


		TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET KAIZEN NO:-07						
		TPM CIRCLE NAME :	LOSS NO. / STEP															
		DEPT :- IQA	RESULT AREA	P	Q	DEF:- A	C		D	S	M							
CELL :-A312	CELL NAME:-	MACHINE / STAGE :- Supplier End Matrix						OPERATION :- PDC										
KAIZEN THEME To prevent A312 body flash on profile			IDEA :- Added both side pin in die to avoid flash defect in mounting hole.															
WIDELY/DEEPLY:-			COUNTERMEASURE:-1) Added both side pin in die to avoid flash defect in mounting hole.						BENCHMARK		2240 No.							
PROBLEM / PRESENT STATUS :-									TARGET		0 No.							
									KAIZEN START		04.07.2014		KAIZEN FINISH		17.07.2014			
			BEFORE						AFTER									
WHY - WHY ANALYSIS :-			RESULT :-															
Why 1 –A312 mounting hole ϕ 6.2+0.3 undersize ,6.5 pin not enter in mounting hole			<div style="text-align: center;"> <h3>Re-occurrence of Complaint</h3> <table border="1" style="margin: 10px auto;"> <thead> <tr> <th>Category</th> <th>Value</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>2240</td> </tr> <tr> <td>After</td> <td>0</td> </tr> </tbody> </table> </div>										Category	Value	Before	2240	After	0
Category	Value																	
Before	2240																	
After	0																	
Why 2 – Flash in mounting hole.																		
Why 3 –Gap in fix up side & moving side pin																		
Why 4 –operator removing flash manually																		
Why 5 –Single hole fettling by operator & skip it.																		
ROOT CAUSE :- 1)Single hole fettling by operator & skip it			WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram															
REGISTRATION NO&DATE: 18.07.2014			HOW TO DO : Verify the action plan -															
REGISTERED BY :- Mohan Kate			FREQUENCY – As Per supplier Audit plan.															
MANAGER'S SIGN :- Sunil Kinkar			BEFORE						AFTER									
COST INCURRED FOR MAKING KAIZEN																		
MATERIAL COST IN RS				LABOUR COST IN RS				TOTAL COST IN RS										
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																		
SR. NO.	CELL	TARGET	RESPONSIBILITY			STATUS												
1	-----	-----	-----			-----												