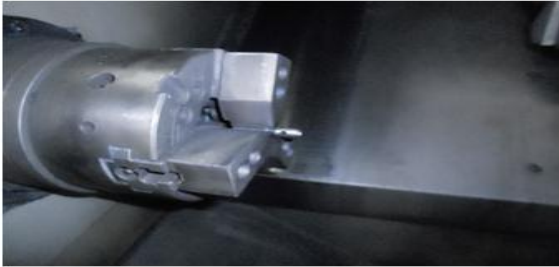



QUALITY IMPROVEMENTS – A225 PRV

PROD

ADVIK	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	KAIZEN IDEA SHEET																																				
	TPM Circle Name:	Loss no.																																													
Plant-1 Chakan	Dept.: Machine Shop	Step									Kaizen No.:																																				
Cell No.: 01	Cell Name: A225 relief valve	Result Area	P	Q-		C	D	S	M	Operation : Machining																																					
Kaizen Theme: To eliminate concentricity rejection		Idea : Tail stock center provided on machine to avoid job deflection in running.																																													
		Counter Measure: 1) One side tail stock center provided.																																													
Problem / Present Status: 1) Concentricity of A225 prv not ok ID TO OD. 2) Wall thickness found -		Before : 					<table border="1"> <tr> <td>Bench Mark</td> <td>500</td> </tr> <tr> <td>Target</td> <td>0</td> </tr> <tr> <td>Kaizen Start</td> <td>15-May-14</td> </tr> <tr> <td>Kaizen Finish</td> <td>19-May-14</td> </tr> <tr> <td colspan="2">Team Members With Sign :</td> </tr> <tr> <td colspan="2">1.Someswar</td> </tr> <tr> <td colspan="2">2 Maruti sagar</td> </tr> <tr> <td colspan="2">3. Nana ugale</td> </tr> <tr> <td colspan="2">Benefits:</td> </tr> <tr> <td>P</td> <td>Productivity increased</td> </tr> <tr> <td>Q</td> <td>Concentricity ok</td> </tr> <tr> <td>C</td> <td></td> </tr> <tr> <td>D</td> <td></td> </tr> <tr> <td>S</td> <td></td> </tr> <tr> <td>M</td> <td>---</td> </tr> <tr> <td colspan="2">Kaizen Sustenance :</td> </tr> <tr> <td colspan="2">What to do : Tailstock clamping to be provided on machine.</td> </tr> <tr> <td colspan="2">How to do : Ensure tailstock clamping while PRV machining.</td> </tr> </table>					Bench Mark	500	Target	0	Kaizen Start	15-May-14	Kaizen Finish	19-May-14	Team Members With Sign :		1.Someswar		2 Maruti sagar		3. Nana ugale		Benefits:		P	Productivity increased	Q	Concentricity ok	C		D		S		M	---	Kaizen Sustenance :		What to do : Tailstock clamping to be provided on machine.		How to do : Ensure tailstock clamping while PRV machining.	
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Why Why Analysis : Why 1) ID not concentric to OD Why 2): During OD turning component clamped incorrectly. Why 3) Job deflect in running condition.		After : 																																													
Root cause- Job deflect in running condition.		Result : 1) Concentricity ok 2) Productivity is increased . 3) Quality improve.																																													
Registration no.& dt : :20/05/14																																															
Submitted by : Someswer																																															
Manager's Sign : Surendra Kulkarni																																															
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