

CELL:- PRV **CELL NAME:-** A225 PRV **MACHINE / STAGE :-** CNC M/C **OPERATION :-** Turning & Gas Nitro carburizing

KAIZEN THEME : To eliminate A225 PRV OD o/s after Nitro carburizing spec.11.4-0.03 actual 11.43 . **IDEA :-** Growth pattern to be studied & size to be finalize.

Problem present status :-A225 PRV OD oversize spec 11.4-0.03 mm actual observed 11.43 mm .

- COUNTERMEASURE:-**
1. Semi finished dimension to be change from $\varnothing 11.4 +0.010$ to $\varnothing 11.4 -0.010$
 2. Semi finished drawing to be confirm.
 3. Ring gauge to be prepared $\varnothing 11.4 -0.010$

BENCHMARK	200 no's
TARGET	0 no
KAIZEN START	25.02.2016
TDC	12.03.2016
KAIZEN FINISH	

TEAM MEMBERS : Ganesh Gaikwad, Sachin Yeole, Ganesh Padwalkar ,Santosh wachchaure ,Ashish ,Sachin kadnar , Nana.

Machining stage $\varnothing 11.4 +0.010$	After nitro carburizing $\varnothing 11.4-0.03$	Growth
11.405-11.412	11.455-11.461	0.049-0.050

Machining stage $\varnothing 11.4 -0.010$	After nitro carburizing $\varnothing 11.4-0.03$	Growth
11.394-11.398	11.420-11.428	0.023

Before

After

BENEFITS :-

1) In-house rework & rejection eliminated.

WHY - WHY ANALYSIS :-

Why1 :- A225 PRV od o/s.

Why2 :- After gas nitro carburizing part get oversize .

Why3 :-No size calculated before nit riding .

RESULT :-

Currently check 100 % with ring gauge

KAIZEN SUSTENANCE

WHAT TO DO:- Check point added in daily audit check sheet .

HOW TO DO:- Check size with ring gauge.

FREQUENCY :- Daily .

ROOT CAUSE :- No size calculated before nit riding .

REGISTRATION NO. & DATE : 25.02.2016

REGISTERED BY :- Ashish Jagtap

MANAGER'S SIGN :- Sunil Kinkar

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	Not Applicable			