													Pla	ant ·	- 15	
	TPM CIRCLE NO :-	ACTIVITY		KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET				
	TPM CIRCLE NAME :	LOSS NO. / STEP									KAIZEN N					
	DEPT :- IQA	RESULT AREA		Р	P Q DEF :- A		Α	С	D	S M			-			
CELL :-A305	CELL NAME:- Milling	MACHINE / STAGE :- Milling						0	OPERATION :- Grooving							
KAIZEN THEME: To eliminate A305 Shaft without milling found at customer end		IDEA :- Core Pin in insert depth is controlled within 0.05mm														
										BENCHMARK 01Nos.						
										TARGET0 No.KAIZEN START9.03.2016						
PROBLEM/PRESENT STATUS:- Rejection due variation in 1.2mm deep		COUNTERMEASURE:- The depth of 1.7mm inside												.4.2016		
		the c	the die varies within 0.05mm													
		For all the cavities.								TEAM MEMBERS :-						
									К	Kashinath Savanji. Ganesh Padwalkar,						
									E	BENEFITS :-						
										1)No production loss						
										2) No Supplier Rejection						
										3)No customer complaint						
BEFORE									KAIZEN SUSTENANCE							
		1	AFTER								WHAT TO DO :- Add point in QM sheet					
WHY - WHY ANALYSIS :-		RESULT :-														
		IL.SO								HOW TO DO : Daily checking in QM						
Why 1 –A 305 Shaft without groove found at										FREQUENCY – Daily						
customer end																
Why 2 –Defective part skipped from																
inspection																
Why 3 – Not arrest ir	n existing process															
Why 4 –No poka-yoke for groove checking.									-							
										COST INCURRED FOR MAKING KAIZEN						
	1								MATERIAL COST LABOUR COST TOTAL C IN RS IN RS IN RS							
ROOT CAUSE : No poka-yoke for groove checking.			4						\vdash	IN RS IN RS IN RS						
REGISTRATION NO&DATE: 903.2016										SCOPE & PLAN FOR HORIZONTAL I						
REGISTERED BY :Kashinath Savanji									NC		LL	TARGET	RESPONSIB	ILIIY	STATUS	
									_							
MANAGER'S SIGN :- Ganes	sh Padwalkar															