

"What a Person's mind can conceive & believe, it can achieve!"

Share & Care – November 2020

By Sri Padhmam Consultancy & Training

Quality starts with 'Clarity'

Happy Quality month !



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Wall of Fame



Top Performers

Mr. K. Raja
Mr. L. Prakash
Mr. J. Venkatesan
Mr. Ramesh
Mr. Jayaram Selvam

Co-ordinated by
Ms. Surya

PFMEA (AIAG-VDA
Latest Edition)

Super Auto Forge,
Chennai

Wall of Fame



Top Performers

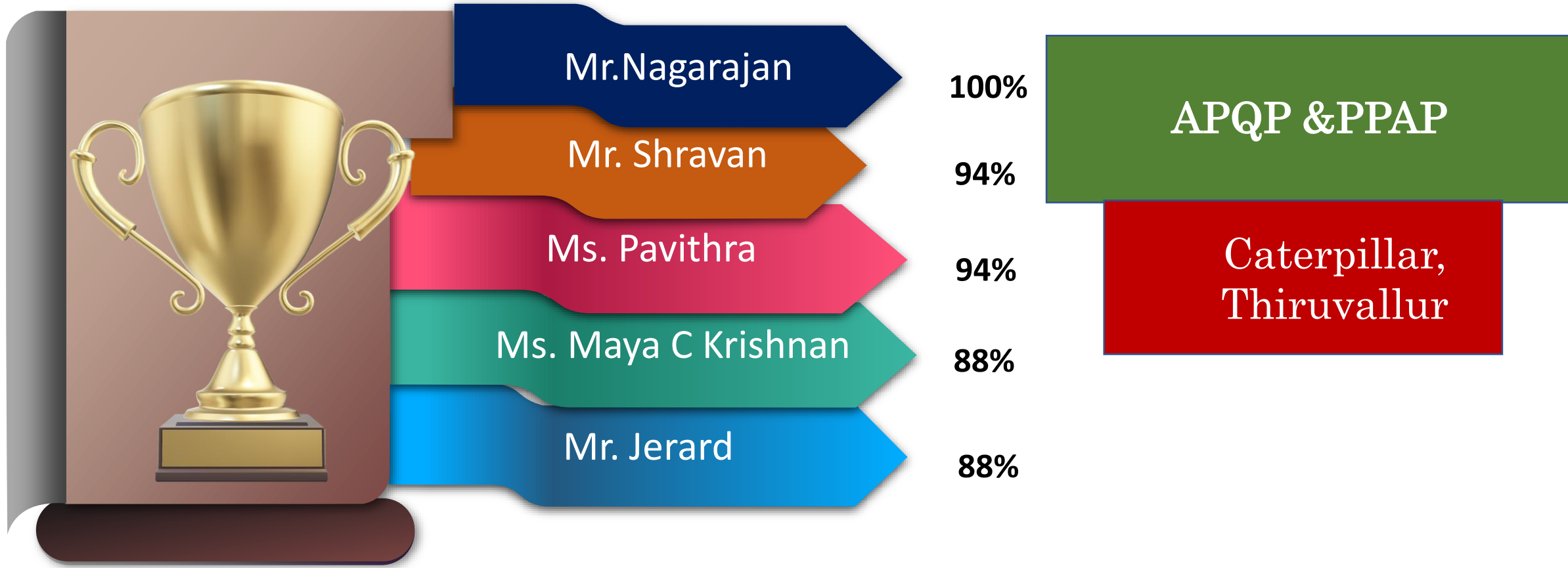
Mr. Surya
Mr. Venkatesh
Mr. Kasirajan
Mr. S. Manu Krishna
Mr. N. Mahesh
Mr. Gnanaraj

Co-ordinated by
Ms. Anuradha

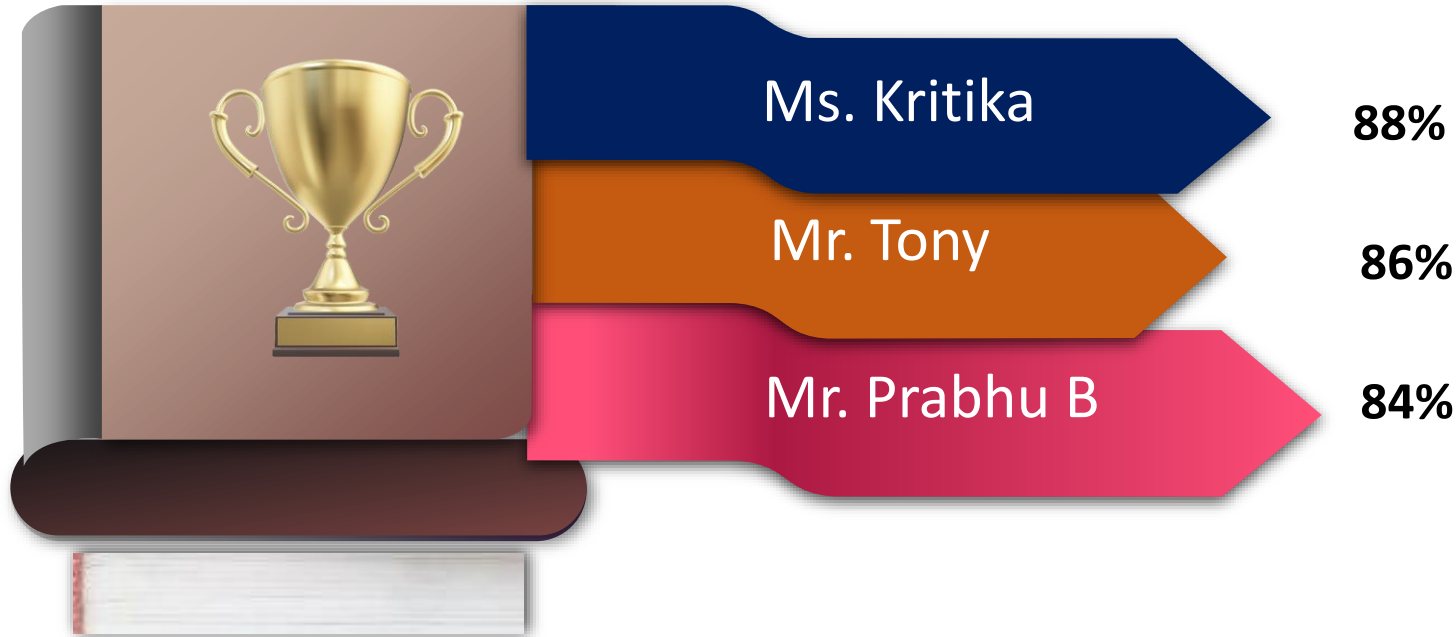
**PFMEA (AIAG-VDA
Latest Edition)**

**Besmak Components,
Chennai**

Final Qualification Test Top Scorers



Final Qualification Test Top Scorers



Process FMEA
(AIAG-VDA Latest Edition)

Sri Padhmam
Public Program

Process FMEA implementation project

Top 2 teams during October 2020 (cycle II) review

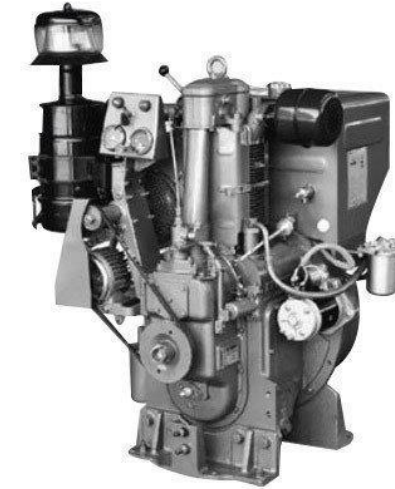


Ms. Pallavi Sapra & Team

Sponsor : Mr. Jaivir Singh

Mr. Mukesh Agarwal & Team

Sponsor : Mr. Sandeep Jaiswal



PFMEA(AIAG-VDA
Latest Edition)

Eicher Engines,
Alwar,
Rajasthan

Team Structure

Advisor	Sponsor	Team Leader
		
Manish Srivastava	Jaivir Singh	Pallavi Sapra

Member	Member	Member	Member	Member
				
Narendra Jangid	Asif Khan	Arun Kumar	Rohit Kaushik	Virender Sudhir

Editor's Desk

Dear readers!

We are hoping that all our members are staying safe ! India is now experiencing a downward trend in Covid. Pray the Almighty, for this to continue and virus is eradicated very soon !

During September, we initiated the Personality plus journey and there are 30 + participants regularly attending our sessions ! The progress and feedback are quite encouraging ! We are predominantly focusing in to the topics such as Time management, Goal setting, Planning, Communication and Leadership skills ! As such 4 leaders are contributing in this journey !

November being Quality month, guess there will be some events in your work places ! More than the celebrations, Quality comes from better technology and a Culture creation for which Top management must have a clear focus towards this !

In terms of employability, country like India is having huge scope to develop. Let it start from every one of us by acquiring new skill sets to suit ourselves for the emerging needs !

God bless all !

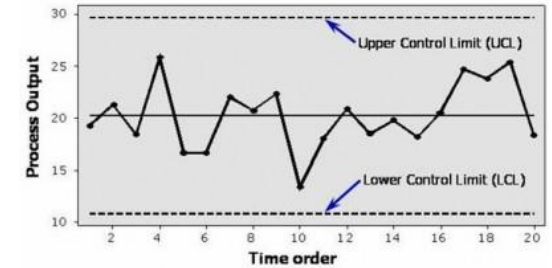


Earnestly yours ...

A V Manivannan

Statistical Process Control -Control Charts

Control charts have had a long history of use in U.S. industries and in many offshore industries as well. There are the reasons for their popularity.



- ❖ Control charts are a proven technique for improving productivity. A successful control chart program will reduce scrap and rework, which are the primary productivity killers in any operation.
- ❖ If you reduce scrap and rework, then productivity increases, cost decreases, and production capacity (measured in the number of good parts per hour) increases.
- ❖ Control charts are effective in defect prevention. The control chart helps keep the process in control, which is consistent with the “do it right the first time” philosophy.

Statistical Process Control - Control Charts

- ❖ It is never cheaper to sort out “good” units from “bad” units later on than it is to build it right initially.
- ❖ If you do not have effective process control, you are paying someone to make a nonconforming product
- ❖ Control charts prevent unnecessary process adjustment. A control chart can distinguish between background noise and abnormal variation; no other device including a human operator is as effective in making this distinction.
- ❖ If process operators adjust the process based on periodic tests unrelated to a control chart program, they will often overreact to the background noise and make unneeded adjustments.
- ❖ Such unnecessary adjustments can actually result in a deterioration of process performance. In other words, the control chart is consistent with the “if it isn’t broken, don’t fix it” philosophy.

Statistical Process Control - Control Charts

- ❖ Control charts provide diagnostic information.
- ❖ Frequently, the pattern of points on the control chart will contain information of diagnostic value to an experienced operator or engineer.
- ❖ This information allows the implementation of a change in the process that improves its performance.
- ❖ Control charts provide information about process capability.
- ❖ The control chart provides information about the value of important process parameters and their stability over time.
- ❖ This allows an estimate of process capability to be made.
- ❖ This information is of tremendous use to product and process designers.

Statistical Process Control



How to conduct Capability Studies on the parts being Supplied by our Suppliers ?

My problem is, that the lot will have a mix of Parts produced from different shifts and different machines also !

Mr. G. Subramanian M/s. Poclain Hydraulics, Pondicherry



There is no harm in computing the Sigma and Cp, Cpk ! However, we need to collect about 100 parts from different supplies (one week duration is good). Also, we need to ensure Cp & Cpk results to be 1.67 and above. Otherwise, stratify and conduct studies at suppliers' place

- AVM

Problem Solving – The Toyota Way

Approach to Larger Issues



Issue	Typical Scope	Examples	Implementation Process
Large issues, low quantity, high complexity and difficulty	Issues that effect the entire organization, plant, or department	<ul style="list-style-type: none">• Annual planning• New model launch• Interdepartmental issues• Product development	<ul style="list-style-type: none">• Management kaizen training• Cross-functional teams• Department/Plant management• Initiated and supported by plant management

Problem Solving – The Toyota Way

Approach to Medium Issues



Issue	Typical Scope	Examples	Implementation Process
Medium-size issues, moderate to high quantity, medium complexity and difficulty	Issues similar to typical Six Sigma projects or kaizen events. May affect the group or department.	<ul style="list-style-type: none">• Development of new processes• Procurement of new equipment• Significant safety, quality, production, or cost issues	<ul style="list-style-type: none">• Departmental, cross-functional team (production, maintenance, engineering)• Intergroup team (members of same group)• Quality Circles• Small teams or individuals• Supported by supervisor or department manager• Possible payment award through the suggestion program

Problem Solving – The Toyota Way

Approach to Small Issues



Issue	Typical Scope	Examples	Implementation Process
Small-size issues, virtually unlimited quantity, low difficulty to resolve	Issues that appear repeatedly throughout the day. May cause small amounts of waste every cycle. Range in opportunity from very small to fairly significant.	<ul style="list-style-type: none">• Elimination of minor issues and waste• Small continuous improvement such as 5S, visual factory, or improvement of standardized work• Andon process to stop the line and fix problems immediately	<ul style="list-style-type: none">• Primarily an individual effort• May be a joint effort or small team• Generally initiated by individuals or small teams• Supported largely by direct supervisor• Payment award and implementation through the suggestion program

Learner's Voice via Google

- I am happy to be part of the training session and truly admire the team's Communication, Professionalism, Quality and Value.
- Training program designs are very good and innovative which helps to think and grasp the concepts.
- Many thanks to AVM sir for explaining the concepts in a most practical way !

- Mr. Yokesh Anand, Sundram Fasteners (TVS), Chennai
on MSA



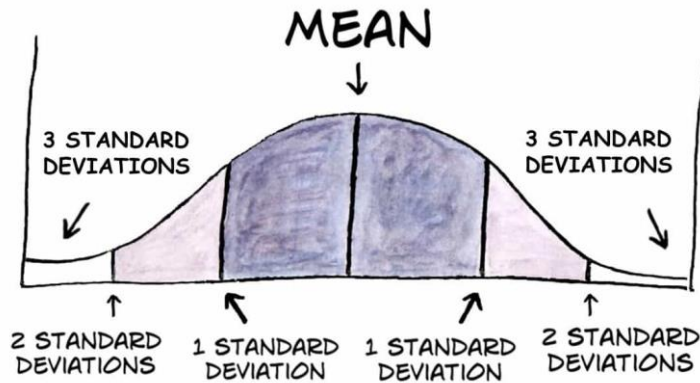
- Learning concepts with real-time examples gets registered in mind
- Training materials provided are very effective and useful.
- A great experience for me and I am sure I will apply the same in my work.

- Mr. Yuvaraj
on Process FMEA

Sample Standard deviation : Methods to compute

$\hat{\sigma}$ or S

How many methods are present to compute the
Sample Standard deviation?



Last month's question : Our view

4 methods			
1	$\sqrt{\frac{\sum (x - \bar{x})^2}{n - 1}}$	2	$\frac{\bar{R}}{d_2}$
3	$\frac{\bar{R}}{d_2^*}$	4	$\frac{R}{d_2^*}$



Lighter side....



Let us convert this tough time for our Skill development !



SPES

Very much
reasonable
cost !

Train your
Employees
with our videos



**Manufacturing of Connectors, Wire harness,
Moulded parts, Pressed components, Power cards
PCB assemblies.**

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Salient Steps to Implement Five S

