

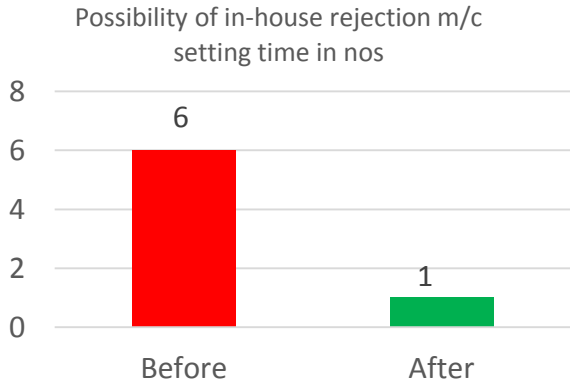


| ADVIK | | TPM CIRCLE NO :-8 | | ACTIVITY | | KK | QM | PM | JH | SHE | OT | DM | E&T | KAIZEN IDEA SHEET | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|-------------------|----------------------------|--|--|----------------|----------------------------|------------------|------------|-------------|---|-----------------|--------|------------------|-------------------|--------------|--|-----------------|--------|---|-------|---|--------------|----------------|---|-------------|---|-------------------|---|-----------------|---|------------------|---|--------------|--------|--|-------|--|--|--|
| | | TPM CIRCLE NAME: Star | | LOSS NO. / STEP | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | DEPT :- Production | | RESULT AREA | | P | Q | A | | C | D | S | M | | | | | | | | | | | | | | | | | | | | | | | | | | |
| CELL:- Oil pump | | CELL NAME:- A315/A387/A449 | | MACHINE / STAGE :- FRD | | | | | | OPERATION :-Facing & Boring | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| KAIZEN THEME :- To improve quality | | | | IDEA :- Operation sequence change. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Problem present status :-Possibility of in-house rejection during m/c setting time | | | | COUNTERMEASURE:- Operation sequence change now 1 st operation Back facing & 2 nd operation dia. 23.15 reaming & other. | | | | | | BENCHMARK | | 6 nos | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  <table border="1" data-bbox="721 396 988 639"> <thead> <tr> <th>Op. seq. no.</th> <th>Operation name</th> </tr> </thead> <tbody> <tr><td>1</td><td>Dia. 23.0 boring</td></tr> <tr><td>2</td><td>Back facing</td></tr> <tr><td>3</td><td>Dia.9.0 reaming</td></tr> <tr><td>4</td><td>Dia. 8.0 reaming</td></tr> <tr><td>5</td><td>Back chamfer</td></tr> </tbody> </table> | | | | Op. seq. no. | Operation name | 1 | Dia. 23.0 boring | 2 | Back facing | 3 | Dia.9.0 reaming | 4 | Dia. 8.0 reaming | 5 | Back chamfer | <table border="1" data-bbox="1014 362 1281 608"> <thead> <tr> <th>Op. seq. no.</th> <th>Operation name</th> </tr> </thead> <tbody> <tr><td>1</td><td>Back facing</td></tr> <tr><td>2</td><td>Dia. 23.15 boring</td></tr> <tr><td>3</td><td>Dia.9.0 reaming</td></tr> <tr><td>4</td><td>Dia. 8.0 reaming</td></tr> <tr><td>5</td><td>Back chamfer</td></tr> </tbody> </table>  | | | | | | Op. seq. no. | Operation name | 1 | Back facing | 2 | Dia. 23.15 boring | 3 | Dia.9.0 reaming | 4 | Dia. 8.0 reaming | 5 | Back chamfer | TARGET | | 1 nos | | | |
| | | | | Op. seq. no. | Operation name | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | Dia. 23.0 boring | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | Back facing | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | Dia.9.0 reaming | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | Dia. 8.0 reaming | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5 | Back chamfer | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Op. seq. no. | Operation name | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | Back facing | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | Dia. 23.15 boring | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | Dia.9.0 reaming | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 | Dia. 8.0 reaming | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 5 | Back chamfer | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| KAIZEN START | | 08/11/2017 | | | | TDC | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| KAIZEN FINISH | | 10/11/2017 | | | | TEAM MEMBERS :- Amit Singh | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | BENEFITS :- | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | 1.Reduce possibility of in-house rejection during m/c setting time 2.Quality improve . 3.Moral improve | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | KAIZEN SUSTENANCE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WHY - WHY ANALYSIS :- WHY-1:-Possibility of in-house rejection during m/c setting time WHY-2:- We can't check total height after back facing operation. WHY-3:-1 st operation dia. 23.15 boring & after back facing operation during this time we can't Declamp to this comp. | | | | RESULT :-Reduce possibility of in-house rejection during m/c setting time | | | | | | WHAT TO DO:- HOW TO DO:- FREQUENCY :- One time activity | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ROOT CAUSE :-Operation sequence poor. | | | |  <p>Possibility of in-house rejection m/c setting time in nos</p> <table border="1"> <thead> <tr> <th>Time</th> <th>Rejection (nos)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>6</td> </tr> <tr> <td>After</td> <td>1</td> </tr> </tbody> </table> | | | | | | | | | | | | Time | Rejection (nos) | Before | 6 | After | 1 | | | | | | | | | | | | | | | | | | |
| Time | Rejection (nos) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Before | 6 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| After | 1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| REGISTRATION NO. & DATE :- 13.11.17 | | | | SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| REGISTERED BY :- Harish | | | | SR. NO. | | CELL | | TARGET | | RESPONSIBILITY | | STATUS | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| MANAGER'S SIGN :- Prashant verma | | | | | | All oil pump cell | | 15/12/2017 | | Prince kumar | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |