ENDURANCE Complete Solutions Endurance Group	**Corrective Action Report (Supplier)**	Doc No. :FT-QA- 43 A Rev. No. : 00 Rev. Date : 04.08.2021 Page No. : 01 of 02

NC No.		Part No. & Rev. No.	520PL04302O/B	ETL Division	SUSPENSION
NC Date	30.05.2024	Part Name	WASHER DF-01	ETL Plant	NARSAPURA
NC Submission Date		Supplier Name & Code	SAPTAGIRI INDUSTRIES(100165)		

1. Problem Description (To be filled by ETL)

Defect Description	THICKNESS O/S					Defect Photo / Sketch
Detection Satge (√)		**Problem Severity (√)**		**NG Qty**		
Receipt		Safety				
Inprocess		Fitment				
Customer End	√	Function				
Warranty		Aesthetic				
Repeatative (√)		Yes		No	√	

2. Stock Details & action taken for NG Parts	**Location -->**	**ETL End**	**Warehouse**	**Transit**	**Supplier FG**	**Supplier WIP**	**Total**
	Total Qty	4000	0	0	1000	0	5000
	Check Qty	4000	0	0	1000	0	5000
	NG Qty	13 nos	0	0	0	0	13
	Action Taken	Scrap	**SRCAP**	Rework		Under Deviation	

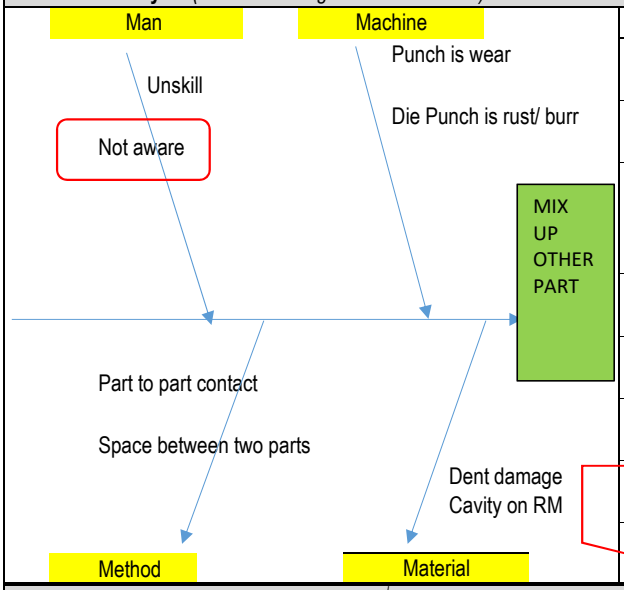
2. a Containment Action : Re inspect all Pipeline ,material at Saptagiri End.

3. Process Flow

RM sheet IN → SHEET SHEARING → BLANKING & PIERCING → PLATING → Final Inspection → Packing / Dispatch

4. Process Details	Process / Operation	Press and Plating		Outsource	Yes	√	No	√
	Machine / Cell	Press Shop	Machine / Cell No.	SI/ PS / 05				

5. Problem Analysis *(Fish Bone Diagram & Fact Check)*



#	Possible Cause	Fact Verification	Jud
	Punch is wear	Not	
	Die Punch is rust/ burr	Not	
	Dent damage Cavity on Material	No chance all portion of Die Is found OK	
	Part to part contact	No contact	
	Space between two parts	No metal contact	
	Unskill	Skill man	
	Not aware	Awareness is less	

6. Inspection Method Analysis (Current) (√)

Inspection Method	Pokayoke		Gauge		Instrument		Sp. Gauge		Other	Visual
Check Point at FI	Yes	√	No		**Checking Freq.**	100%	Sampling		Sample Size	

7. Root Cause Analysis

	Why 1	Why 2	Why 3	Why 4	Why 5
Occurrence	Material Thickness os More	Wrong size part	Mix other part		

Root Cause (Occurrence)	Mix other part

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	Why 1	Why 2	Why 3	Why 4	Why 5
Outflow	Material Thickness os More	Inpection method is visual	for visualisation sufficient Awareness required	At a time multi model packed	

Root Cause (Outflow)	At a time multi model packed

8. Countermeasure (Occurrence , Outflow & System side Actions) Both, Long term and short actions to be mentioned

#	Countermeasure Details	Resp.	Tgt Date	Status
Occurrence	Get separate the tables of Modelwise	Mr. Solankhe	21.06.2024	G
Outflow	At a time only One part Model to be Packed	Mr. Pradip	24.06.2024	G

9. Inspection Method After Customer Complaint (√)

Change In Inspection System		Yes		No	√	Details									
Inspection Method	Pokayoke		Gauge		Instrument		Sp. Gauge		Other	Visual					
Check Point at FI	Yes	√	No		**Checking Freq.**	100%		Sampling		Sample Size					

10. Evidance of Countermeasure

	Before	After		Before	After
Occurrence		Get partition,	Outflow		

11. Horizontal Deployment (√)

Horizontal Deployment Required	Yes	√	No		Target Date	01.06.2024
Applicable Machine / Model / Plant						

12. Document Review (√)

Drawing		Control Plan		PM Check Sheet		Pokayoke Check Sheet		If other, specify	
PFMEA		WI / SOP	√	JH Check Sheet		Audit Check Sheet			
Process Flow Chart		Packing Std		Insp Check Sheet					

13. Effectiveness of Action *(To be monitored by ETL)*

Date				**Remarks**
Qty				
Status				
Verified By				

Dhirajkumar	Mr. Nitin Wagade		
Prepared By (Supplier)	**Approved By (Supplier)**	**Reviewed By (ETL)**	**Approved By (ETL)**