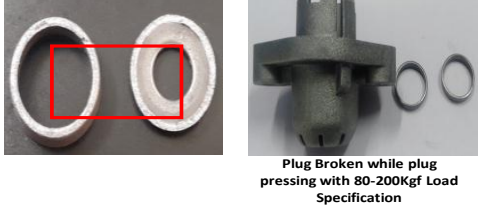


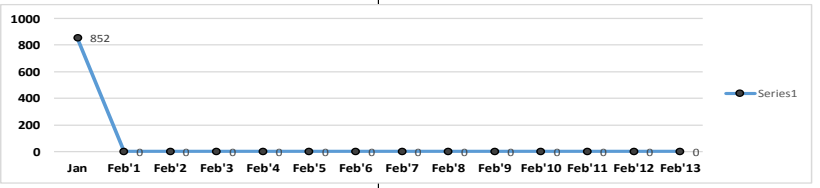


ADVIK Passionately Innovative	TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET																				
	TPM CIRCLE NAME :-	Passionately innovative		LOSS NO./STEP																												
CELL : A668 / 06M	DEPT :	Process Quality	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M																					
CELL NAME :	TENSIONER ASSY	MACHINE STAGE:	PLUG PRESSING	OPERATION:	BODY PLUG PRESS																											
KAIZEN THEME :	KAIZEN IDEA : To prevent plug cut during plug pressing station																															
PROBLEM PRESENT STATUS :	COUNTERMEASURE: Occurrence Side :- Tool corner radius specification to be standardized Detection side :- Tool life to be validated and freezed																															
During plug press, Plug corner getting fracture leads to crack 	Occurrence Side :- 1) Tool corner radius specification standardized (Spec :- 0.1 ~ 0.3) revised ,hardness in mean 2) Excess power stroke to be controlled by providing step for approach stroke impact on corner radius 3) Body ID Ovality to be controlled and maintain in Mean 4) Body ID chamfer inline with A157 body id 5) Load validation to be done 6) Plug squeezing to be arreted by modifying by Locator OD 13.05mm 7) locator OD bottom should be maintain 17.25+0.02mm 8) 17.30 to 17.40mm dia to be maintain at USL & Target Date : 26-01-2020			Detection Side :- 1) Tool history card provided to fix the tool life by taking average tool change 2) Tool change frequency to be added in PCP 3) Tool corner radius to be updated in Tool PM check sheet 4) Auto Tool change alarm in Plug pressing station 5) Revised drawing to be controlled and absolute to be scrapped 6) Plug Drawing to maintain R1 max corner radius 7) PPG to be provide to check After plug press dia 8) PPG to be provided to bore body bore ID 9) Drawing to be revised, like angle 2 dgreee, step, draft, concentric, roundness, finish, material. 10) Pressing tool interferenace to be discuss with Rnd Target Date : 26-01-2020			BENCHMARK: 852 TARGET: 0 KAIZEN START: 27-12-2019 TARGET DATE: 26-01-2020 KAIZEN FINISH: 26-01-2020 TEAM MEMBERS: Dashrath Harisha MC Pradeep.V BENEFITS:- To eliminate rejection % & NAV																									
WHY-WHY ANALYSIS: Occurrence Side :- Why 1 Plug corner getting fracture leads to crack Why 2 Plug pressing tool shrap corner formed Why 3 Tool corner radius wornout Why 4 Tool corner radius & tool clearance not Detection Side :- Why 1 Tool change frequency not followed Why 2 Tool life not freezed since in NPD initial stage	BEFORE (Occurrence side Photo) 		AFTER (Occurrence side Photo) 		KAIZEN SUSTAINANCE WHAT TO DO: Tool change as per frequency HOW TO DO: as per the WE FREQUENCY: Daily shift start																											
ROOT CAUSE:- Occurrence Side :- Tool corner radius & tool clearance not standardized in drawing Detection Side:- Tool life not freezed since in NPD initial stage	BEFORE (Detction side Photo) Not available		AFTER (Detction side Photo) Tool change frequency to be added in PCP Tool corner radius to be updated in Tool PM check sheet Auto Tool change alarm in Plug pressing station Revised drawing to be controlled and absolute to be		SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT <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></td> <td></td> <td></td> <td></td> <td>Completed</td> </tr> </tbody> </table> HD SCOPE INFORMATION IN OTHER PLANT <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.	CELL/PRODUCT	TDC	RESP.	STATUS					Completed	SR.NO.	PLANT	WHEN	WHOM	STATUS					
SR.NO.	CELL/PRODUCT	TDC	RESP.	STATUS																												
				Completed																												
SR.NO.	PLANT	WHEN	WHOM	STATUS																												
REGISTRATION NO.: DATE: 26-01-2020 REGISTERED BY: Dashrath MANGERS SIGN: Karthikeyan.S	RESULTS: Before:- Rejection Quantity :- 852 number in the month of January (NPD MP in the month of january) 		After:-		MP WORTHY KAIZEN: YES/NO MP REGISTRATION NO.: KAKATORA SHEET APPLICABLE: YES/NO KAKATORA SHEET SR. NO																											
AHPL/QMS/FR/09/E, Rev. No.:04, Rev. Date:11.07.2019																																

Note: In Results the effectiveness of action after C/m taken to be shown in day wise format.