



TPM CIRCLE NO :-		ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET
TPM CIRCLE NAME :		LOSS NO. / STEP									
DEPT :- IQA		RESULT AREA	P	Q	DEF:- A		C	D	S	M	
CELL :-A305	CELL NAME:- Milling	MACHINE / STAGE :- Milling	OPERATION :- Grooving								
<b>KAIZEN THEME:</b> To eliminate A305 Shaft without milling found at customer end		<b>IDEA :-</b> Core Pin in insert depth is controlled within 0.05mm									
<b>PROBLEM/PRESENT STATUS:-</b> Rejection due variation in 1.2mm deep 		<b>COUNTERMEASURE:-</b> The depth of 1.7mm inside the die varies within 0.05mm For all the cavities. 									
<b>WHY - WHY ANALYSIS :-</b> <b>Why 1</b> –A 305 Shaft without groove found at customer end <b>Why 2</b> –Defective part skipped from inspection <b>Why 3</b> – Not arrest in existing process <b>Why 4</b> –No poka-yoke for groove checking.		<b>RESULT :-</b>									
<b>ROOT CAUSE :</b> No poka-yoke for groove checking.		<b>WHAT TO DO :-</b> Add point in QM sheet <b>HOW TO DO :</b> Daily checking in QM <b>FREQUENCY –</b> Daily									
<b>REGISTRATION NO&amp;DATE:</b> 9..03.2016		<b>COST INCURRED FOR MAKING KAIZEN</b>									
<b>REGISTERED BY :</b> Kashinath Savanji		<b>MATERIAL COST IN RS</b>			<b>LABOUR COST IN RS</b>			<b>TOTAL COST IN RS</b>			
<b>MANAGER'S SIGN :-</b> Ganesh Padwalkar		-----			-----			-----			
<b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b>											
Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS							