OD						
			Open side						
			Close side						
			Free Length						
			OD						
			Open side						
			Close side						
			Free Length						
			OD						
			Open side						
			Close side						
			Free Length						
			OD						
			Open side						
			Close side						
			Free Length						
			OD						

Remarks:-

Checked By : [signature]