ADVIK P1 Immunicate R0.1-3 Activity Immunicate R0.1-3 TPM CIRCLE RVME :: DEPT :: Q.A COSS 00.7 STEP DEPT :: Q.A P Q orrestance C CELL ::-A345RotdprCELL NAME :: Rotor Grinding MACHINE / STAGE :- Rimaco / 50 IDEA :: Surface Bed to be Grinding & Taper to be for thickness toper (Spec 30- 0.02 mm & actual observed by 29.985-29.975) IDEA :: Surface Bed to be Grinding & Taper to be for thickness toper (Spec 30- 0.02 mm & actual observed by 29.985-29.975) IDEA :: Surface Bed to be Grinding done & taper maintain in 0.005 mm.2) Defined part loading area on bed. WIDELY/DEEPLY:- PROBLEM / PRESENT STATUS :- A345 Outer & inner rotor thickness toper (Spec 30-0.02 mm & actual observed by 29.985 - 29.975) OUTTERMEASURE:- 1) Surface bed grinding done & taper maintain in 0.005 mm.2) Defined part loading area on bed. WHY - WHY ANALYSIS :- Why 1 :- A345 Outer & inner rotor thickness toper spec 30-0.02 mm & actual observed by 29.985 - 29.975) RESULT :- Why 2 :- During grinding on surface grinder excess material remove from one side of face. 700 - 610 - 500 - 100 - 100 610 - 600 - 100 - 100	от	DM	E&T		en idi			
KAIZEN THEME :- To avoid A345 Outer & inner rotor thickness taper IDEA :- Surface Bed to be Grinding & Taper to be . WIDELY/DEEPLY:- COUNTERMEASURE:- 1) Surface bed grinding done & taper maintain in 0.005 mm.2) Defined part loading area on bed. PROBLEM / PRESENT STATUS :-A345 Outer & inner rotor thickness taper (Spec 30-0.02 mm & actual observed by 29.985 -29.975) IDEA :- Surface Bed to be Grinding & Taper to be . Image: BEFORE Image: BEFORE Image: BEFORE WHY - WHY ANALYSIS :- Why 1 :- A345 Outer & inner rotor thickness taper spec 30-002 mm & actual observed by 29.985 -29.975) Image: BEFORE WHY - WHY ANALYSIS :- Why 1 :- A345 Outer & inner rotor thickness taper spec 30-002 mm & actual observed by 29.985 -29.975) RESULT :- Why 2 :- During grinding on surface grinder excess material remove from one side of face. f00 - 00 - 00 - 00 - 00 - 00 - 00 - 00 -	D	S	м					
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WIDELY/DEEPLY:- PROBLEM / PRESENT STATUS :- A345 Outer & inner rotor thickness taper (Spec 30-0.02 mm & actual observed by 29.985 - 29.975) Image: Spec 30-0.02 mm & actual observed BEFORE WHY - WHY ANALYSIS :- Why 1 :- A345 Outer & inner rotor thickness taper spec 30-0.02 mm & actual observed by 29.985 - 29.975) WHY - WHY ANALYSIS :- Why 1 :- A345 Outer & inner rotor thickness taper spec 30-0.02 mm & actual observed by 29.985 - 29.975) Why 2 :- During grinding on surface grinder excess material remove from one side of face. Why 3 :- 0.030 mm taper observed in surface grinder excess material remove from one side of face. Why 3 :- 0.030 mm taper observed in surface grinder excess material remove from one side of face.		emoved. BENCHMARK 610 Nos.						
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PROBLEM / PRESENT STATUS :-A345 OUTER & inner rotor thickness taper (Spec 30-0.02 mm & actual observed by 29.985 -29.975) Image: Spec 30-0.02 mm & actual observed by 29.985 -29.975) BEFORE WHY - WHY ANALYSIS :- Why 1 :- A345 Outer & inner rotor thickness taper spec 30-0.02 mm & actual observed by 29.985 -29.975) Why 2 :- During grinding on surface grinder excess material remove from one side of face. Why 3 :- 0.030 mm taper observed in surface grinding bed.	K	KAIZE	EN S	TART		1.2015)	
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WHY - WHY ANALYSIS :- RESULT :- Why 1 :- A345 Outer & inner rotor thickness actual observed by 29.985 -29.975) 700 - Why 2 :- During grinding on surface grinder 600 - excess material remove from one side of face. 400 - Why 3 :- 0.030 mm taper observed in surface 300 - grinding bed. 200 -								
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winy 2Doining grinding on solucce grinderexcess material remove from one side of face.500 -Why 3 : - 0.030 mm taper observed in surface300 -grinding bed.200 -		FREQUENCY : Once in week						
Why 3: - 0.030 mm taper observed in surface grinding bed. 300 - 20								
		COST INCURRED FOR MAKING KAIZEN						
	MA	ATERIA IN F			UR COST TOTAL COST N RS IN RS			
ROOT CAUSE- :-0.030 mm taper observed in surface	-	SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT						
Before After After								
REGISTERED BY :- Ashish Jagtap	NO.).				-		
MANAGER'S SIGN :- Sunil kinkar	1		nding cell	29.01.15	Aji devo		Complete d	