

Step

1

2

3

4

5

Step

1

2

3

4

Step

1

6

7

8


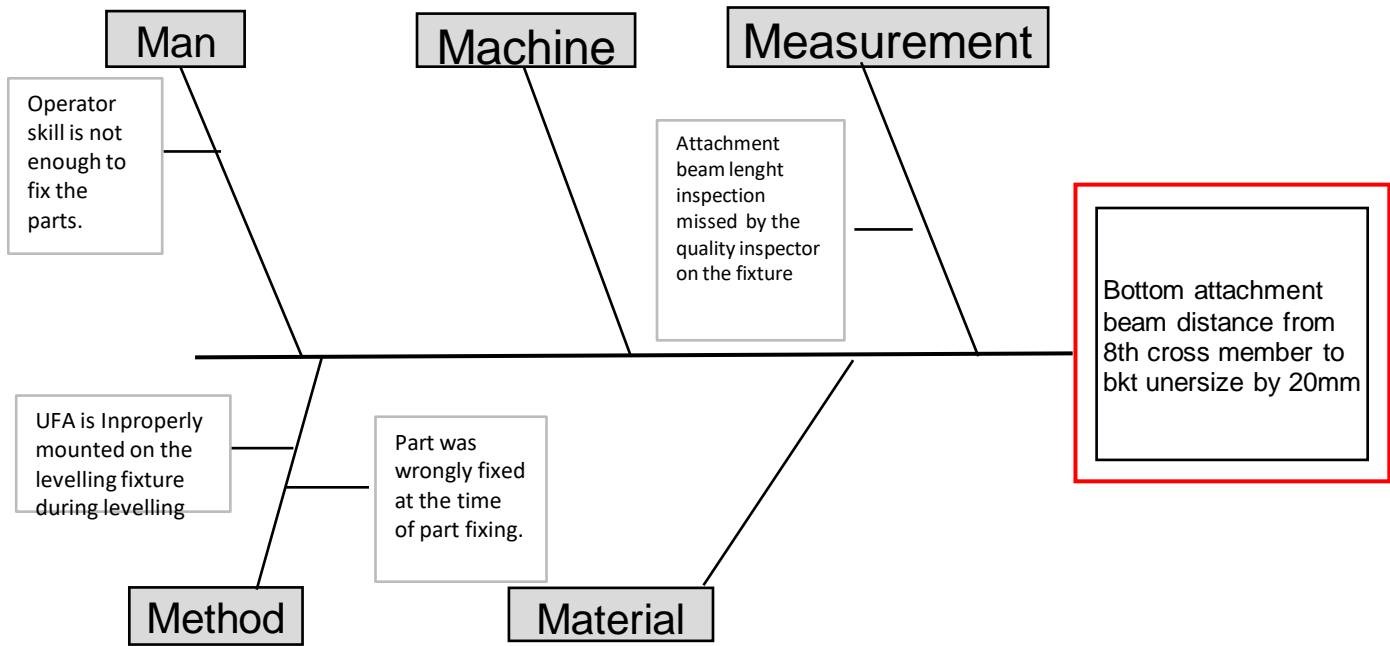
Step


1


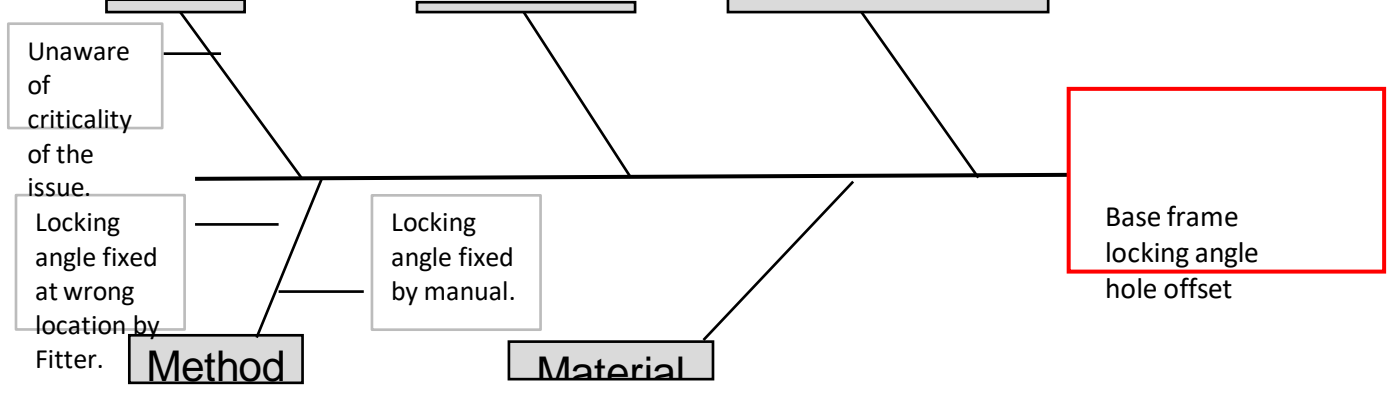
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Sparkline							Doc No:	QD/06
							Rev No:	00
							Date:	17.05.17
Problem Statement		Part Number	461 UFA	Date	Issue No.	Responsible dept	Responsible	Issue observed at : DICV Line
Bottom attachment beam fitment issue		Part Name :	9T UFA	10.03.18	-	SEPL Quality & Production	Praveenkumar	07-02-2018
		Supplier Name :	Spark line Equipments					
Problem Description		Defect Photo		Cause validation symbols for results: O= no direct cause X= direct cause Δ= inexplicit cause				
Bottom attachment beam distance from 8th cross member to bkt unersize by 20mm				No.	Investigation method	Weightage	WHY?	
				1-	Unawre of the dimension and criticality of the dimension.	O	Bottom attachment beam distance from 8th cross member to bkt unersize by 20mm	
Inspection Lot: 3				2-	Part was wrongly fixed at the time of part fixing.	X	WHY?	
Affected / Blocked Quantity : 1				3-	Attachment beam lenght inspection missed by the quality inspector on the fixture.	O	WHY?	
				4-	UFA is Inproperly mounted on the levelling fixture during levelling	O	WHY?	
				5	Operator skill is not enough to fix the parts.	X	WHY?	
Probable root cause:								Root cause
1-Unawre of the dimension and criticality of the dimension.								1-Part was wrongly fixed at the time of part fixing.
2-Part was wrongly fixed at the time of part fixing.								3- Attachment beam lenght inspection missed by the quality inspector on the fixture.
3- Attachment beam lenght inspection missed by the quality inspector on the fixture.								
4- UFA is Inproperly mounted on the levelling fixture during levelling								
5-Operator skill is not enough to fix the parts.								
Interim containment action								
When(Date)	Containment Action By Whom	OK Quantity	Rejected Quantity					
At DICV :	SEPL Representative	2	1					
At SEPL :	Quality inspector	3	3					
Cause & Effect								
								

Corrective action					
No.	Countermeasures	Who	When	Status	Validation
1	All attachment beam distance must be inspected	SEPL	8.02.18	Started	Continuously followed
2	Poke-yoke is provided to control attachment beam lenght within limit	SEPL	10-02-2018	Completed	After implementing no issues found on the further dispatches.
Horizontal deployment process - Preventive action					
Will be applicable for all models of 9T Under frames					
					

Sparkline							Doc No:	QD/06
							Rev No:	00
							Date:	17.05.17
Problem Statement		Part Number	4.2 tons B3	Date	Issue No.	Responsible dept	Responsible	Issue observed at : Saint gobain
Base frame and side frame II fitment issue at customer end.		Part Name :	Collier	26.10.17	-	SEPL Quality	Praveenkumar.s	24.10.17
		Supplier Name :	Spark line Equipments Pvt. LTD					
Problem Description		Defect Photo		Cause validation symbols for results: O= no direct cause X= direct cause Δ= inexplicit cause				
Base frame and side frame II locking hole offset which leads to fitment issue at customer end.				No.	Investigation method	Weightage	WHY?	
				1	Base frame locking angle fixed at wrong location by Fitter.	X	Base frame and side frame II fitment issue at customer end.	
Inspection Lot: 15				2	Unaware of criticality of the issue.	O	WHY?	
Affected / Blocked Quantity : 1				3	Locking angle fixed by manual	X	WHY?	
							WHY?	
							WHY?	
Probable root cause:								Root cause
1- Base frame locking hole offset at LH side due to wrong fitment.								Locking angle fixed by manual
2-Locking angle fixed at wrong location by Fitter.								
3-Unaware of criticality of the issue.								
4-Locking angle fixed by manual								
Interim containment action								
When(Date)	Containment Action By	OK Quantity	Rejected Quantity					
At Saint gobain:	SEPL Representative	14	1					
At SEPL :	Quality inspector	20	-					
Cause & Effect								
								

Corrective action					
No.	Countermeasures	Who	When	Status	Validation
1	Base frame locking angle fixed on the fixture	SEPL	From next dispatch	Completed	After implementing no issues found on the further dispatches.
Horizontal deployment process - Preventive action					
Same procedure will be followed for J1 collier.					
