

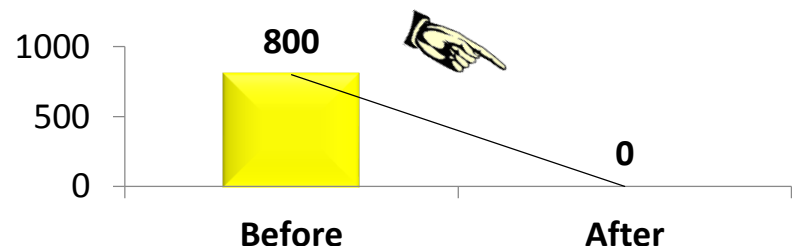


AD ▼ IK	TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET
PLANT:P14	TPM CIRCLE NAME :	LOSS NO./STEP									
	DEPT :	Quality Assurance	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M
CELL :A662	CELL NAME :	A662 Flange ID 15mm boring	MACHINE STAGE:	CNC Turning				OPERATION:	Boring		

<b>KAIZEN THEME :</b>	<b>KAIZEN IDEA :</b>	
To Prevent the defect of A662 Flange Dia 15mm Unclean	There should be no play	BENCHMARK: 4500 nos. TARGET:00 KAIZEN START: 12/08/2019

<b>PROBLEM PRESENT STATUS</b>	<b>COUNTERMEASURE:</b>	<b>TARGET DATE: 20/08/2019</b>
800 no's A662 flange Dia 15mm bore unclean	Reduced the clearance between part locating slot to locating Pin by increasing the locating pin width from 3.65mm to 3.80mm and Both locating Pins CD Defined 5.80 +/-0.05mm 2)Check Point to be add in fixture validation check sheet.	KAIZEN FINISH: 11/09/2-19

<b>WHY-WHY ANALYSIS:</b>	<b>BEFORE</b>	<b>AFTER</b>	<b>TEAM MEMBERS:</b>
<p><b>Why 1</b> :Material stock not available for boring at one side.</p> <p><b>Why2</b> :While loading part shifted at one side.</p> <p><b>Why3</b> : The clearance between part locating slot and locating pin was more 0.20mm.</p> <p><b>Why4</b> : Locating Pin width observed 0.20(actual:-3.65mm) mm under size.</p> <p><b>Why5</b> :Locating Pin width and CD not defined.</p>			Mr. Datta.Pandre
			Mr. Manukar
			<b>KAIZEN SUSTAINANCE</b>
			<b>WHAT TO DO:</b> To revise the fixture drawing and check point for PE added in DDIS
			<b>HOW TO DO:</b> As per revised drawing & DDIS
<b>FREQUENCY:</b> Each occurrence			

<b>ROOT CAUSE:-</b>	<b>RESULTS: Rejection Trend</b>	<b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b>										
Locating Pin width and CD not defined.		<table border="1"> <thead> <tr> <th>SR.NO.</th> <th>CELL/ PRODUCT</th> <th>TDC</th> <th>RESP.</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>A657 line 2</td> <td>05/10/19</td> <td>Madhu</td> <td>Inprocess</td> </tr> </tbody> </table>	SR.NO.	CELL/ PRODUCT	TDC	RESP.	STATUS	1	A657 line 2	05/10/19	Madhu	Inprocess
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1		A657 line 2	05/10/19	Madhu	Inprocess							
REGISTRATION NO.:P14/QM/2019/09		<b>HD SCOPE INFORMATION IN OTHER PLANT</b>										
DATE:		<table border="1"> <thead> <tr> <th>SR.NO.</th> <th>PLANT</th> <th>WHEN</th> <th>WHOM</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	SR.NO.	PLANT	WHEN	WHOM	STATUS					
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REGISTERED BY: Manash KP												
MANGERS SIGN:												

