

ACT *now*

ACMA Centre for Technology

Vol 8 No. 3
December 2015



- ▶ **Gold Award Winners of 2nd ACT Case Study Competition 2015, New Delhi & Pune**
- ▶ **Culmination of:**
 - ACT MSME Lean Clusters NCR & Pantnagar
 - ACT Foundation Clusters 8N & 8SW
 - ACT Advance Clusters 4N & 4SW
- ▶ **Launch of:**
 - 3rd ACT Engineering Excellence Cluster & 1st ACMA-CII ZED Cluster
 - ACT Foundation Clusters
 - ACT Advance Clusters



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“Achieve Best to Give the Best”

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One complimentary copy of "ACT Now" is sent to each member of ACMA. Additional copies are available @ ₹ 150/- for each copy. This cost is including service tax & postage charges.



Chairman's Message

Following the call of 'Make in India' given by our Honourable Prime Minister, India is poised to become a global manufacturing hub. Automotive industry remains one of the largest part of the Indian economy so it follows that global opportunities which will be knocking the doors of the Indian auto component industry. However, to capitalize on this prospect Indian entrepreneurs must attain global levels of manufacturing excellence for competitive enhancement for their respective businesses.

ACMA Centre for Technology (ACT) has been contributing in a big way to support the auto component fraternity to realise these levels of operational excellence. Till date, more than 650 component manufacturing plants have significantly benefited thorough various ACT interventions. Additionally, a number of new projects are on the cards which aim at taking the auto component industry to previously unscaled heights.

Apart from the individual gains accrued to respective companies through ACT cluster programs, ACMA also helps companies showcase their key achievements through various competitions organised at national level platforms. Some such competition are national Kaizen competition, national Quality circle competition, ACMA Awards etc. Recently, ACMA also initiated ACT Case Study Competitions for the auto component industry. The first such competition was held at ACT Summit in Feb'2015 at Pune.

Encouraged by the overwhelming response at the 1st competition, a 2nd Case Study Competition was organized at Delhi for North & East regions and at Pune for South & West regions. The case studies were invited from industry on various topics i.e Quality, Environment, Total Employee Involvement (TEI), Innovation, Digitization and Skill Development. We are sharing with you some of the prize winning case studies in this issue.

Feedback from the readers is always very important for us to keep on improving this publication. Please do send us your feedback in the designated format.

Thank you and I wish you a very happy new year 2016.

Srivats Ram

2nd ACT Case Study Competition 2015

23rd October, 2015 at Delhi, 28th - 29th October, 2015 in Pune

ACMA (Automotive Components Manufacturers Association of India) has been actively involved in facilitating greater synergy between the various stakeholders of the automotive component industry. ACT (ACMA Center for Technology) was formed in the year 1989 to provide technical support and services to ACMA members. ACT has been instrumental in implementing various cluster program for auto component industry. ACT Clusters are considered a proven approach to improve manufacturing practices of auto component manufacturing industry.

As a step ahead, ACT organized the 1st ACT Case Study Competition in February, 2015 which received a very good response from the industry. 'Case Study Presentations' were delivered under 4 streams by the participant companies, i.e., (1) Zero Defect Quality (Customer Delight) (2) Environment – Energy Conservation, Resource Conservation (Nature Delight) (3) TEI - Total Employee Involvement (Employee Delight) and (4) Innovation- Technology, Productivity, Cost (stake holders' delight).

Encouraged by the huge response received for First ACT Case Study Competition, 2nd ACT Case Study Competition was organized on 23rd October, 2015 at Delhi and on 28th and 29th October at Pune. This time 'Case Study Presentations' were delivered under 6 streams by the participant companies, i.e. (1) Environment (2) TEI - Total Employee Involvement (3) Quality (4) Skill Development (5) Innovation and (6) Digitization. At Level 1 - A total of 177 case studies were received under various streams of competition. In Delhi, 76 Case studies were shortlisted for the Level 2 Competition to deliver presentation at the final round. In Pune the figures were: 196 case studies received and 114 shortlisted for the final round (Level 2).

Level 2 Jury comprised of veterans of industry:

Delhi

- Dr. K Kumar, Former Director, Maruti Suzuki India Limited.
- Mr. RB Madhekar, CEO, R.B.M.S.S
- Mr. Paramjit Singh Chadha, Managing Director, Continental Automotive Brake Systems (I) Pvt. Ltd.
- Mr. Puneet Kapur, Principal Consultant, Lean Excellence
- Mr. Sunil Shrivastava, Vice President, Minda Industries Ltd.
- Mr. Sushil Sharma, General Manager, New Holland Tractor (Fiat) India,
- Mr. Vipin Garg, Vice - President (ERDEXE), Maruti Suzuki India Limited.

And the Chief Guest was - Mr. IV Rao, Executive Advisor, Maruti Suzuki India Limited.

Pune

- Mr. P Y Deo, Former DGM (QA), Tata Motors Ltd.
- Mr. Surendra Gadgil, Former GM, Tata Motors Ltd.
- Mr. Anil Karmarkar, Former DGM, Tata Motors Ltd.
- Mr. A S Ruikar, Former GM-Manufacturing, Tata Motors Ltd.
- Mr. Kiran Walimbe, Freelancer
- Mr. Prakash Avachat, Former GM - Business Excellence, TATA Motors Ltd.

And the Chief Guest & Guests of honour were Mr. Gangadhar Nadgouda, Head Supplier Quality Management System, Tata Motors Ltd., Mr. Sanjay Karne, General Manager, Mercedes Benz India, Mr. Kirti Rathod, Chairman Western Region ACMA, Mr. Shirish Bokil, Vice President – Regional Sourcing India, Sandvik Mining and Sandvik Construction.

Following are the winners of 2nd ACT Case Study Competition in Delhi:

Gold Award Winner



Neolite ZKW Lightings Pvt. Ltd., Bahadurgarh

Quality

Silver Award Winner

**Minda Industries Limited (Acoustic Div.), Pantnagar
Wheels India Ltd., Rampur**

Bronze Award Winner

**Subros Limited, Manesar
New Swan Enterprises, Unit-II, Ludhiana**

Environment

Gold Award Winner



Subros Limited, Manesar

Silver Award Winner

Wheels India Ltd., Rampur

Bronze Award Winner

Advik Hi-Tech Pvt. Ltd., Pantnagar

Nipman Fastener Industries Pvt. Ltd., Haridwar

Total Employee Involvement

Gold Award Winner



Minda Industries Ltd.
(Acoustic Div.), Pantnagar

Silver Award Winner

Subros Limited, Manesar

Bronze Award Winner

Munjral Auto Ind. Ltd., Haridwar

Hella India Lighting Ltd., Derabassi

Innovation

Gold Award Winner



Lumax Industries Ltd., Haridwar

Silver Award Winner

Advik Hi-Tech Pvt. Ltd., Pantnagar

Neolite ZKW Lightings Pvt. Ltd., Bahadurgarh

Bronze Award Winner

Subros Ltd., Manesar

Sterling Tools Ltd., Prithla

Skill Development

Silver Award Winner

Subros Limited, Manesar

Bronze Award Winner

Sandhar Automotives, Gurgaon

Digitization

Certificate of Appreciation

Bharat Gears Limited, Faridabad

Following are the winners of 2nd ACT Case Study Competition in Pune:

Quality

Gold Award Winner



Rane Brake Lining Limited

Silver Award Winner

Spicer India Pvt. Ltd.,
Siddheshwar Industries Pvt. Ltd. UNIT-I

Bronze Award Winner

Endurance Technologies Pvt. Ltd., Braking Division
Bharat Gears Ltd.
Wheels India Ltd.

Certificate of Appreciation

Sagar Auto Parts Pvt. Ltd.,

G B Rubber Products

Environment

Gold Award Winner



India Nippon Electricals Ltd.

Silver Award Winner

Delux Bearings Pvt. Ltd, Plant-I

Bronze Award Winner

Gabriel India Ltd.
Delux Bearings Pvt. Ltd., Plant-II

Total Employee Involvement

Gold Award Winner



Sanjeev Auto Parts Manufacturers Pvt. Ltd.

Silver Award Winner

Harita Seating Systems Ltd.

Bronze Award Winner

Endurance Technologies Pvt. Ltd., Braking Division
Wheels India Ltd.

Innovation

Gold Award Winner



Sanjeev Auto Parts Manufacturers Pvt. Ltd.

Gold Award Winner



Rane Brake Lining Ltd.

Silver Award Winner

Wheels India Limited

Wheels India Limited

Bronze Award Winner

J K Fenner (India) Ltd.

Vikrant Auto Suspensions

Eaton Industrial Systems Pvt. Ltd.

Certificate of Appreciation

Rucha Technologies Private Limited

Nippon Thermostat (India) Ltd.

Skill Development

Gold Award Winner



Gabriel India Ltd.

Silver Award Winner

A Raymond Fastener India Pvt. Ltd.

Bronze Award Winner

Mindarika Pvt. Ltd.

Digitization

Certificate of Appreciation

Sagar Auto Parts Pvt. Ltd.

We congratulate & wish all the best to all the winners. The feedback of the event is very encouraging & the next competition is scheduled to be held during next ACT Summit at Pune in 2016.

Case Studies of Gold Award Winner Companies

2nd ACT Case Study Competition

23rd October 2015, New Delhi and 28th - 29th October, Pune

Neolite ZKW Lightings Pvt. Ltd.

Bahadurgarh, Haryana

Case Study Stream – “Quality”

Project Name: Burn Defect in Hard Coat Process.

Project Start Date: 1st August 2014

Project End Date: 30th October 2014

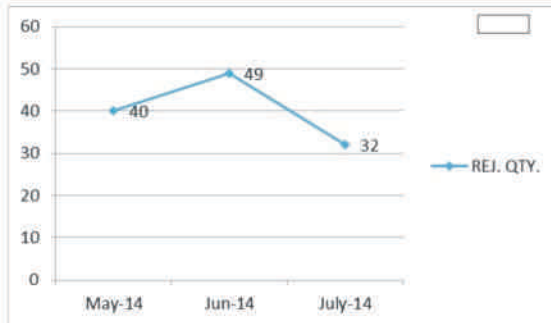
Project Title: To eliminate the rejection in hard coat due to burning problem.

Project Linkage to Company Business: Company Objective is to reduce In-House Rejection PPM.

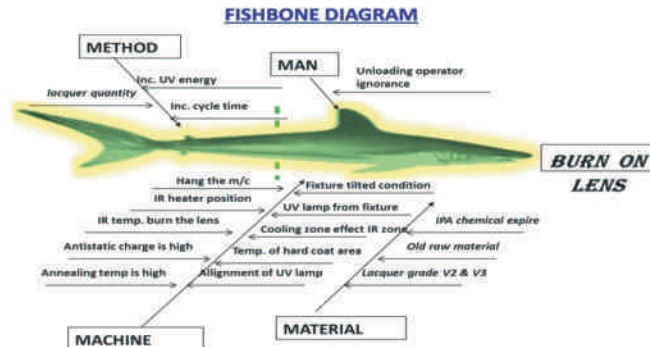
Project Objective: To Reduce the Rejection PPM in Hard Coat due to Burning Problem



Past Trend of the Problem:



Analysis to find Root Cause:



Cause & Effect MATRIX

Sr.No	Process Priority	9	Total
Process Input			
1	Fixture tilted condition	9	81
2	UV lamp height from fixture	9	81
3	Inc. the efficiency of UV energy	9	81
4	Alignment of UV lamp	9	81
5	Unloading operator ignorance	9	81
6	Inc. cycle time	9	81
7	Hang the m/c	9	81
8	Annealing temp. is high	3	27
9	Lacquer grade V2 & V3	3	27
10	IR temp. burning the lens	3	27
11	Temperature of Hard Coat area	3	27
12	Old raw material	1	9
13	Anti static charge is high	1	9
14	Lacquer qty.	1	9
15	IPA chemical expire	1	9
16	IR heater position	1	9
17	Cooling zone effect on IR zone	1	9

Ranking co relation:-

0=none, 1 = weak, 3= moderate, 9 = strong

Validation of Root Cause & Action:

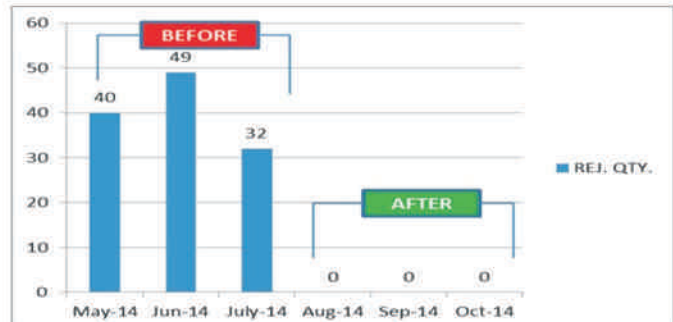
Validation of Causes

Sr. No.	CHECK POINT	CHECKING METHOD	OBSERVATION	RESULT										
1	Fixture tilted condition	By measuring scale	Due to tilted position of the fixture UV heat striking the lens unequally. But no more effect on lens. Because burn occur below the down side of the lens	Burn don't observe, so this check pt. is invalid										
2	UV lamp height from fixture	By measuring scale	<table border="1"> <thead> <tr> <th colspan="2">Dist. Of UV lamp from lens</th> </tr> </thead> <tbody> <tr> <td>1st lamp</td> <td>15.1 cm</td> </tr> <tr> <td>2nd lamp</td> <td>13.4 cm</td> </tr> <tr> <td>3rd lamp</td> <td>13.0 cm</td> </tr> <tr> <td>4th lamp</td> <td>12.2 cm</td> </tr> </tbody> </table>	Dist. Of UV lamp from lens		1 st lamp	15.1 cm	2 nd lamp	13.4 cm	3 rd lamp	13.0 cm	4 th lamp	12.2 cm	We check the UV energy data at this height and found energy as per standard (3300-5800 mJ) so this check pt. is invalid
Dist. Of UV lamp from lens														
1 st lamp	15.1 cm													
2 nd lamp	13.4 cm													
3 rd lamp	13.0 cm													
4 th lamp	12.2 cm													
3	Inc. the efficiency of UV energy	By UV energy display	When we inc. the energy then energy under specification (3300-5800mJ/cm ²)	Burn don't observe, so this check pt. is invalid.										
4	Alignment of UV lamp	By visual	The rays coming from UV lamp strike from UV zone base, reflection occur in the previous lens & pre-curing process occur	When pre-curing lens cure again below the UV lamp then burn problem occur, so this check pt. is invalid										
5	Hang the M/C	By manually	<table border="1"> <thead> <tr> <th>CHECK</th> <th>REASON</th> </tr> </thead> <tbody> <tr> <td>By stop Conveyor</td> <td>Due to sensor problem</td> </tr> <tr> <td>By stop UV door</td> <td>Due to sensor problem</td> </tr> </tbody> </table>	CHECK	REASON	By stop Conveyor	Due to sensor problem	By stop UV door	Due to sensor problem	When the m/c is hang then the lens placed below the UV lamp more than 25 sec but lens don't burn, small amount of whiteness is occur, so this check pt. is invalid				
CHECK	REASON													
By stop Conveyor	Due to sensor problem													
By stop UV door	Due to sensor problem													
6	Unloading operator ignorance	By manually	When a fixture strike with limit switch at unloading area then conveyor stop immediately until the operator unload the fixture	Lens placed below the UV lamp for a long time (until the operator unload the fixture). But burn don't observe, so this check pt. is invalid										
7	Inc. cycle time	By HUMAN M/C INTERFACE (HMI)	If we inc. cycle time then lens placed in UV zone for a long time & more heated	Burn not observe but the rate of productivity dec. so this check pt. is invalid.										
8	Inc. The IR temp.	By HUMAN M/C INTERFACE (HMI)	If we inc. IR temp. burn problem doesn't observe, but decrease DFT & increase IPL.	This check pt. is invalid										
9	Temperature of Hard Coat area	Check the temperature of hard coat area by temperature display outside of hard coat	Specified temperature for hard coat= 27±3°C	Temperature varying 24-34°C and in sometime 18°C										

Counter Measures

L ROOT CAUSE	COUNTERMEASURE	TARGET DATE	RESPONSIBILITY	STATUS
UV alignment	Set the UV lamp in this way, that the energy strike on the lens & reflection do not occur.	15/08/14	Mr. Ashok Gautam & Maintenance deptt	DONE
UV alignment	Dull black paint on the UV zone base plate for removal of reflection.	30/08/14	Mr. Ashok Gautam & Maintenance deptt	DONE
UV alignment	We also fixed a SS plate vertically on UV base plate for absorption of reflected rays in case of reflection occur.	26/08/14	Mr. Ashok Gautam & Maintenance deptt	DONE

Before & After Status:



What is uniqueness of this project: Improve knowledge about UV lamps.

Benefits of the Project:

Tangible (Quantitative)

1. Financial Benefits INR 3,60,000 per Annum.
2. Rejection PPM of Hard Coat Decrease.

Intangible (Qualitative)

1. Communication Skills Improved.
2. Enhanced Mould Knowledge.
3. Team Morale Increased.
4. Enhanced Computer Knowledge.
5. Good Exposure to Problem Solving.
6. Improvement in Overall Personality.

HORIZONTAL DEPLOYMENT

Product name	Customer name	Efficiency of UV lamp				Hard coat temp. °C
		1	2	3	4	
N-1317	Hella	95	95	80-85	80-85	27±3
N-1166	Skoda	95	95	80-85	80-85	27±3
N-1110	Piaggio	95	95	75-85	75-85	27±3
N-1205	GM	95	95	75-85	75-85	27±3

Subros Limited
Manesar, Gurgaon
Case Study Stream – “Environment”

Project Name: Carbon Foot Print



Project Start Date: December 2013

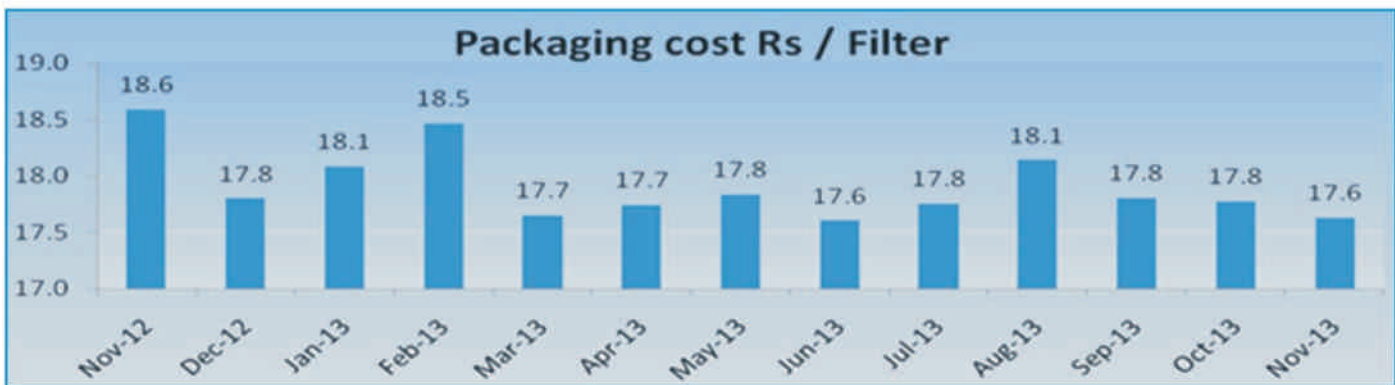
Project End Date: August 2014

Project Title: To Reduce the Consumption of Corrugated Box in Spares Packaging.

Project Linkage to Company Business: Sustainability

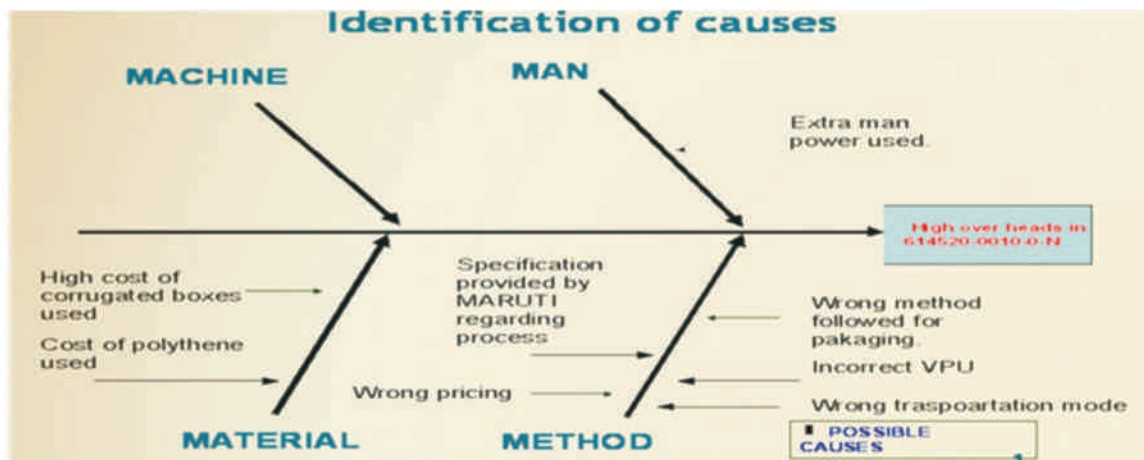
Project Objective: To Reduce Packaging Cost by 50 % (By Reducing the Consumption of Corrugated Boxes)

Past Trend of the Problem:

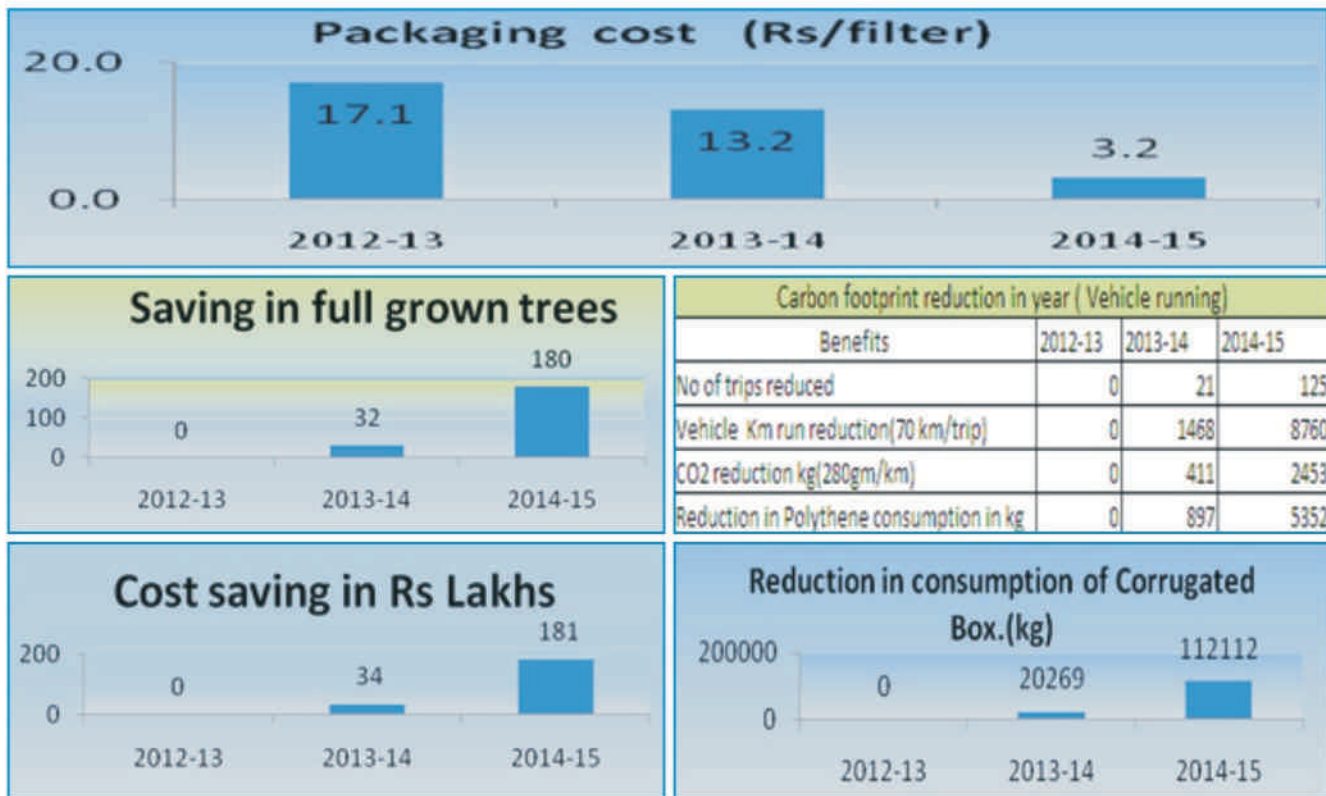


Analysis to find Root Cause: Pareto Diagram, Histogram.

Validation of Root Cause & Action: Maximum Cost is due to Filter Packaging.



Before & After Status:



Uniqueness of this Project: We are Able to Reduce the Carbon Footprint without Impacting the Quality of the Product. Carbon Dioxide Emission reduced by 2453 kg in One Year.

Benefits of the Project:**Tangible (Quantitative)**

Financial Benefits INR 1.8 Crore / Annum

Intangible (Qualitative)

(Space, Time, Skill Reduction etc.)

1. Space Saving of 125%.
2. 180 Nos. of Trees Saved / Annum.
3. Vehicle Trip Reduction 56%.

Minda Industries Limited (Acoustic Div.) Pantnagar, Uttarakhand Case Study Stream – “Total Employee Involvement”

Project Name: Rock Star (TPS)

Project Start Date: 6th March 2015

Project End Date: 25th May 2015

Project Title: Capacity Enhancement of Dia-70 Line by 40%.

Project Linkage to Company Business: Every Company has a goal to achieve Maximum Production with Minimum Cost, so this Project is linked with our Company Business.

Project Objective: To Increase the Productivity of Line from 4000 to 5600.

Past Trend of the Problem:

CONDITION OF ASSY. LINE (BEFORE TPS)		
	REQUIREMENT (March .15)	ACTUAL (March .15)
Customer Requirement /day	5500 Nos.	4000 Nos.
Takt Time :-	4.90 Sec.	
Cycle Time :-		6.75 Sec.
Cycle Time :-		106.23
Actual Prod /Associate/Hour		23 Nos.
No. of Associates.-		22 MP
Prod. /shift/Average.-		3800 Nos.
Line Capacity		4000 Nos.
TOTAL OVER TIME ON LINE = 3 HRS./DAY (3*22=66 MAN-HOURS/DAY)		

Analysis to find Root Cause:

TIME STUDY OBSERVATION SHEET																		
Product name: HORN ASST Product no: 815237 Process: Resonator/Riveting		Date: 24.02.2015 Associate Name: Sumit Prasad Studied By: Sumit Prasad		BEFORE														
S.No	Element	P/O Time			Observed Time										Element % (SMT)	Remarks		
		Manual	Auto	Wait	1	2	3	4	5	6	7	8	9	10				
1	Buffer assembly				5.17	5.17	5.16	5.16	5.16	5.16	5.16	5.16	5.16	5.16	5.16	5.16	88	
2	Pick housing from buffer stage & pick housing from future, place housing on future				2.4	2.4	2.39	2.4	2.4	2.39	2.4	2.39	2.4	2.39	2.4	2.39	8.8	8.8
3	Pick resonator & washer & place on housing				2.4	2.75	2.7	2.75	2.75	2.8	2.8	2.7	2.8	2.8	2.8	2.8	17	
4	Put 10 piece resonator (10.00 Sec for 100 pcs)				0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	9	
5	Put 10 washer in basket (10.00 Sec for 100 pcs)				0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	0.30	9	
TOTAL:					5.75	5.80	5.80	5.80	5.80	5.80	5.80	5.80	5.80	5.80	5.80	5.75	87	

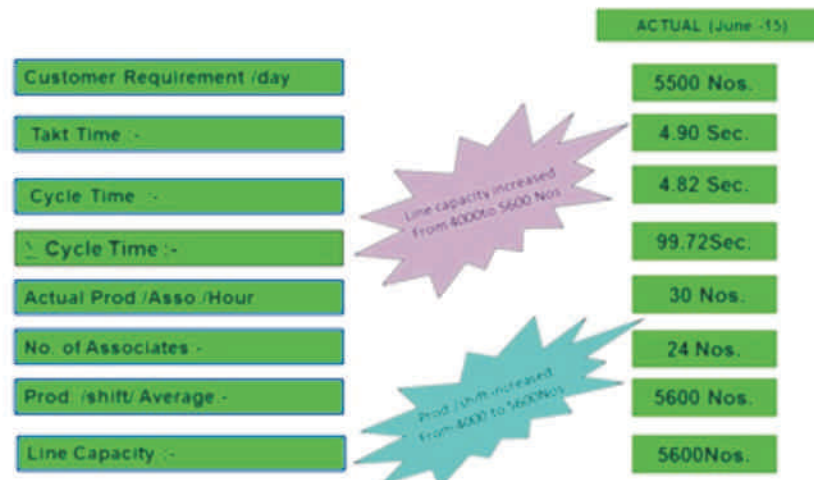
SEQUENCE OPERATION SHEET							
Product Name: Resonator/Riveting Process: M: Chander Singh M: Shikhar Singh M: Shikhar Singh						BEFORE	
Model	Process Name	Station	S.M	IS	Model Code		
SEQ NO	EIS NO./SL NO.	Sequence Description	Work Type				
1	1	Buffer Processing	O		815237	815245	
2	2	Pick Corator & put housing	O		815237	815245	
3	3	Inserting plate on next stage	A		815237	815245	
4	4	Pick housing & place on future	A		815237	815245	
5	5	Place resonator on future	A		815237	815245	
6	6	Pick Washer (5.00 Sec for 5 pcs)	X		815237	815245	
7	7	Place resonator from housing box (10.00 Sec for 40 pcs)	X		815237	815245	
8	8	Adjust the guitar machine (10.00 Sec for 5 pcs)	X		815237	815245	
9	9	Inserting del changer (10.00 Sec for 100 pcs)	X		815237	815245	

Validation of Root Cause & Action:

KAIZEN IDEA SHEET

Month	March-15	Line Improvement Ideas				
Line Number	2 (Die-75)					
S.No	Idea for Improvement	Reason	Acknowledged On & By	Target Date	Res.	Effect.
1	Rollbin grinding stage fixture to be fixed	Made of waiting on rollbin grinding	Sunil Pandey	March-15	MAINT	Time saving
2	18.5" leveling stage fixture to be fixed	Made of waiting in Diep. Assy.	Maint. Team	April-15	MAINT	Time saving
3	Route to be provide on Diaphragm Assy	Made of waiting	Sunder	April-15	MAINT	Reduce Muda
4	Rotometer stage to be an auto type	Rotometer machine speed slow	Sunil Pandey	March-15	MAINT	Increase production
5	To Provide the one extra Air Gap stage.	Balance the Air Gap stage	Diwan	March-15	MAINT	Increase production
6	To Provide one extra acoustic calibration.	Balance the line	Sunil Pandey	March-15	MAINT	Reduce waiting
7	To shift Gortex stage to off line.	Man power saving	Sunder	March-15	MAINT	Reduce Muda
8	To provide Safety Guard on all Stage	Safety Improvement	Maint Team	May-15	MAINT	Zero Accident on Line
9	To Implement Safety Curtain on 1,8 3rd	Safety Improvement	Maint Team	May-15	MAINT	Zero Accident on Line

Before & After Status:

**CONDITION OF ASSY. LINE
(AFTER TPS)**

Uniqueness of this Project : Meeting Customer Requirements without Overtime whereas in Past we were Working with 3 Hours OT.

Benefits of the Project:**Tangible (Quantitative)**

1. Line capacity increased by 40% & productivity increased by 28%.
2. Total saving of INR 920000/ Year.
3. 100% delivery sustained.

Intangible (Qualitative)

1. Increase in Customer Satisfaction.
2. Increase in Team Spirit.
3. Improvement in Self-Confidence.

Lumax Industries Ltd.
Haridwar, Uttrakhand
Case Study Stream - "Innovation"

Project Name: Innovation of New Product Technology

Project Start Date: February 2014

Project End Date: August 2015

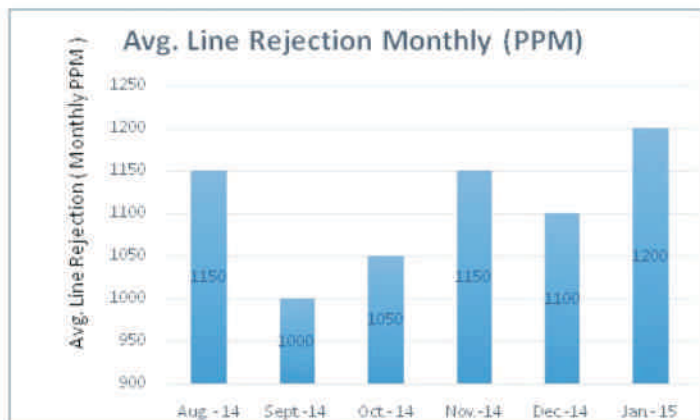
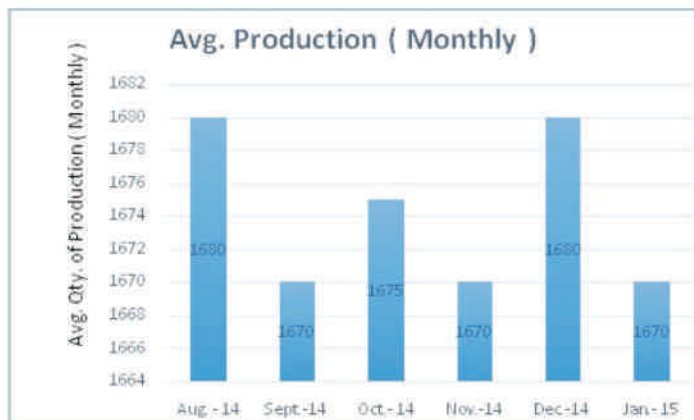
Project Title: In our existing Process H / L and T / L is manufactured in Manual Process. So that increased our Rejection and reduced the Productivity. Also Our Customer is not Satisfied 100%.

Now we made a very innovative change in the process i.e. Convert manual to Conveyer System. Our Line Rejection is Eliminated and Productivity is improved.

Project Linkage to Company Business: Improve the Productivity and Eliminate Line Rejection. We Maintain the Bench Mark for Different Line.

Project Objective: Improve the Productivity and Eliminate Line Rejection through the New Process of Technology.

Past Trend of the Problem:



Analysis to find Root Cause: Brain Storming & used Cause & Effect Diagram to find the Problem.

Validation of Root Cause & Action: Validated the Root Cause, initiated Action to Process on Conveyer System.

Before - Manual Process



After – Conveyer Introduced



Uniqueness of this Project:

1. New Innovation from Manual process to Conveyor Process and mfg. of both Side Production.
2. Improve Productivity
3. Eliminate Line Rejection and Customer Delighted

Benefits of the Project:**Tangible (Quantitative)**

Financial Benefits INR 38,00,000 / Annum

Intangible (Qualitative)

1. Improved Productivity from 25 to 40.
2. Customer Demand met without any Overtime.
3. Process/Quality Improvement.

**India Nippon Electricals Ltd.,
Hosur, Tamil Nadu
Case Study Stream – “Environment”**

Project Name: To improve the process and waste elimination by Mt. Fuji team

Project Title : In old process method, the varnish consumption was more than the norms, refilling of varnish to bottle took more time and more waste since we were unable to reuse the varnish because mixed varnish developed jell condition.

So we introduced cooling system to avoid jelling of varnish, reduced the refilling duration to save the time, reduced wastage of varnish and achieved productivity improvement.

Project linkage to company business : Quality policy to reduce waste reduction and improve environment condition by Total Employee Involvement.

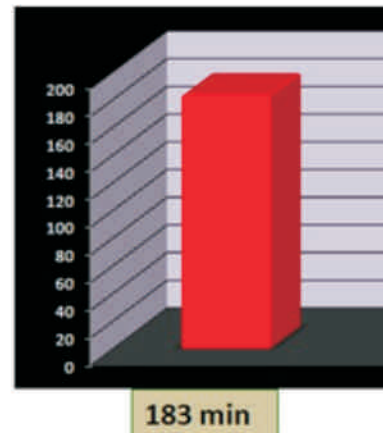
Project objective: To improve the process method and increase the productivity through elimination of Non value added activity and improved waste management.

Past Trend of the problem:

Wastage of varnish / Year



Varnish refilling Time / Day



Analysis to find root cause: We have Brainstormed to find out reason and made cause and effect diagram.

It was observed that varnish refilling time is more due to frequent interval of manual pouring and no reuse of mixed varnish due to jell condition (Viscosity increased)

Innovative Idea: - Introduction of cooling and new refilling system.

As shown below, we introduced new varnish tank and eliminated plastic bottles and reused varnish.



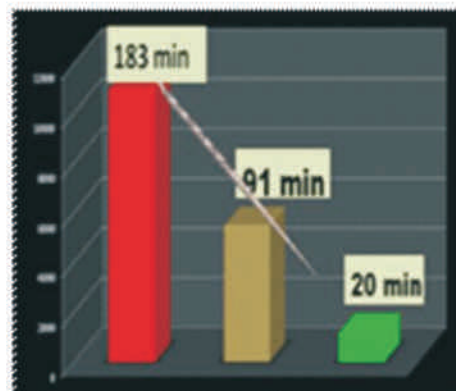
Validation of root cause & Action: Varnish pouring and refilling time reduced, varnish flow is even and prevented the jell of varnish through cooling system introduced.

Before & After Status:

Wastage of varnish

BENEFITS		
Varnish excess consumes / year in Rupees		
	Before	After
Weight	7888 Kgs	0 Gms
Value	Rs.19,72,000	Rs.0.00

Varnish refilling Time



New pouring machine



* There is a un-measurable minimum wastage of varnish

What is uniqueness of this Project:

Adherence to Norms of Varnish

Introduction of Cooling System

Introduction of New Pouring Machine

Benefits of the Project:

Tangible (Quantitative)

7888 Kgs. of Wastage Varnish saved.

Cost saving through this project INR 19,72,000

Intangible (Qualitative)

Operator fatigue eliminated.

Our project is eco-friendly.

Hazard Waste Management Process Minimized.

Sanjeev Auto Parts Manufacturers Pvt.Ltd.
Aurangabad, Maharashtra
Case Study Stream – “Total Employee Involvement”

Project Name : Safety Drive

Project Start Date : May 2015

Project End Date : July 2015

Project Title : To Lay Down Safety Guidelines As Per Processes.

Project Linkage to Company Business: Company Objective this year is to achieve zero accidents.

Project objective: To create awareness about Safe Working Conditions and their Impact on Occupational Health (Reduction of Physical injury cases & ill health conditions).

Past Trend of the problem: Lack of awareness about Unsafe Work Conditions and their threats.

Analysis to find root cause: No understanding of Safety PPEs required and the importance of their use.

Validation of root cause & Action :





Action taken:

- The Capturing of unsafe condition & action on shop floor
- Work station wise PPE implementation plan, including 3A compliances
- Closure of happened accident
- Guideline & required PPE matrix
- Activity wise PPEs display board at main gate
- Work station / Process wise PPEs display board at machine shop
- PPEs availability
- SOP for PPEs - Do’s& Don’ts
- Adherence to PPES ... Monitoring
- SOP for identification of unsafe condition & act
- To display notice for all employees to identification of unsafe condition & unsafe act
- To distribute unsafe condition & unsafe act format
- To provide suggestion box for identification of unsafe condition & unsafe act
- Tracking sheet for monitoring

Before & After Status :

Before: No display boards to indicate Safety PPEs required at the particular station.

After: Display boards at Main gate & each and every station in all plants.

 <p align="center">P I T C H Passion Innovation Transparency Challenge Humility</p> <p align="center">USE OF PERSONAL PROTECTIVE EQUIPMENT (PPE)</p> <p align="center">PROFILE GRINDING MACHINE</p>				
S.N	Type of Activity/ Process	Safety Shoes	Cut Proof Hand gloves	Safety Goggle
1)	Profile Grinding	✓ 	✓ 	✓ 

Main Gate

SANJEEV GENERAL GUIDELINE FOR THE USE OF PPE PERSONAL PROTECTIVE EQUIPMENT TO BE USED																
S.N	Type of Activity/ Process	Safety Shoes	Goggles	Leather Goggles	Full Face Mask	Leather Apron	Back Apron	Safety Helmets	High Voltage Protection	Ear Protection	Eye Protection	Respirator	Hand Protection	Body Protection	Face Shield	Resistor
61	All Employees working in the plant	✓														
62	Fabrication	✓														
63	Welding	✓	✓	✓												
64	Welding (Shielded Metal Arc)	✓														
65	Welding (GTAW)	✓														
66	Welding (MIG)	✓														
67	Welding (Stick)	✓														
68	Welding (Plasma)	✓														
69	Welding (Laser)	✓														
70	Welding (Electron Beam)	✓														
71	Welding (Resistance)	✓														
72	Welding (Friction Stir)	✓														
73	Welding (Cold Chamber)	✓														
74	Welding (Hot Chamber)	✓														
75	Welding (Inert Gas)	✓														
76	Welding (Non-Ferrous)	✓														
77	Welding (Aluminum)	✓														
78	Welding (Copper)	✓														
79	Welding (Titanium)	✓														
80	Welding (Inconel)	✓														
81	Welding (Stainless Steel)	✓														
82	Welding (Carbon Steel)	✓														
83	Welding (Low Alloy Steel)	✓														
84	Welding (High Alloy Steel)	✓														
85	Welding (Cast Iron)	✓														
86	Welding (Cast Steel)	✓														
87	Welding (Aluminum Alloy)	✓														
88	Welding (Copper Alloy)	✓														
89	Welding (Titanium Alloy)	✓														
90	Welding (Inconel Alloy)	✓														
91	Welding (Stainless Steel Alloy)	✓														
92	Welding (Carbon Steel Alloy)	✓														
93	Welding (Low Alloy Steel Alloy)	✓														
94	Welding (High Alloy Steel Alloy)	✓														
95	Welding (Cast Iron Alloy)	✓														
96	Welding (Cast Steel Alloy)	✓														
97	Welding (Aluminum Alloy)	✓														
98	Welding (Copper Alloy)	✓														
99	Welding (Titanium Alloy)	✓														
100	Welding (Inconel Alloy)	✓														

SAFETY FOR MY SELF MY FAMILY MY COMPANY.

Before: PPE Requirement and Hazard Assessment unclear

After: PPE Requirement laid down as per possible Hazardous conditions

5.2 PPE Requirement

PPE is required for at least, but not limited to the following hazardous exposures:

Body Part	Hazard
Head	Falling objects, low level areas, electrical conductors proximal to head, low level obstructions in the pathway.
Eye and Face	Flying particles, molten metal, liquid chemicals, acids/caustics, gases/vapors, injurious radiation.
Ear	High noise levels.
Respiratory system	Harmful dusts, fogs, fumes, mists, gases, smokes, sprays, oxygen deficient areas.
Torso	Heat, chemical splashes, impacts, radiation.
Arm and hand	Electrical shock, skin adsorption of harmful chemicals, heat.
Foot and leg	Falling or rolling objects, sharp objects, slippery surfaces, electrical hazards.

Before: No means to know of all Unsafe Conditions. This would lead to inability to eliminate most problems.

After: Pathway to gather information about Unsafe Conditions and Unsafe Acts from people across the organization

What is uniqueness of this project: This project highlighted the importance of safety, occupational health care and use of PPEs to ensure the two. The Safety Drive was deployed at all sites with a distinct change in Safety Culture.

Benefits of the Project:

Tangible (Quantitative)

Reduced number minor accidents reported, and maintenance of number of major accidents at zero.

Intangible (Qualitative)(Space, Time, Skill reduction etc.)

Increased awareness about safety and development of Safety Culture.

Sanjeev Auto Parts Manufacturers Pvt.Ltd. Aurangabad Maharashtra Case Study Stream – “Innovation”

Project Name: To reduce Set-Up Time by doing Innovation in Tooling and Fixture

Project Start Date: 25th March 2015

Project End Date: 14th August 2015

Project Title: To Reduce Set Up Time by Establishing SMED in Robotic Cell.

Project Linkage to Company Business: To Increase OEE

Project Objective:

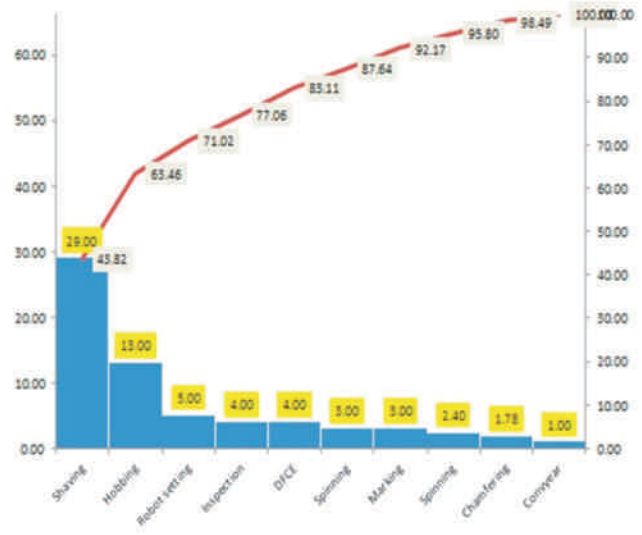
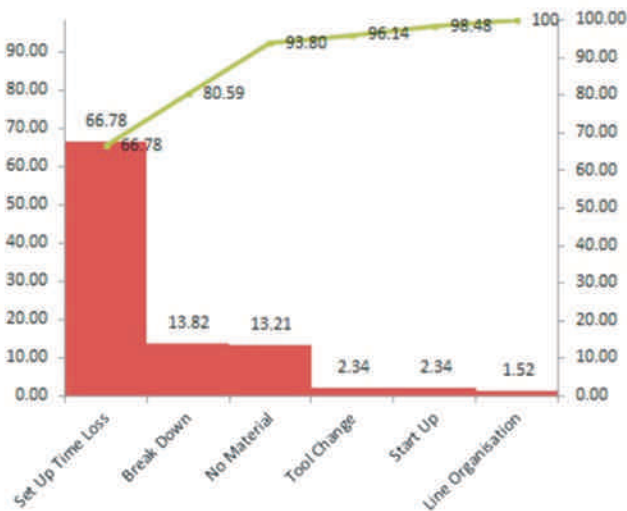
To Reduce Set Up Time From 64 Min to Single Digit

To Increase OEE from 75 by 10 %

Past Trend of the Problem:

OEE Target of 90% not achieved, due to Set Up Time loss

To Increase OEE from 75 To 90%



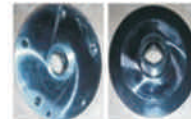
Shaving Machine Set Time Is More.

Analysis to find Root Cause:

Sr. No	Activity	Time Required
1	Collecting Bolt & Allen Keys	3 min
2	Collect HSK Plate/Shaving Mandrill Plate/Shaving Mandrill at Machine	3 Min
3	HSK Plate Bolting & trueing	13 min
4	Shaving Mandrill Plate Bolting & Trueing	15 min
5	Shaving Mandrill Bolting & Trueing	15 Min
6	Clamping Side Assembly with Bolting	15 min
Total Time required for shaving Set Up		64 min



HSK Plate



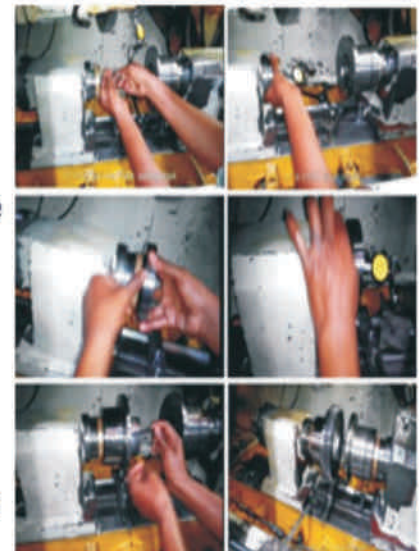
Shaving Mandrill Plate



Shaving Mandrill



Bolts required 20 no's



During Shaving Machine Setting Time is More.

Validation of Root Cause & Action:

No's Of Bolt used 151 & Takes 64 Min as an Ave

Auto Loading

Quick Change of locator --- Replace 3 Bolting with single Allen bolt

Before



Required 3 bolts to tightened the Auto Loading Locator
Result in more time to change set up

After



Required Only One Allen Bolt to tightened the Auto Loading Locator
Result : Save Set Up time

Quick Change of Hobbing Fixture

Quick Change of Hobbing fixture --- Replace 3 Bolting with single Allen bolt

Before

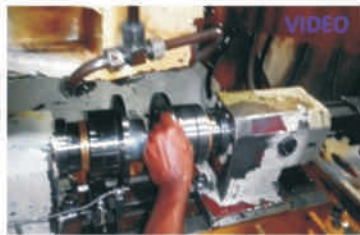


Required 3 bolts to tightened the Hobbing Fixture
Result in more time to change set up

After



Replace 3 Bolt with Single Bolt for tightening the Hobbing Fixture
Result : Save Set Up time



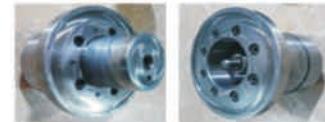
Action Taken
Internal Activity Of Assembly of Shaving Mandrill Plate & Shaving Mandrill are completed externally & kept ready to quick change set up by using only 2 bolts

Following Idea are generate to Eliminate Root cause

1. Fixed Spindle HSK Plate on spindle & True it only once time.



2. Internal Activity Of Assembly of Shaving Mandrill Plate & Shaving Mandrill are completed externally & kept ready to quick change set up by using only 2 bolts



Before & After Status:

Before - Cell OEE 75%

Set Up Time for Shaving Set Up 64 Min

After - Cell OEE 85%

Set Up Time For Shaving Set Up 1.5 Min

What is Uniqueness of this Project:

Idea of Operator.

In SMED Project – This is Big Improvement Considering Saving in Set-Up Time in Total SMED Project in Sanjeev.

Benefits of the Project:

Tangible (Quantitative)

Set up Time – 64 min to 1.5 min

Intangible (Qualitative)

- i) Reduction in Fatigue
- ii) Reduction in skill

Gabriel India Limited Pune, Maharashtra Case Study Stream – “Skill Development”

Project Name: Skill Upgradation training for developing competent workforce

Project Start Date: January 2014

Project End Date: December 2014

Project Title: Project linkage to company business:

The 3 main focus areas of the company are stated:

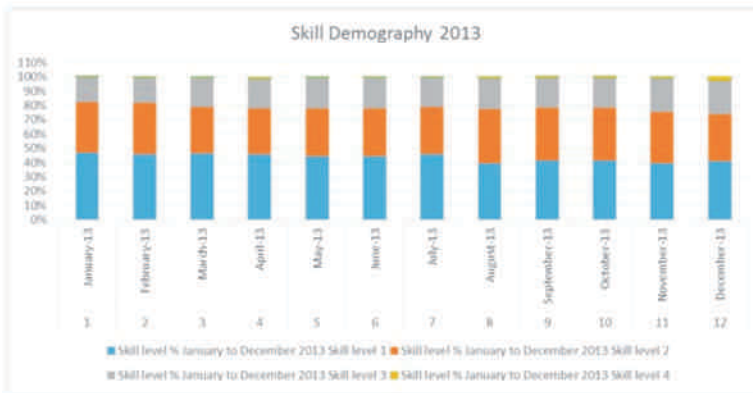
- A. Complexity Reduction
- B. Productivity Improvement

C. PPM Reduction

Project objective: (Example- To achieve zero defect for ABC product at customer end)

1. To ensure the availability of Requisite Skilled Manpower as per Business Requirement
2. Developing the competent workforce through skill building
3. To Increase productivity
4. To reduce Customer PPM.

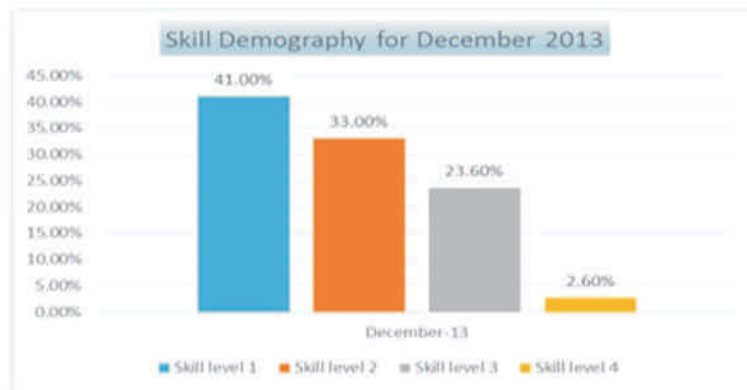
Past Trend of the problem:



Target = 60% Operating Engineers to be in Skill level 3 & Above

1. Desired skill level 3 & 4 at a low % of 21% and 0.87% respectively.
2. Shocks per man were 17.97 nos per person / day whereas target is 28 nos per person / day
3. Customer PPM was 276 PPM

Analysis to find root cause:



Theme of the project:- Improving Skill Level % of Level 3 & Above from 27% to 70%

1. Brainstorming
2. Ishikava Diagram

Validation of root cause & Action:

We Used Verification & Validation Matrix to find out the accurate root cause from Ishikawa Diagram

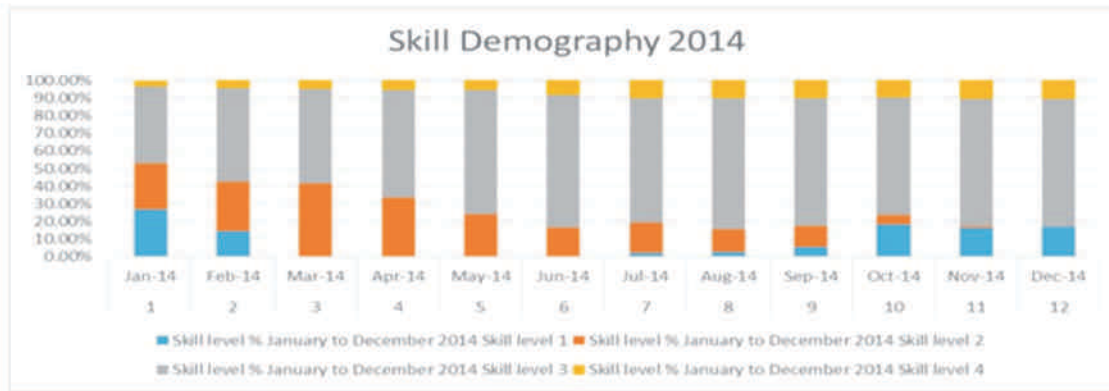
ACTIONS :-

1. Separate training department
2. 5% extra manpower set in the budget to accommodate increased training hours.
3. Increased training budget
4. Started dexterity center for critical operations

5. Deskilling in rod line
6. Developed a pool of Subject Matter Experts and Internal Trainers.
7. Developed in-depth process wise training modules
8. Increased period of induction from 5 to 11 days.
9. Installed a learning kiosk
10. Monitoring of adherence to training calendar.

Before & After Status:

- Skill Level 3 & 4 Achieved 73.26% and 10.08% Respectively.
- Shocks per Man Achieved 27.81 Nos per Person / Day whereas Target is 28 Nos per Person / Day
- Customer PPM Reduced to 51 PPM



Dexterity Center



Stimulation	Purpose
Piston Assembly Valving station	Muscle Memory
Rod inspection table	Identify defects
PDI inspection table	Identify defects
Safety simulation for two hand push button (As per Toyota guidelines)	Handling of machine
Safety simulation for importance of safety shoe (As per Toyota Guidelines)	Safety importance in shopfloor
Hydraulics	JH
Pneumatics	JH
Simulation for quality gauges and instruments	Handling of Attribute and Variable gauges



Inauguration of Training Dept.



Visit of Dr. APJ Abdul Kalam



Classroom Training



On Job Training



Learning Kiosk for OE's



Creative Skills Training



Certified In-house Trainer

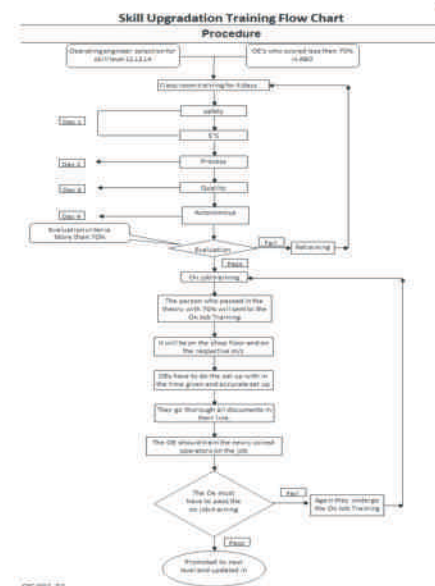
What is Uniqueness of This Project:

- Addressing every Stakeholders Requirement.
- Low Hanging Fruit to Achieve Company Goals.
- Unique Programs of Skill Development such as Induction, Skill Upgradation & CST Programs.
- Introduction Dexterity Centre for Muscle Memory development & Skill Enhancement.

Benefits of the Project:

Intangible (Qualitative)

- Highly Motivated Employees.
- Availability of Skilled Operators.
- Customer Satisfaction



INSTITUTE FOR AUTOPARTS & HAND TOOLS TECHNOLOGY



(UNDP/UNIDO ASSISTED PB. GOVT. PROJECT)
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AN ISO 9001 : 2008 CERTIFIED INSTITUTION



Institute for Autoparts & Hand Tools Technology is a Punjab Government Project assisted by UNDP/UNIDO. The Institute is primarily assisting Small Scale Automotive Component & Hand Tools manufacturers to upgrade their Technology base and Quality of their products in the changing economic and technological environment.

FACILITIES AVAILABLE WITH THE INSTITUTE

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Launch of :

3rd ACT Engineering Excellence Cluster and 1st ACMA CII ZED Cluster Program

– 28th September 2015

The 1st ACT Engineering Excellence Cluster was launched in the year 2011 having 7 companies as its members. The 2nd such Cluster was launched in the year 2012 which comprised of 4 companies. These clusters have been very successful and all the participating companies achieved tremendous results as part of 2 years journey.

Based on the need of the industry the 3rd ACT Engineering Excellence Cluster was launched on 28th September 2015.

This cluster focuses on building engineering capabilities in the automotive industry.

Following companies have joined the 3rd ACT Engineering Excellence Cluster:



Launch of 3rd ACT Engineering Excellence Cluster

1. JK Fenner (India) Ltd., Sriperumbudur
2. Wheels India Limited, Aluminum Div., Padi
3. Wheels India Limited, Sriperumbudur
4. Lucas-TVS Ltd., Padi
5. Sanjeev Auto Parts Mfg. Pvt. Ltd., Waluj
6. Hero Motors Ltd., Dadri
7. Cummins India Ltd., Kothrud



Launch of 1st ACMA-CII ZED Cluster

On the same day, ACMA CII Zero Defect and Zero Effect Cluster was launched at Chennai.

ACMA joined hands with Confederation of Indian Industries (CII) to initiate this special cluster program on Zero Defect & Zero Effect. An MOU in this regard was signed between ACMA and CII during First ACT Summit on 16th February, 2015.

This cluster will be jointly supported by both these organizations. Auto component industry will be served by ACMA, whereas the rest of the industries will be taken care by CII.

This will be a two year improvement journey. The roadmap of this cluster will cover the following topics.

- TEI / 5S / Must be Facilities
- Skill Development
- Zero Defects (Considering all aspects of Quality i.e. Quality of total business processes in entire supply chain)
- New concepts in Zero Defects like Quality Roadmap / Green
- Zero Effect: Bringing all aspects of Production system under Zero effect. Check list to achieve Zero Effect is available with CN
- New product Development and New Product Introduction

This cluster will be mentored by Mr. C. Narasimhan, Chief Mentor ACT and the counselling support will be provided by Mr. Dinesh Vedpathak, Head Cluster Program. For Non-auto industry: CII has proposed the name of Mr. Amit Sanghvi as counsellor

The following companies have joined the 1st ACMA CII ZED Cluster:

1. Neolite ZKW Lightings Pvt. Ltd., Bahadurgarh
2. Sandhar Automotives, Gurgaon
3. JK Fenner (India) Ltd., Dindigul
4. VE Commercial Vehicles Ltd., Dewas
5. Abilities India Pistons & Rings Ltd., Ghaziabad
6. Rockman Industries Ltd., Bawal
7. Yazaki Wiring Technologies India Pvt. Ltd., Chennai

Culmination of :

ACT MSME Lean Cluster NCR – 27th November 2015

ACT MSME Lean Cluster Pantnagar – 3rd December 2015.

The Culmination ceremony of ACT MSME Lean Cluster NCR was organized on 27th November, 2015 in ACMA Delhi Office. The cluster was counselled by Mr. SB Dokey, Expert ACT Cluster Program and mentored by Mr. VK Sharma, Principal Counselor ACT.

Following companies were part of this cluster:

1. Meenakshi Polymers (P) Ltd., Dadri
2. Neolite ZKW Lightings Pvt Ltd., (Sheet Metal Unit), Bahadurgarh
3. Neolite ZKW Lightings Pvt Ltd., Gurgaon
4. New Swan Components Pvt. Ltd., Gurgaon
5. New Swan Enterprises, Tapukara
6. Sellowrap Industries Pvt. Ltd., Gurgaon
7. TKW Automotive Pvt. Ltd., Gurgaon
8. TKW Fasteners Pvt. Ltd., Gurgaon

Mr. Sunil Arora, Chairman ACMA Northern Region, Mr. Dinesh Vedpathak, Head Cluster Program, Mr. VK Sharma, Principal Counselor ACT, Mr. SB Dokey, Expert



Culmination of ACT MSME Lean Cluster NCR

ACT Cluster Program attended this event along with the CEO's & representatives of cluster members.

All companies made substantial progress in overall improvements and their concerted efforts resulted in overall saving of INR 173.03 Lakhs. The overall feedback from the cluster companies is very good at 96.7% satisfaction level.

The Culmination ceremony of ACT MSME Lean Cluster Pantnagar was organized on 3rd December, 2015 at Pantnagar. The cluster was counselled by Mr. Mahesh Gupta, Counselor ACT and mentored by Mr. VK Sharma, Principal Counselor ACT.

Following companies were part of this cluster:

1. Advik Hi-Tech Pvt. Ltd., (Plant 3), Pantnagar
2. Advik Hi-Tech Pvt. Ltd., (Plant 9), Pantnagar
3. Minda Industries Limited, (Acoustic Division), Pantnagar
4. SBR Auto Components Ltd., Pantnagar
5. Singla Forging, Pantnagar

The event was attended by Mr. Vinnie Mehta - Director General ACMA, Mr. Avinash Singh - HOD Quality Assurance - Bajaj Auto Ltd., Mr. Sheetal Dhawan - Zonal Coordinator ACMA Northern Region, Mr. Sandeep Tyagi - VP-Operations Lumax Inds Pantnagar, Mr. VK Sharma - Principal Counselor ACT, Mr. Mahesh Gupta - Counselor ACT along with the CEOs & representatives of cluster member companies.



Culmination of ACT MSME Lean Cluster Pantnagar

The one year improvement journey resulted in cost savings of INR 83.61 Lakhs by all the companies. The overall feedback received from the cluster participating companies is very encouraging and the satisfaction level is 94%. As part of Talent Development, this cluster has developed pool experts in cluster companies for each topic of cluster roadmap.

ACT congratulates all participating companies for successfully completing this improvement journey.

Culmination of :

**ACT Foundation Cluster 8N and ACT Foundation Cluster 8SW
ACT Advance Cluster 4N and ACT Advance Cluster 4SW**

Launch of:

**ACT Foundation Cluster 9 and 10
ACT Advance Cluster 6 and 7**

–7th December 2015: Hotel Lalit, New Delhi



7th December, 2015 was an eventful day for ACMA Centre for Technology (ACT). 5 new clusters were launched on this date at Hotel Lalit, New Delhi. Also culmination ceremony of 4 running clusters was organized on the same day at the same venue.

Mr. Rattan Kapur, Vice President ACMA, Mr. Ramesh Suri, Immediate Past President ACMA, Mr. Sunil Arora, Chairman ACMA Northern Region, Mr. Vinnie Mehta, Director General ACMA, Mr. Dinesh Vedpathak, Head Cluster Program ACT, Mr. VK Sharma, Principal Counselor ACT, ACT counselors and other team members attended the event along with the CEOs and representatives of cluster member companies.

Culmination of Clusters

Following clusters were successfully completed:

ACT Foundation Cluster 8N

Counselor : Mr. Atul Gupta, Counselor ACT

Mentor: Mr. VK Sharma, Principal Counselor ACT

Following companies were part of this cluster:

1. Chopra Autotech (P) Ltd., Haridwar
2. Jumps Auto Industries Ltd, Gurgaon
3. Meenakshi Polymers Pvt. Ltd. Haridwar
4. Mark Exhaust System Ltd., Binola
5. New Swan Enterprises - II, Ludhiana
6. Sandhar Automotives, Dhumaspur
7. Sterling Tools Ltd., Prithla
8. Wheels India Ltd. Rampur

This Cluster Achieved a Total Cost Saving of INR 1099.6 Lakhs

The Overall Feedback shows the satisfaction level of 90%

ACT Foundation Cluster 8SW

Counselors : Mr. Sunil Mutha, Sr. Counselor ACT, Ms. Sapana Baravkar, Counselor ACT, Mr. KR Bhoopalan, Expert-ACT Cluster Program, Mr. G Ananthkrishnan, Expert-ACT Cluster Program, ACT

Mentor : Mr. Dinesh Vedpathak, Head Cluster Program ACT

Following companies were part of this cluster:

1. Delux Bearing Ltd., Pune
2. India Nippon Electricals Ltd., Bangalore
3. MGM Springs (P) Ltd., Ananthapur
4. Mutha Founders Pvt. Ltd., Satara
5. Nash Industries (I) Pvt. Ltd., Bangalore
6. Western Thomson (India) Ltd., Chennai

This Cluster Achieved a Total Cost Saving of INR 548.6 Lakhs

The Overall Feedback shows the satisfaction level of 90%

ACT Advance Cluster 4N

Counselor : Mr. VK Sharma, Principal Counselor, ACT

Mentor : Mr. Dinesh Vedpathak, Head Cluster Program ACT

Following companies were part of this cluster:

1. Anand NVH Products (P) Ltd., Gurgaon
2. Munjal Auto Industries Ltd., Haridwar
3. Neolite ZKW Lightings Pvt. Ltd., Bahadurgarh
4. New Swan Autocomp (P) Ltd., Ludhiana
5. Nipman Fastener Industries Pvt. Ltd., Haridwar

This Cluster Achieved a Total Cost Saving of INR 404.6 Lakhs

The Overall Feedback shows the satisfaction level of 97%

ACT Advance Cluster 4SW

Counselor : Mr. Sunil Mutha, Sr. Counselor ACT, Mr. KR Bhoopalan, Expert-ACT Cluster Program

Mentor : Mr. Dinesh Vedpathak, Head Cluster Program ACT

Following companies were part of this cluster:

1. Moflex Suspensions Pvt. Ltd., Vadodara
2. Pinnacle Industries Ltd., Pithampur
3. Sandhar Automotive, Banagalore
4. Vikrant Auto Suspensions, Vadodara
5. Wheels India Ltd., Sriperumbudur, Chennai

This Cluster Achieved a Total Cost Saving of INR 1638.6 Lakhs

The Overall Feedback shows the satisfaction level of 94%

New Clusters Launched

Following new clusters were launched:

ACT Foundation Cluster 9 & 10

Following northern region companies have joined the ACT Foundation Cluster 9:

1. India Nippon Electricals Ltd., Revari
2. Meenakshi Polymers Pvt. Ltd., Gurgaon
3. Meenakshi Polymers Pvt. Ltd., Binola
4. Autocomp Corporation Panse Pvt. Ltd., Pantnagar

5. Mehta Engineers Ltd., Ludhiana
6. Neolite ZKW Lightings Pvt. Ltd., Noida
7. Admach Auto India Ltd., Faridabad
8. Sansera Engineering (P) Ltd., Manesar

Following South-West region companies have joined the Foundation Cluster 10:

1. Menon & Menon Ltd., Kolhapur
2. Rockman Industries Ltd., Chennai
3. Track Components Ltd. (MESL), Pune

Additional companies are under assessment.

ACT Advance Cluster 6, 7 & 8

Following Northern region companies have joined the ACT Advance Cluster 6:

1. Chopra Autotech Pvt. Ltd. Unit 4, Haridwar
2. Wheels India Ltd., Rampur
3. Sterling Tools Limited, Prithla
4. Stumpp Schuele & Somappa Springs Pvt. Ltd., Sohna
5. Rockman Industries Ltd., Mangli

Following Northern region companies have joined the ACT Advance Cluster 7:

1. Meenakshi Polymers Pvt. Ltd., Haridwar
2. Chopra Autotech Pvt. Ltd. Unit 3, Ludhiana
3. Chopra Autotech Pvt. Ltd. Unit 1, Ludhiana
4. Amar Autotech, Haridwar
5. Amar Autotech, Ludhiana

Considering the over whelming response received, ACT had released a circular announcing the Launch of ACT Advance Cluster 8 to ACMA members.

Following South-West region companies have joined the ACT Advance Cluster 8:

1. MGM Springs (P) Ltd., Anantapur
2. Paranjape Autocast Pvt. Ltd., Shirwal
3. JK Fenner (I) Ltd., Madurai
4. Gajra Differential Gears Ltd., Devas
5. Huf India Pvt. Ltd., Chakan, Pune

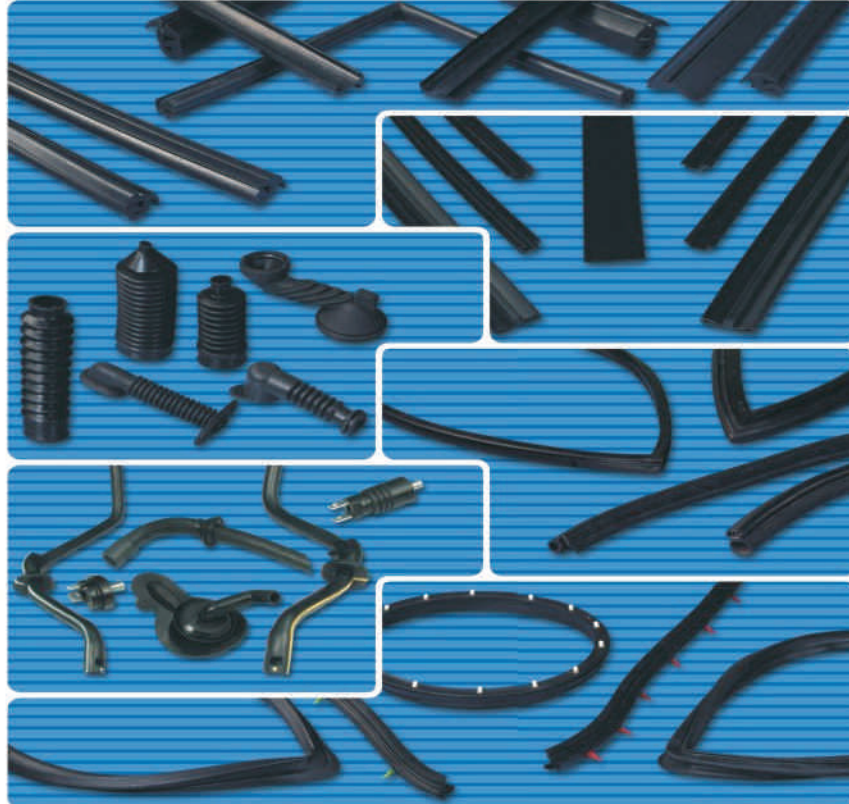
Additional companies are under assessment.





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ACMA Export Cluster Program

With "Make in India" proclamation, our country is poised to be the manufacturing hub for the world. Also, there are aspirations of the industry for "Import Substitution". For this to translate into reality, the Manufacturing Quality must be reliable and world class. German Automotive Manufacturing Quality standard VDA 6.3 is globally proven tool which can help our industry achieve these targets. VDA 6.3 process auditing standards are tried, tested and established. Moreover, the German Automotive industry expects its suppliers to qualify audits as per VDA 6.3. This is a Process Oriented Standard which integrates business processes and Quality Tools to get an overall rating of the company. This German standard directly evaluates your company's performance.

In view of the need of the hour a New Cluster is being launched to prepare participants to qualify them to face Export Audits as well as make their processes robust as per the standard.

Topics covered for Export Qualification-

- Conducting actual audit as per standard
- Structure of standard
- Risk identification with Turtle diagram
- Evolving corrective actions.
- Machine and Process capability, Pre Control charts,
- Failure prevention, Mistake proofing & Poka Yoke solutions
- Reduced customer/ internal/ supplier concerns
- Different tools to make processes robust to qualify for Export Audits.

Process-

- Awareness of VDA 6.3 Process auditing
- Readiness for conducting process audit as per VDA 6.3, within organization.
- Establishing internal audit system
- Revise the basic concept evidence of which is required to be seen in Auditee organisation
- Learning the VDA way of process auditing which is different from System auditing.
- Get to know your levels & develop internal auditors
- Finding out status. Evolving corrective actions
- Classroom plus workplace training & handholding for implementation.
- Focus upon various knowledge-bases as well as mandatory capabilities required to be witnessed by the auditors of German Auto OEMs.
- Impart training of requirements of potential buyer organizations

Deliverables-

- Capability for implementing VDA 6.3 and interacting with German OEMs.
- Supplier requirements of Auto OEMs from other American & European countries.
- Quality improvement
- Cost effectiveness
- Establish audit system
- Rating improvement of customer
- Downgrading rules
- Hands on training of VDA audit.

ACMA will soon be announcing this cluster program.

ACMA		ACMA EXPORT ROADMAP												PM_46_G14 Rev 0 : Dec 2015		
Time in Months*	1	2	3	4	5	6	7	8	9	10	11	12	Deliverables	Implementation during 12 months		
1. Preparing organisation for the Audit 2. Reduced customer/ internal/ supplier concerns										Supplier requirements of Auto OEMs		Supplier requirements of Auto OEMs from other American & European countries.		Revise the basic concepts, evidence of which is required to be seen in auditee organization. Organisation will be prepared for facing Customer Audits		
1. Focus areas of Process elements P6.1 to P6.6 2. Focus areas of Process elements P5 & P7. 3. Focus areas of Process element P2, P3 & P4 4. Quality Tools, 7 types of wastes, 8D & Problem-solving. 5. Machine and Process capability, Pre Control charts, 6. Failure prevention, Mistake proofing & Poka Yoke solutions 7. Continuous Improvement techniques including DOE & QFD				Tools and Proficiency (Different tools as per VDA 6.3)						Revise the basic concepts Evidence in auditee organization. Different tools as per VDA 6.3 Quicker Problem Solving						
1. Conducting actual audit as per VDA 6.3 method using the internal audit team. 2. Evolving corrective actions.			Hands On training of VDA audit.			Compiling excel sheet & interpreting findings Evolving improvement plan Finding out status. Get to know your levels & develop internal auditors Learning the VDA way of process auditing which is different from System auditing.						Actual implementation of VDA 6.3 with Internal Audits				
1. System audit Vs. Process audit 2. Structure of VDA 6.3 3. Process elements P2 to P7 4. Generic launch Pad 5. Risk identification with Turtle diagram		Awareness of VDA 6.3 process auditing		Understanding the VDA system of process auditing. Evolving open audit-questions & link up to VDA questionnaire. Hurdle Rules / Knock Out criteria Potential analysis with P1 Understanding customer requirements											Create awareness of VDA 6.3	
Property of ACT (ACMA Centre for Technology) 2015																

Rev 0 : Dec 15

* Timeline mentioned in terms of month is a guideline and can vary as per the situation. All course contents must be delivered within the cluster program duration *

Two Days Workshop on VDA 6.3 Process Auditing

8th & 9th September, 2015: ACMA Pune office

To create awareness about VDA 6.3 process auditing, ACMA Centre for Technology conducted a Two Days Workshop on VDA 6.3 Process Auditing on 8th and 9th September, 2015 at ACMA Pune office.

15 persons from following companies have participated in this workshop:

1. A Raymond Fasteners India Private Limited, Pune
2. Delux Bearing Pvt. Ltd. Plant II, Pune
3. GB Rubber Products, Pune
4. Inteva Products India Automotive Pvt. Ltd., Pune
5. Lucas TVS Ltd., Chennai
6. Rockman Industries Ltd., Ludhiana
7. Spicer India Pvt. Ltd., Pune

The faculty Mr. Kiran Walimbe has 30 years of hard core experience from the automotive industry. He is a certified auditor and trainer for VDA 6.3 Process

auditing in India and abroad.

The program covered following topics:

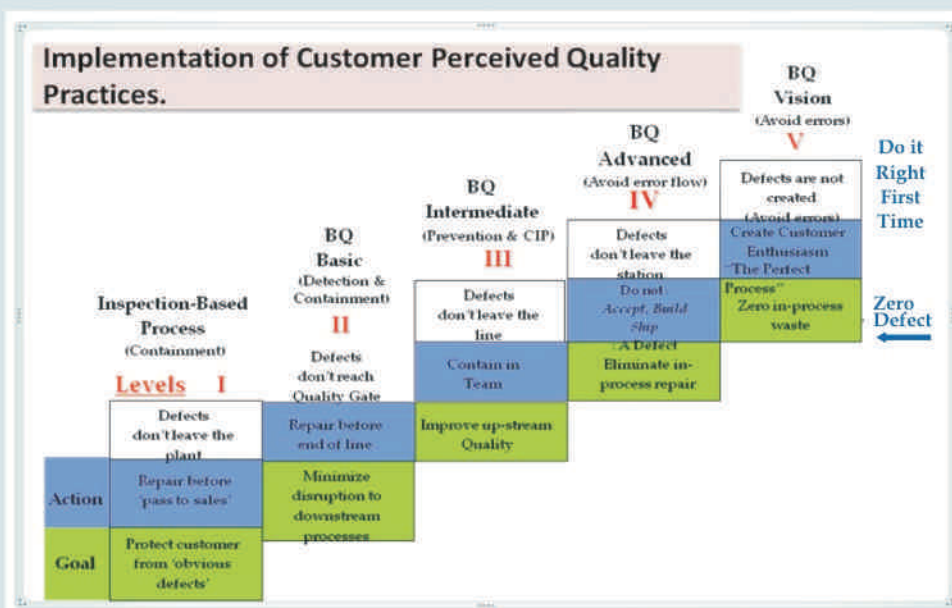
- System Audit Vs Process Audit :
- Process elements P1 to P7
- Generic launch pad & its 4 drivers.
- Traffic light auditing
- Auditor's action plan: Process – Turtle diagram – Identification of risks – planning for risk assessment – audit findings – recording in excel sheet.
- Interpreting excel sheet & it's macros,
- Downgrading rules.
- Audit actual, How to improve earlier ratings or how to get high ratings in the first attempt.

The feedback received is very encouraging hence another program on same topic has been announced for Delhi. This is scheduled for 12 ~13 January, 2015.

Customer Perceived Quality Cluster :

The main purpose of Launching this cluster is for qualifying Tier 2 / 3 organisations to supply defect free components to their customers. Achieving & Excelling the bench mark levels to manufacture and deliver the best Quality products to all the Customers. Customer Perceived Quality (CPQ): An organization wide initiative to address competition. CPQ Initiative is aligned with the purpose emphasized in Vision & Mission of organization. CPQ is for operational excellence driven with senior management involvement on a continued basis. The entire frame work of CPQ is built on five principles.

- Total Employee Involvement (TEI): "Engage everyone to achieve quality culture".
- Variability Reduction (VR): "To reduce variation and stabilize"
- Built Quality (BQ): "Do not Accept, Build, and Ship Defects"
- Short Lead Time (SLT): "Drives first time quality, quick problem solving"
- Continuous Improvement (CI): "TPM, Kaizen, suggestion scheme and self-managed team concepts"



Session of GRE : Geneva, Switzerland



The work of preparing harmonized global standards for automotive components & subsystems is done by a Committee known as WP.29 under UNECE.

* WP 29 administers three UNCE Agreements, UNCE 1958, UNCE 1998, UNECE 1997.

* There are six Subsidiary Bodies - GRs.

- WORKING PARTY ON LIGHTING AND LIGHT SIGNALING – GRE
- WORKING PARTY ON BRAKES & RUNNING GEARS – GRRE
- WORKING PARTY ON PASSIVE SAFETY – GRSP
- WORKING PARTY ON POLLUTION & ENERGY – GRSP
- WORKING PARTY ON NOISE – GRB
- WORKING PARTY ON GENERAL SAFETY PROVISIONS – GRSG

Each of the above Groups has Indian Group headed by Chairman and experts

GRSG : The Working Part on General Safety The Working Party on General Safety (GRSG) is the subsidiary body of the World Forum for Harmonization of Vehicle Regulations (WP.29) that prepares regulatory proposals on general safety to WP.29.

GRE : The Working Party on Lighting and Light-Signalling

The Working Party on Lighting and Light-Signalling (GRE) is the subsidiary body of the World Forum for Harmonization of Vehicle Regulations (WP.29) that prepares regulatory proposals on active safety, specifically regarding vehicle Lighting and Light-Signalling to WP.29.

These groups of experts conduct research and analysis to develop standards requirements for all types of vehicles.

These groups convene officially twice a year and entrusts informal groups with specific subjects that need to be considered urgently or that require special expertise. More than 100 experts participate at these sessions.

The Working Party is open to the governmental experts from any member country of the United Nations, and to any regional economic integration organization set up by member countries of the United Nations, and to experts of governmental organizations. Experts of non-governmental organizations (NGOs) may participate in a consultative capacity. Final decisions are taken by Government representatives by vote at the World Forum WP.29 level.

The work of these experts is transparent: All agendas,

working documents and reports are openly accessible on this website.

This year Team of 4 members of Indian GRSG attended GRSG (Working Party on General Safety) at Geneva from 29th September to 2nd October 2015. Salient points :

- Regulation No. 107 (M2 and M3 vehicles) Proposals for further amendments :GRSG committed to review the provisions on automatic fire suppression systems in order to find consent on the mandatory installation of such systems on vehicles of Classes I and II.
 - o Adopted as supplement for 06 series and will be put up in March session of WP29.
- Regulation No. 39 (Speedometer/odometer): GRSG agreed to resume consideration of ECE/TRANS/WP.29/GRSG/2015/16 and GRSG-108-38, both tabled by the Fédération Internationale de l'Automobile (FIA), proposing further amendments to Regulation No. 39
 - o Informal Document 109-13. This would be official document for the next session. Revised proposal to be submitted by European commission.
- Regulation No. 43 (Safety glazing): GRSG agreed to consider a revised proposal by European Association of Automotive Suppliers (CLEPA) excluding from the main vision zone an area to allow the application of safety systems for vehicles other than M1 category.
 - o Considering the Head injury criteria values for multiple gazed panes if used in case of Bus rollover is critical when compared to other glass panes , hence Germany, France, CLEPA , CLCCR doesn't support the support Hungary Document,
- Regulation No. 46 (Devices for indirect vision): GRSG agreed to consider a proposal (ECE/TRANS/WP.29/GRSG/2015/23) by OICA clarifying the conditions for the installation of surveillance mirrors, when integrated in a housing already including one or several mirrors of classes II or III.
 - o This document was supported by Japan, France, IRU and the document was adopted, It would be as supplement to the Regulation. Will be put up in March session of WP 29.
- Regulation No. 73 (Lateral protection devices): GRSG may wish to consider a proposal by the expert from UK on this subject, if available.
 - o 109-17 will be a formal document for the next GRSG session.
- Election of Officers: In compliance with Rule 37 of the Rules of Procedure (TRANS/WP.29/690 and Amends.1 and 2), GRSG will elect the Chair and Vice-Chair of the sessions scheduled for the year 2016.
 - o Mr. Antonio ERARIO was reelected as the chair person. Dr. Máttyás MATOLCSY (Vice-Chair) has informed that he would be retiring and hence voting was conducted for new Vice-chair and Mr. Kyle HENDERSHOT of Canada was elected.

Recent Activities of ACT

- Culmination of ACT MSME Lean Cluster NCR 27th November 2015
- Culmination of ACT MSME Lean Cluster Pantnagar 3rd December, 2015
- Culmination of :
ACT Foundation Cluster 8N and 8SW 7th December 2015
ACT Advance Cluster 4N and 4SW
- Launch of:
ACT Foundation Cluster 9 and 10 7th December 2015
ACT Advance Cluster 6 and 7
- Two Days Workshop on VDA 6.3 Process Auditing 8th and 9th September 2015 at ACMA Pune Office
- 2 Days Certification Programme On "ZERO Defect - Customer Perceived Quality" 23rd and 24th December 2015 at ACMA Pune Office

Forthcoming Activities

- Launch of 1st Resource Efficiency Cluster Program (NCR) February 2016- January 2017
- Launch of ACT Quality Cluster for Tier 2/3 companies February 2016
- Launch of 1st ACMA Export Cluster program February 2016- January 2017
- Culmination of ACT MSME Lean Cluster Haridwar-Pantnagar February 2016
- Culmination of ACT MSME Lean Cluster Ludhiana February 2016
- Culmination of Lean Project for Makino Auto March 2016
- Two Days Workshop on VDA 6.3 Process Auditing 12th and 13th January 2016 at ACMA Delhi Office
- Two Days Training Program on "Activity Analysis (Product/Person/Machine)" 28th and 29th January 2016 at ACMA Pune Office
- Certification Course on Leadership Skill Development Delhi & Pune: February 2016
- Certification Course on De-skilling of operations Delhi & Pune: February 2016
- Doubling productivity by Activity Analysis Pune: January 2016
- Certification Course on Value Stream Mapping Delhi: February 2016
- Certification Course on Motivation in Manufacturing Delhi: January 2016
- 2nd NPD Foundation Cluster Program December 2016 – November 2018
- 1st NPD Advance Cluster Program December 2016 – November 2018
- Advance Lean Manufacturing Program April 2016 – March 2017
- ACMA Awards 2015-16 Release of Circular March 2016

ACT now Advertisement Tariff from Dec, 14 onwards

Advertisement Type	Advertisement for Single issue (INR)		Advertisement for one year (three issues) (INR)		Advertisement for two years (six issues) (INR)	
	Member	Non Member	Member	Non Member	Member	Non Member
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Cover Leaf Front - 2 Page Advt.	35000	45000	95000	123000	157000	204000
Cover Leaf Back - 2 Page Advt.	30000	39000	81000	105000	135000	175000
Footer Advt. - Company Logo & Slogan- (excluding Advt. pages)	30000	39000	81000	105000	135000	175000
Back Cover Outside	20000	26000	54000	70000	90000	117000
Centre Spread (2 Page Advt.)	25000	32000	67000	88000	112000	146000
Centre Spread (4 Page Advt.)	50000	65000	135000	175000	225000	292000
Cover Inside (Front or Back of Newsletter)	13000	17000	35000	45000	58000	76000
Inside Full Page	11000	14500	30000	39000	50000	64000
Half Page	6600	8600	17800	23000	30000	39000
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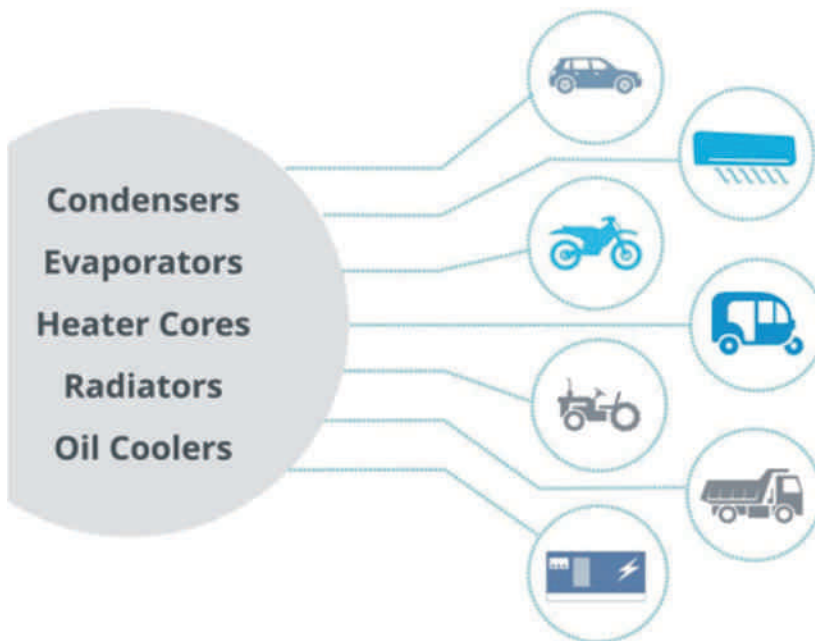
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About Talentonic

Talentonic is an HR consulting, research and products company which was set up by senior HR professionals with both consulting and practicing experience. Talentonic is a scalable HR Services business, which can support Clients' need for growth and increasing sophistication of HR solutions. Our solution areas include



Strategic HR Consulting



HR Point Solutions



Technical HR



HR Products

Our experience in the Automobile Sector

- We have conducted audits for more than **50 auto component** companies on behalf of OEMs and Auto Associations to capture best practices in HR service delivery
- Currently partnering with a number of companies in the sector in defining, designing and implementing their HR plans in the long and short term including running engagement and 360 feedback survey

Consulting Solutions

- Vision, Mission & HR Strategy
- Organization Structuring, Role Definition & Grading (Job evaluation)
- Compensation and Rewards Management
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- Manpower Planning and Optimization
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