
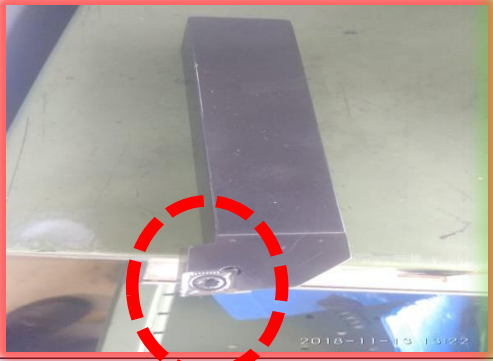
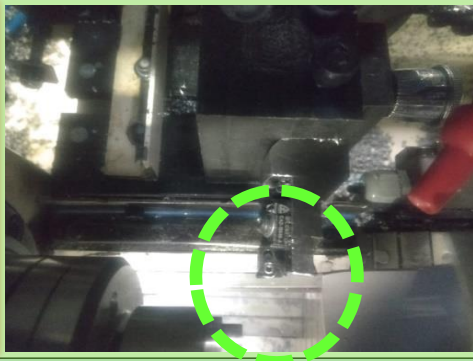


AD  IK		TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET
		TPM CIRCLE NAME :		LOSS NO./STEP									
Plant : P14		DEPT :	Production	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M	
CELL :	A545/A663	CELL NAME :	TENSIONER		M/C STAGE:	SPM			OPERATION:			Facing	
KAIZEN THEME :		KAIZEN IDEA :											
Surface finish reduction		Material Identifier plate has to be mounted in equal level to stand						BENCHMARK:		RA3.4			
		TARGET:		RA 1.2			KAIZEN START:		05.10.18				
PROBLEM PRESENT STATUS :		COUNTERMEASURE:						TARGET DATE:		08.10.18			
Surface finish found Ra 3.4 against Ra 1.6		Shape and nose radius of insert and tool holder changed from CCGT 0.8mm to TCGT 0.8mm and tool holder's angle was changed manually with shim						KAIZEN FINISH:		08.10.18			
		TEAM MEMBERS:				Mr.Manas		Mr.Mohan GS					
		BENEFITS:-											
WHY-WHY ANALYSIS:		BEFORE			AFTER			KAIZEN SUSTAINANCE					
Why1:- Surface finish Ra is more Why2:- Insert and Tool holder shape was not ok Why3:- Holder angle was not ok								WHAT TO DO:					It reversible Kaizen..
		HOW TO DO: -----											
		FREQUENCY:											One time activity
		SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT											
SR. NO	CELL/ PRODUCT	TDC	RESP.	STATUS									
1	A545	08.10.18	Prod	OPEN									
ROOT CAUSE		RESULTS:											
Tool holder shape was not ok		Surface finish reduced from Ra3.4 to Ra 1.2											
REGISTRATION NO.:		P14/KK/2018/41											
DATE:		15.11.2018											
REGISTERED BY:		Mr. Omprakash Barik											
MANAGER SIGN:		Mr. Manas Kumar Dev											
HD SCOPE INFORMATION IN OTHER PLANT													
SR.NO.	PLANT	WHEN	WHOM	STATUS									