

TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :-	LOSS NO. / STEP	10							
DEPT :-QA-9	RESULT AREA	P	Q	DEF :- A/B/C	C	D	S	M	

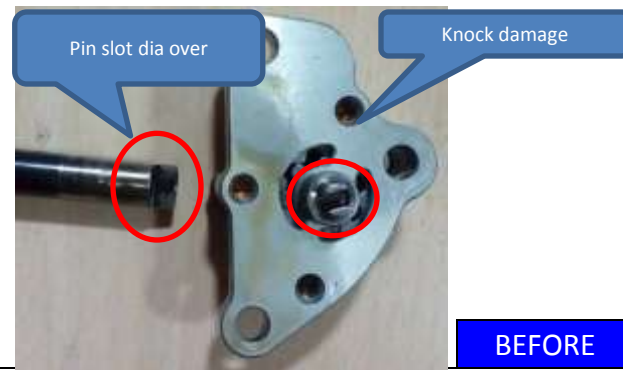
KAIZEN NO:-

CELL	CELL NAME:-	MACHINE /STAGE-FLOW RATE TESTING MACHINE	OPERATION :-FLOW RATE TEST
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KAIZEN THEME– To improve Quality.

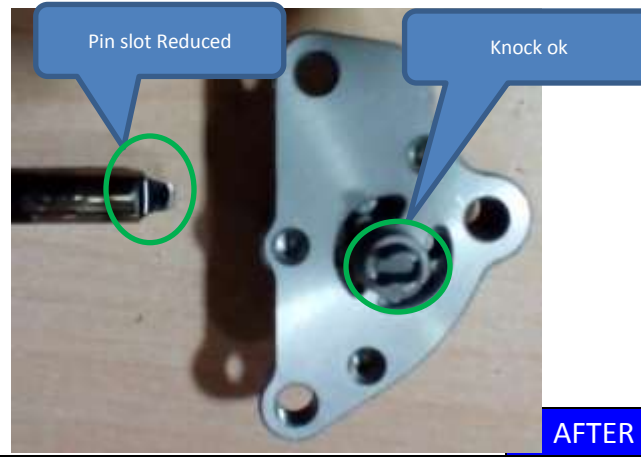
WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS- Knock damage at the time of flow rate test. Pin slot dia 10.50mm more than A316 shaft dia 6.8mm. So that pin rubbing at the knock.



IDEA :-Pin slot Reduced.

COUNTERMEASUR- Pin slot dia reduced from 10.50mm to 6.50mm.



BENCHMARK	04
TARGET	0
KAIZEN START	12-12-2016
KAIZEN FINISH	13-12-2016

TEAM MEMBERS :-SANJEEV,AKASHPAL

BENEFITS :-IMPROVE QUALITY

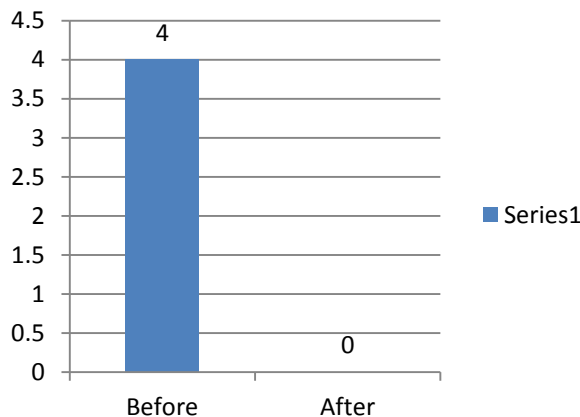
KAIZEN SUSTENANCE

WHY-WHY ANALYSIS :-

- WHY 1:-Knock damage(Burr Fold).
- WHY 2:-Pin slot Rubbing at the knock.
- WHY 3:-Pin slot dia (10.50mm) more then A316 Shaft dia (6.8mm).

ROOT CAUSE :-Pin slot dia over.

RESULT :-OK



WHAT TO DO :-REDUCED PIN SLOT

HOW TO DO –GRINDING

FREQUENCY :-ONE TIME ACTIVITY

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTRATION NO&DATE:-

REGISTERED BY :-

MANAGER'S SIGN :-

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
	A316			