
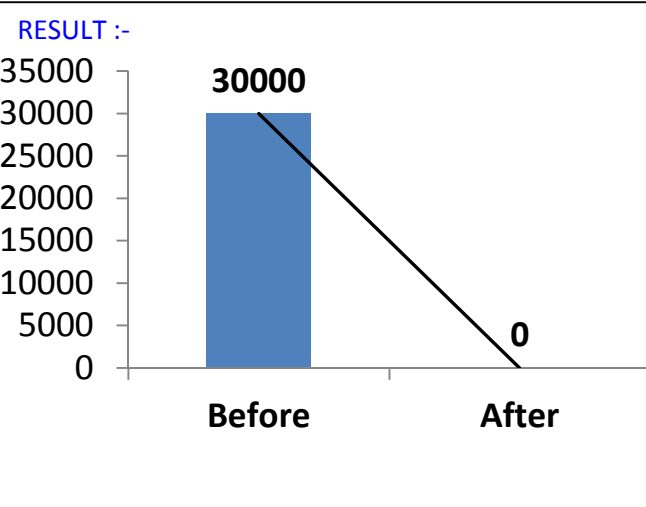


										KAIZEN IDEA SHEET								
TPM CIRCLE NO :-		ACTIVITY		KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN NO:-07						
TPM CIRCLE NAME :-		LOSS NO. / STEP																
DEPT :- IQA		RESULT AREA		P	Q	DEF:- A	C		D	S	M							
CELL :-A103	CELL NAME:-Tensioner Assy.	MACHINE / STAGE :- Supplier End Atul Ent					OPERATION :-HT											
KAIZEN THEME To prevent A103 Thrust washer Sticky problem			IDEA :-1) Add the tumbling process for remove the scaling															
WIDELY/DEEPLY:-			COUNTERMEASURE:- Add the tumbling process for remove the scaling															
PROBLEM / PRESENT STATUS :-																		
<h3 style="color: blue;">No any process available for scaling remove</h3>																		
BEFORE			AFTER															
WHY - WHY ANALYSIS :- Why 1:A103 Thrust washer sticky Why 2 : In quenching process oil gets stick on surface Why 3:No tumbling process after HT			RESULT :-  <table border="1" style="margin-top: 10px;"> <tr> <th>Category</th> <th>Value</th> </tr> <tr> <td>Before</td> <td>30000</td> </tr> <tr> <td>After</td> <td>0</td> </tr> </table>										Category	Value	Before	30000	After	0
Category	Value																	
Before	30000																	
After	0																	
ROOT CAUSE : No tumbling process after HT -			WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram HOW TO DO : Verify the action plan - FREQUENCY – As Per supplier Audit plan.															
REGISTRATION NO&DATE: 19.07.2014			COST INCURRED FOR MAKING KAIZEN															
REGISTERED BY :- Mohan Kate			MATERIAL COST IN RS		LABOUR COST IN RS		TOTAL COST IN RS											
MANAGER'S SIGN :- Sunil Kinkar			-----		-----		-----											
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																		
Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS														
1	-----	-----	-----	-----														