

**TPM CIRCLE NO :-** 01  
**TPM CIRCLE NAME:** Achiever  
**DEPT :-** MACHINE SHOP

**ACTIVITY**  
**LOSS NO. / STEP**  
**RESULT AREA**

KK	QM	PM	JH	SHE	OT	DM	E&T
P	Q	A		C	D	S	M

**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.11.45-0.03 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  $\varnothing 11.4 -0.010$

<b>BENCHMARK</b>	250 no's
<b>TARGET</b>	0 no
<b>KAIZEN START</b>	25.03.2016
<b>TDC</b>	12.05.2016
<b>KAIZEN FINISH</b>	

**TEAM MEMBERS :** Ganesh Gaikwad, Sachin Yeole, Santosh Wakchaure ,Ashish , Sachin Kadnar

Machining stage $\varnothing 11.40 +0.010$	After nitro carburizing $\varnothing 11.45 -0.03$	Growth
11.405-11.412	11.455-11.461	0.049-0.050

Machining stage $\varnothing 11.4 -0.010$	After nitro carburizing $\varnothing 11.45 -0.03$	Growth
11.394-11.398	11.420-11.428	0.023

Before

After

**BENEFITS :-**

1) In-house rework & rejection will be eliminate.

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

**Why1 :-** A225 PRV od o/s.

**Why2 :-** After gas nitro carburizing part get oversize . ( growth observed upto 0.050 mm)

**Why3 :-**No size calculated for machining before Nitro carburizing

**ROOT CAUSE :-** No size calculated for machining before Nitro carburizing

**REGISTRATION NO. & DATE :** 25.03.2016

**REGISTERED BY :-** Ashish Jagtap

**MANAGER'S SIGN :-** Sunil Kinkar

**RESULT :-**

Material send for HT. Lot is under monitoring.

**WHAT TO DO:-** Drawing to be change

**HOW TO DO:-**

**FREQUENCY :-**

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	Not Applicable			