

“What a Person’s mind can conceive & believe, it can achieve!”



Sri Padhmam
Consultancy & Training



Share & Care
February 2018



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www.sripadhmam.com

Contents Shared & Cared this month...

- Top Performers from the companies on various workshops
- Statistical tools : A close look
- How to Improve Cpk
- Thought for the month
- Career growth : An article (HR- SIDE)
- Public Program on Automotive QMS – IATF 16949:2016
- Sri Padhmam e-Learning
- Feedback on Public Program

Happy learning!

A V Manivannan
Principal Consultant & Trainer
Sri Padhmam Consultancy & Training



Mr. Kiran R &

Mr. Sivagnanam V



Mr. Kamalesh Krishna of We two engg pvt ltd,

Mr. Bala Chandar J of MRP &

Mr. Guruprakash G of We two engg.pvt ltd



Mr. Sathish Kumar N,

Mr. Suresh Kumar &

Mr. Naresh S



Advanced Product Quality Planning (APQP) & Product Part Approval Process (PPAP)

Coordinated by: Mr. Maeshwaran & Team



**Mr. Pushparaj K,
Mr. Baranitharan,
Mr. Hemakumar G,
Mr. Phanindra P &
Mr. Muthu Raman R**



#	Name	Company	Marks Obtained out of 100
1	Mr. Ashok Sunder M	Foxconn Technology India Pvt Ltd - Chennai	96
2	Mr. Kannan D	Sundram Fasteners Limited - Chennai	96
3	Mr. Karthik K	Roop Automotive Limited - Chennai	96
4	Mr. Manikandan S	L.G. Balakrishnan & Bros Ltd - Coimbatore	96
5	Mr. Sivakumar V	Modular Auto Limited - Chennai	96
6	Mr. Sureshkumar J	L.G. Balakrishnan & Bros Ltd - Coimbatore	96

Thought For the Month !



“ To solve any problem, here are three questions to ask yourself:

First, what could I do?

Second, what could I read? and

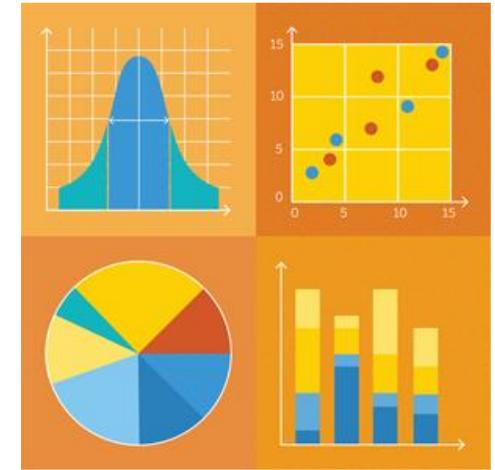
Third, who could I ask?”



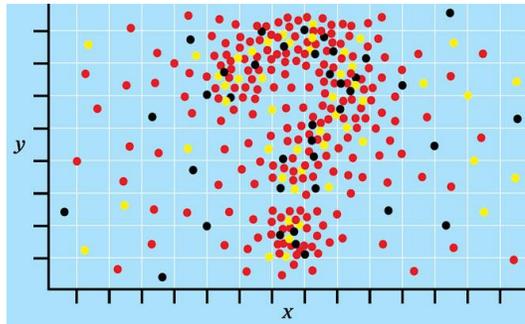
Let us think Deeply & Implement Nicely !

We are offering many Statistics based Workshops such as Statistical process control, Six Sigma awareness, Control Charts, Capability studies and Design of Experiments (Shainin).

This exercise will help those who had undergone the above mentioned programs by us !



Statistical tools : A Close look !



Special Exercise for the Practitioners of Statistics !

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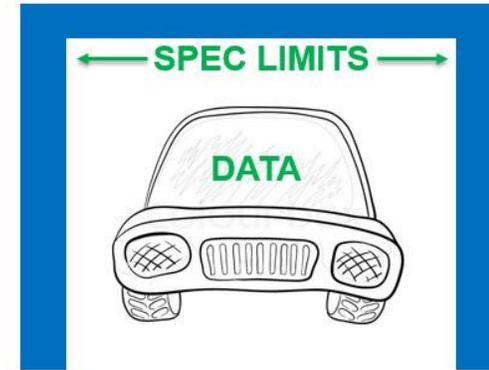


Statistical Tools : A Close look

#	Statistical Tool	Focus Point	Please select the best Option & Circle		
			Option A	Option B	Option C
1	Histogram	First focus	Spread	Location	Shape
2	Pareto Analysis	Origin from	Defence	Economics	Aeronautics
3	Component search	D / d bar Ratio	1.25 Minimum	2.5 Maximum	1.33 Minimum
4	Stratification	Time to apply	Before analysing any data	Immediately after analysing any data	Only when making the Conclusions
5	Pre-control Charts	Consideration	6 Sigma process zone	5 Sigma process zone	Specification Limits
6	Sigma Computation	Methods involved	4	2	3

#2 Compare Cp to Cpk

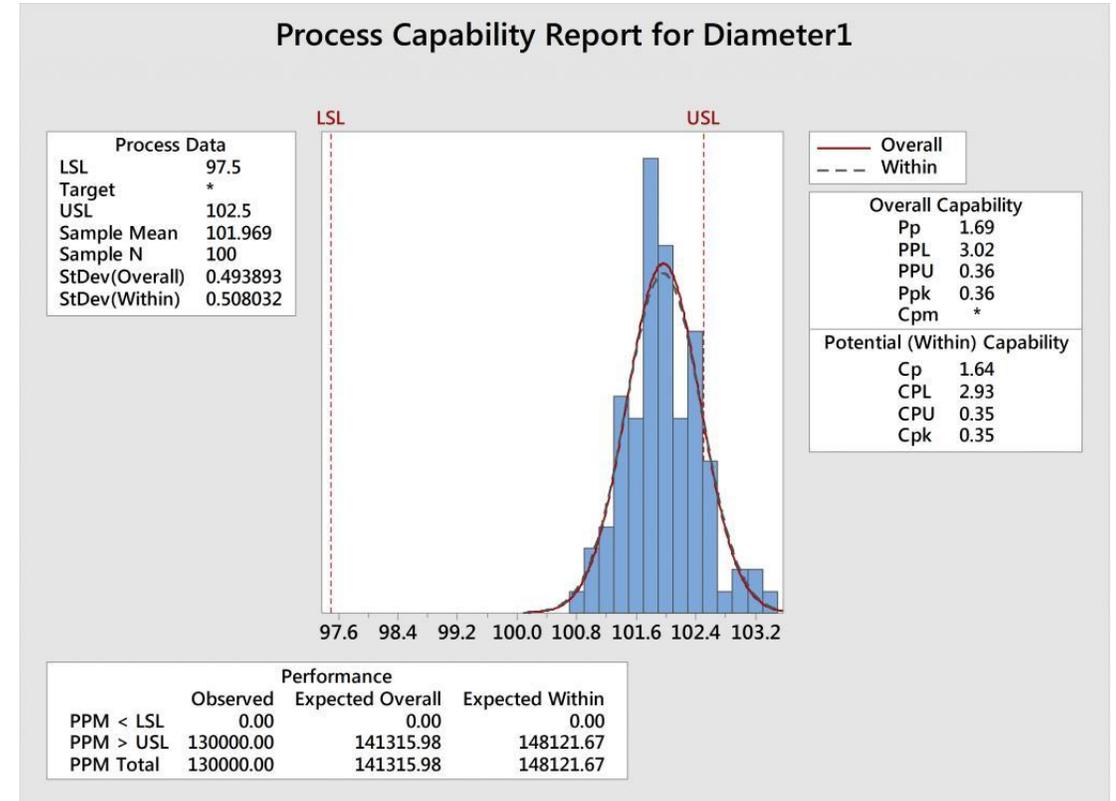
- Cp is similar to Cpk in that the smaller the number, the worse the process, and we can use the same 1.33 gold standard.
- However, the two statistics and their corresponding formulas differ in that Cp only compares the spread of the data to the tolerance width, and does *not* account for whether or not the process is actually centered between the spec limits.
- Interpreting Cp is much like asking “will my car fit in the garage?”
- where the data is your car and the spec limits are the walls of your garage.
- We’re not accounting for whether or not you’re a crappy driver and can actually drive straight and center the car—we’re just looking at whether or not your car is narrow enough to physically fit.



How to Improve Cpk

Example 1:

The analysis for Diameter1 has a C_p of 1.64, which is very good. Because C_p is good, we know the variation is acceptable—we can physically fit our car in the garage. However, C_{pk} , which does account for whether or not the process is centered, is *awful*, at only 0.35.



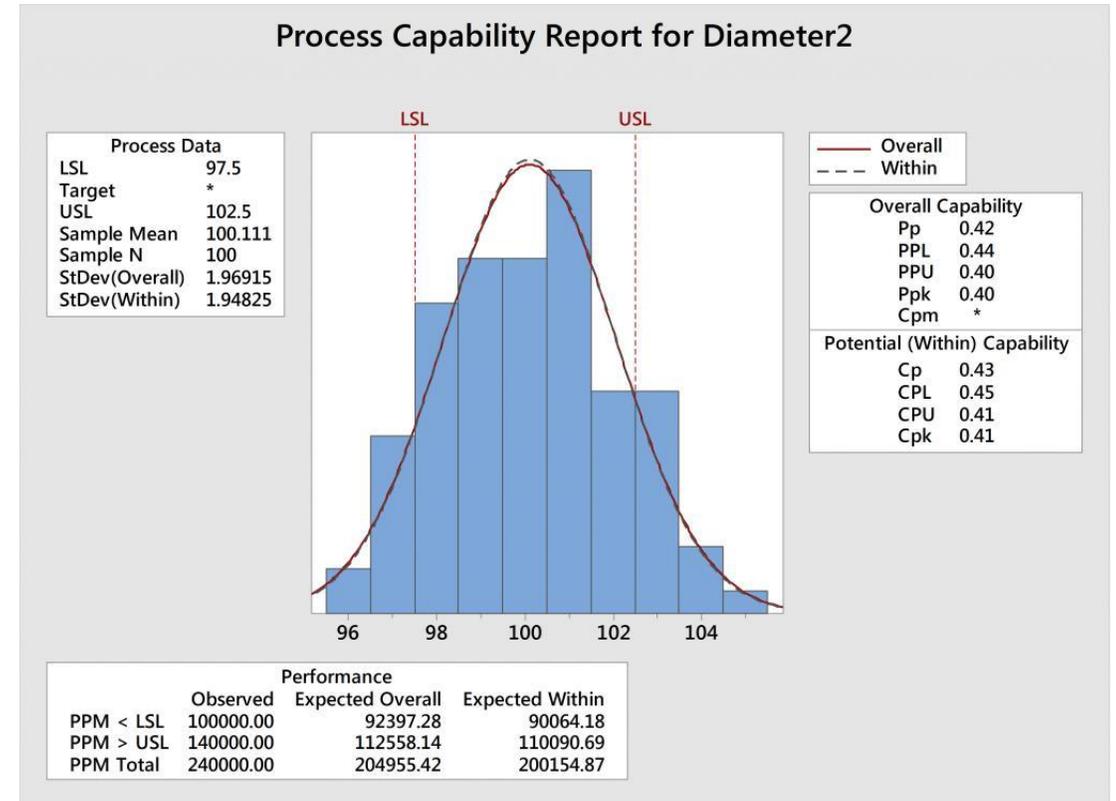
Q: How can we improve Cpk?

A: Shift the mean to center the process between the specs, without increasing the variation.

How to Improve Cpk

Example 2:

The analysis for Diameter 2 shows that $C_p = 0.43$ and $C_{pk} = 0.41$. Because C_p is bad, we know there's too much variation—our car cannot physically fit in the garage. And because the C_p and C_{pk} values are similar, this tells us that the process is fairly centered.



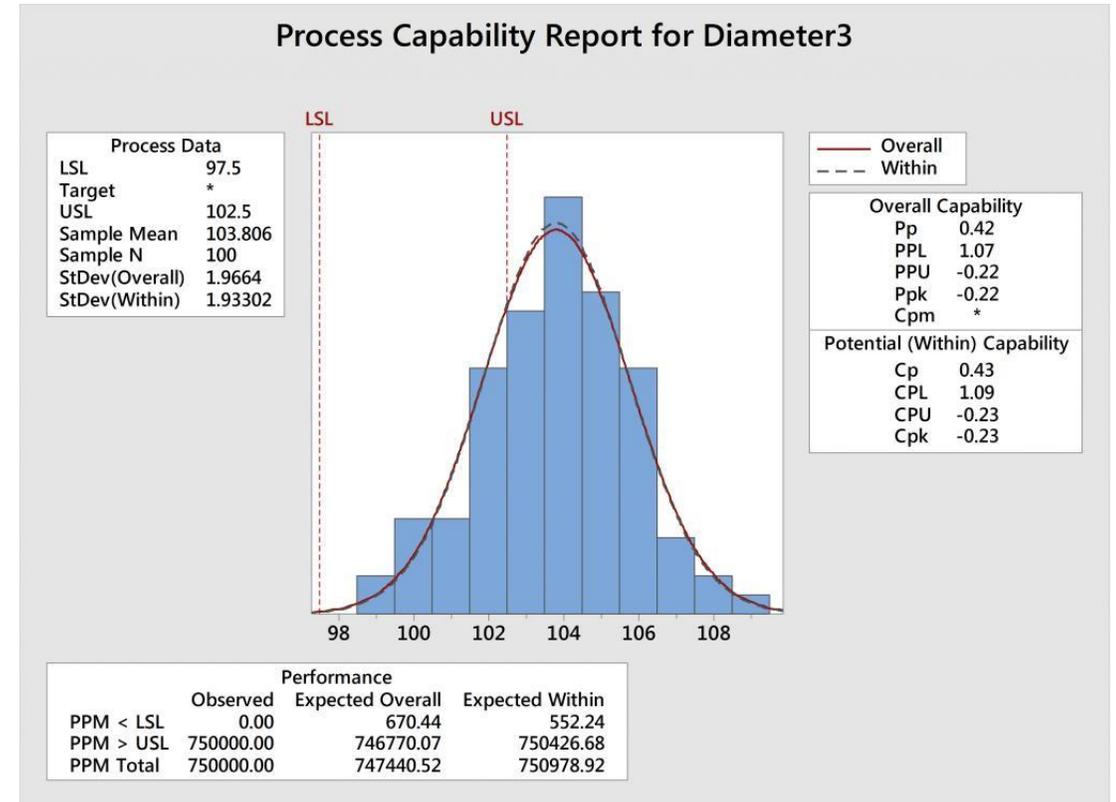
Q: How can we improve Cpk?

A: Reduce the variability, while maintaining the same average.

How to Improve Cpk

Example 3:

The analysis for Diameter 3 has a $C_p = 0.43$ and $C_{pk} = -0.23$. Because C_p is bad, we know there's too much variation. And because C_p is not even close to C_{pk} , we know that the process is also off center.



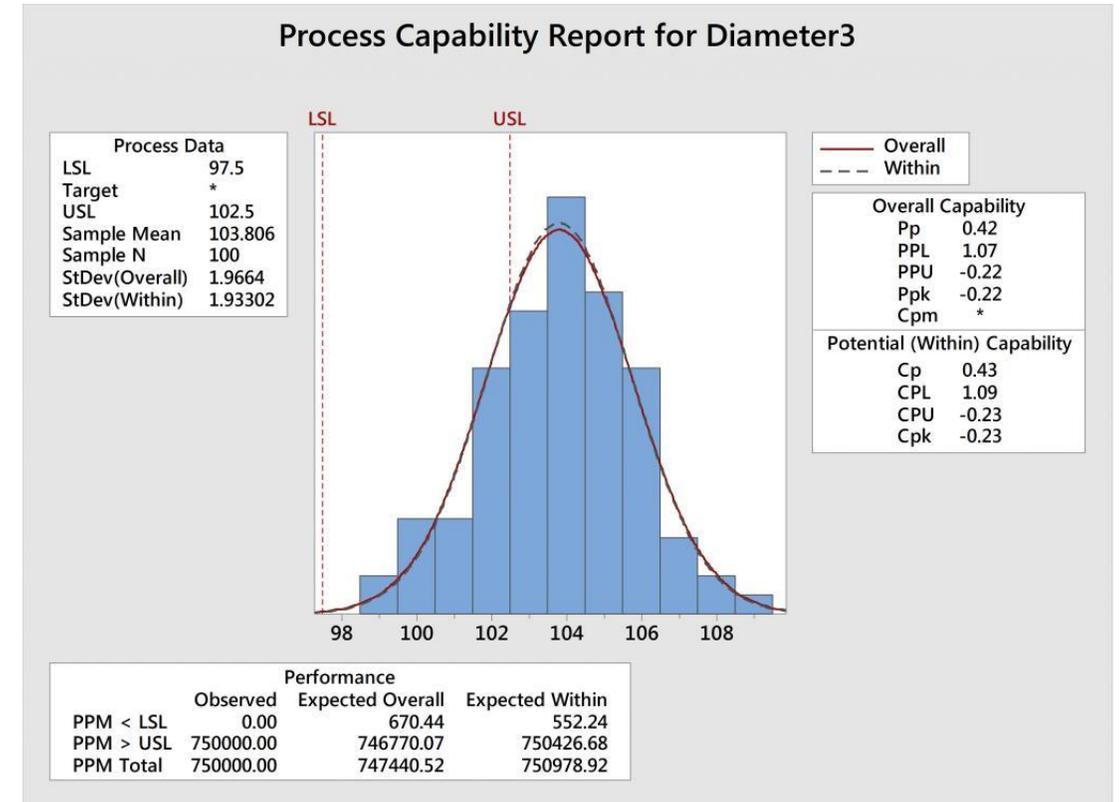
Q: How can we improve Cpk?

A: Shift the mean closer to 100 to center the process and reduce the variation.

How to Improve Cpk

Example 3:

The analysis for Diameter 3 has a $C_p = 0.43$ and $C_{pk} = -0.23$. Because C_p is bad, we know there's too much variation. And because C_p is not even close to C_{pk} , we know that the process is also off center.



Q: How can we improve Cpk?

A: Shift the mean closer to 100 to center the process and reduce the variation.

How to Improve Cpk

In summary:

	Graph	Cp vs Cpk	How to Improve Cpk?
Example 1	Histogram not centered but can physically fit between specs	Cp good but Cpk bad	Center the process
Example 2	Histogram centered but extends beyond specs	Cp and Cpk both bad but similar	Reduce the variation
Example 3	Histogram not centered and cannot physically fit between specs	Cp and Cpk both bad and similar	Center the process and reduce the variation

HR - SIDE



Direction

- ✓ When you cast the vision, you need to come behind it with concrete directions.
- ✓ Your team members can be inspired by an idea, but they become secure with direction. This is where many leaders come up short.
- ✓ They have the vision but they don't know or don't articulate what it takes to get there.
- ✓ “The value of an idea lies in the using of it,” Thomas Edison once said.
- ✓ Don't let your ideas linger indefinitely with no means of making them real.

Creativity

- ✓ When I say to offer direction, I'm not talking about step-by-step instructions.
- ✓ Chances are, after all, that you've wandered into uncharted territory.

To Reach Your Next Big Goal, Follow the 10-80-10 Rule

- ✓ Your team needs to know their destination, who is driving them at each stage, what deadlines they're expected to meet, what resources they have and what limitations (if any) you set.
- ✓ How they arrive at that end point is a different conversation.
- ✓ A project's first stage is its most creative one.
- ✓ Now is the time for unconventional thinking, for exploring every possible means of achieving the vision.
- ✓ Once you get into the heart of the project—the 80 percent—creativity might impede progress.
- ✓ But at the inception, let imaginations run wild.
- ✓ The best ideas don't just appear; they evolve. Give them wings.

Empowerment

- ✓ Leaders who insist on micromanaging will quickly find their overreach slows workflow, squelches creativity and deflates people's confidence.
- ✓ Give your team the tools they need: materials, training, research, time and money.

To Reach Your Next Big Goal, Follow the 10-80-10 Rule

- ✓ Gen. George S. Patton famously declared as he surged through France, "At the present time our chief difficulty is not the Germans, but gasoline. If they would give me enough gas, I could go all the way to Berlin." Fuel your staff, and then get out of the way.
- ✓ I have to admit: This is tough. I've learned the hard way that trying to oversee all aspects of a new project is simply too daunting, too complicated and too frustrating.
- ✓ During a project's middle phases, I transition from project manager to chief cheerleader.
- ✓ This stage is messy, filled with flops, setbacks and unanticipated detours.
- ✓ I'm there to breathe into my team's spirits and encourage them to persevere.
- ✓ So that brings us to the project's end phase, and time for you, the leader, to jump back in, full throttle.

Add your voice.

- ✓ There's a reason you are the leader.
- ✓ You've lived the hard knocks, tallied the successes, learned from the rise and fall of others.

- ✓ Give the project your unique stamp.
- ✓ Your experiences have given you the wisdom and insight to elevate the creation even higher.

Acknowledge the contributions

- ✓ Find opportunities to openly praise and publicly celebrate the work of your colleagues.
- ✓ Your acknowledgment will validate their work, fuel their growth, inspire them to offer even more to your organization—not to mention earn you additional respect as the leader.



Workshop Topic	:	Automotive QMS – IATF 16949:2016
Faculty	:	<u>A V Manivannan</u> , Principal Consultant & Trainer
Objective	:	To give a better insight on automotive QMS IATF 16949:2016 with a special focus on practical implementation on risk based thinking
Program Date & Time	:	<u>9 AM to 5 PM on 9th February 2018 (Friday) [1 day]</u>
Target Participants	:	Engineers & above - from any function

Get your Certificate after successful completion of the course

Program Fee: ~~Rs.2300/-~~ Rs.1,800/- per head (Incl. GST)

Course Deliverables

- ✓ Objective based situation analysis
- ✓ Risk based situation analysis & QMS process mapping
- ✓ Most important terms in “QMS”
- ✓ ISO/TS 16949:2009 Vs IATF 16949:2016 – A comparison on significant changes
- ✓ Automotive process approach
- ✓ Customer Specific Requirements (CSR) – A close look
- ✓ Clause linkages to core tools
- ✓ Documentation

Venue:

Hotel Chennai Deluxe

Next to Omni Bus Stop, Koyembedu,
Chennai.

Corporate offers

No. of participants

Program fee

Companies sponsoring 2 participants for the training

Rs.1,650/- per head

Companies sponsoring 3 or 5 participants for the training

Rs.1,450/- Per head

More than 5 employees need not be nominated by a company

Payment modes

Cash : Before the program begins
Cheque : Sri Padhmam Consultancy & Training
Paytm : 9962117222

NEFT / IMPS

Bank : Karnataka Bank
Branch : Nanganallur
IFSC : KARB0000170
Account # : 1702000100001101
A/c name : Sri Padhmam Consultancy & Training
A/c Type : Current A/C

Date of program:

**09-02-2018
(Friday)**

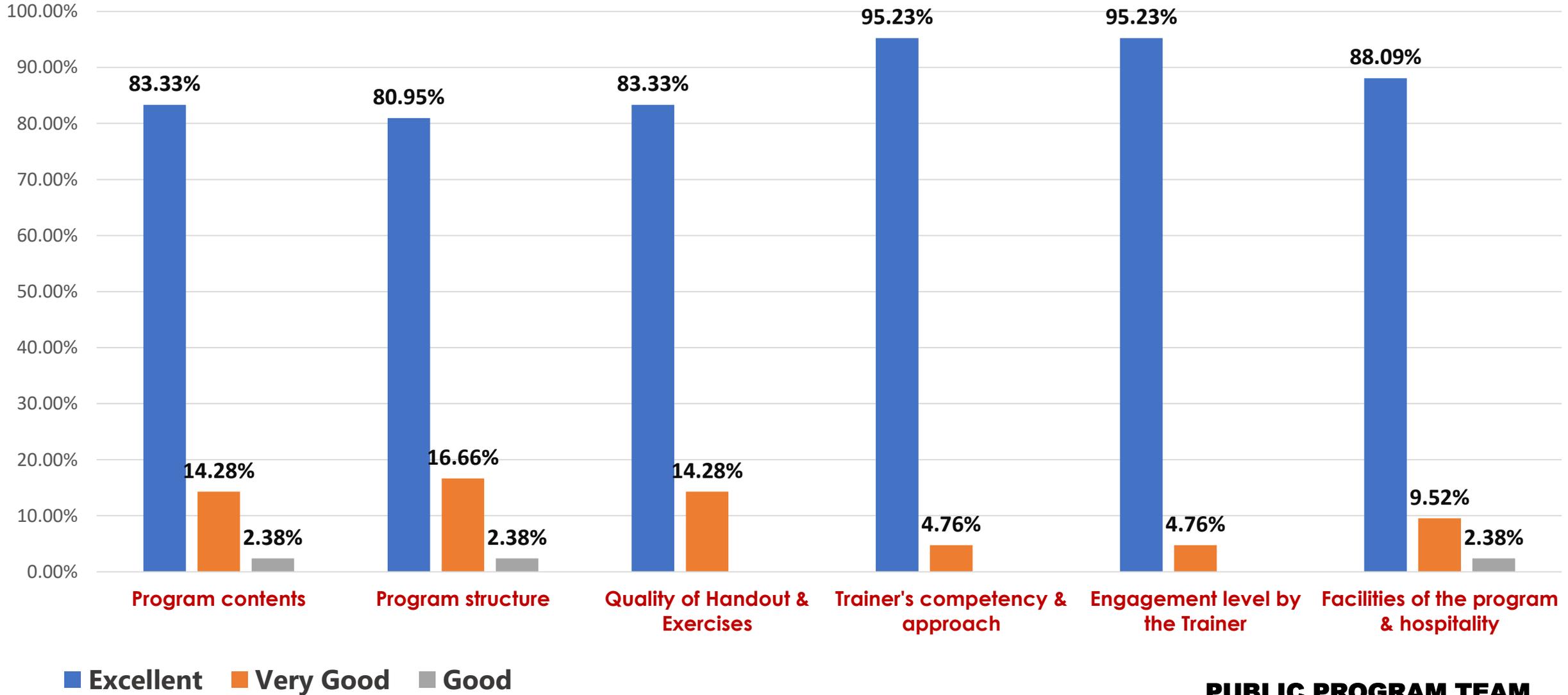


**Mr. Babu R &
Mr. Gopalakrishnan N**



Auditing the Automotive Core Tools Feedback

Total number of participation : 42



PUBLIC PROGRAM TEAM

Chennai

Test your knowledge on Automotive Core tools

#	Statements / Questions	Your response
1	<p>Concepts of variation were given by -</p> <ul style="list-style-type: none"> a) Dr. Deming b) Dr. Shewhart c) Dr. Juran 	
2	<p><u>Ppk</u> studies will target for –</p> <ul style="list-style-type: none"> a) 60 % of the Process width as 6 Sigma spread b) 50 % of the Process width as 6 Sigma spread c) 75 % of the Process width as 6 Sigma spread d) None of the above 	
3	<p>2 Popular confidence levels in MSA are –</p> <ul style="list-style-type: none"> a) 99.73 % & 99 % b) 90 % & 99.73 % c) 90 % & 95 % d) None of the above 	
4	<p>'Attribute data' is also known as Discrete data.</p> <ul style="list-style-type: none"> a) True b) False 	
5	<p>During the Bence marking, QFD must consider –</p> <ul style="list-style-type: none"> a) Products from the Competitors b) Products of the organization c) Performance results expected d) All the above e) Only a & c 	
6	<p>In attribute MSA, when the tolerance range is less –</p> <ul style="list-style-type: none"> a) Grey area will be a challenge b) Grey area will never be an issue. c) None of the above 	

**For Answer to
visit
www.spel.net.in**