


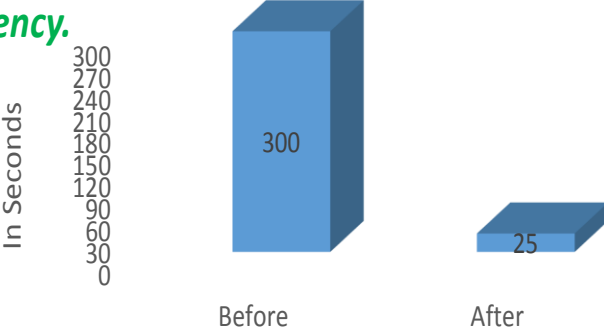


AD  IK		TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET																		
Plant : P14		TPM CIRCLE NAME :		LOSS NO./STEP																											
CELL : Tensioner		DEPT :	Quality	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M																			
CELL NAME :		A545	M/C TAGE:	Broaching			OPERATION:		Broaching																						
KAIZEN THEME :		KAIZEN IDEA :																													
To improve inspection method at A545 Plunger broaching process.		By de-skilling the inspection procedure.							BENCHMARK:		----																				
									TARGET:		-----																				
									KAIZEN START:		08.10.2018																				
									TARGET DATE:		29.10.2018																				
									KAIZEN FINISH:		05.11.2018																				
PROBLEM PRESENT STATUS :		COUNTERMEASURE:							TEAM MEMBERS:																						
A545 Plunger broaching thickness confirmed with dig. Micrometer with a part tolerance of 0.025 mm need skill operator for measurement. And Inspection Time also More.		To provide attribute gauge at Plunger broaching process to confirm the broaching thickness without any difficulty and with zero inspection error. With increased efficiency.							Yogesh		Tushar																				
									BENEFITS:-		- Rejection and rework will eliminated																				
WHY-WHY ANALYSIS:		BEFORE			AFTER			KAIZEN SUSTAINANCE																							
Why 1 : Need skilled operator to check plunger broaching thickness as the process tolerance is 0.025 mm.								WHAT TO DO:																							
Why 2 : A545 Plunger broaching thickness measured with digital micrometer may get wrong reading.								Ir-reversible kaizen																							
Why 3 : Operator skill need to use of ratchet to get accurate reading.								HOW TO DO:																							
								FREQUENCY:																							
								--																							
								SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																							
								<table border="1"> <thead> <tr> <th>SR.NO.</th> <th>CELL/PRODUCT</th> <th>TDC</th> <th>RESP.</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>A663</td> <td>22.12.18</td> <td>Yogesh</td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>				SR.NO.	CELL/PRODUCT	TDC	RESP.	STATUS	1	A663	22.12.18	Yogesh											
SR.NO.	CELL/PRODUCT	TDC	RESP.	STATUS																											
1	A663	22.12.18	Yogesh																												
ROOT CAUSE		RESULTS:																													
A545 Plunger broaching thickness confirmed with dig. Micrometer with a part tolerance of 0.025 mm need skill operator for measurement. And Inspection Time also More.		<p>“ ZERO Inspection Error and Inspection Time Redused to increase efficiency.</p>  <p>In Seconds</p> <table border="1"> <tr> <td>300</td> <td>Before</td> </tr> <tr> <td>25</td> <td>After</td> </tr> </table>											300	Before	25	After															
300	Before																														
25	After																														
REGISTRATION NO.:	P14/QM/2018/23																														
DATE:	15.11.2018																														
REGISTERED BY:	Mr. Omprakash Barik																														
MANAGER SIGN:	Mr. Manju Nagendra																														
HD SCOPE INFORMATION IN OTHER PLANT																															
SR.NO.	PLANT	WHEN	WHOM	STATUS																											