

Ishikawa and Pareto

Skorkovsky ,KPH MU

TQM and Ishikawa FBD

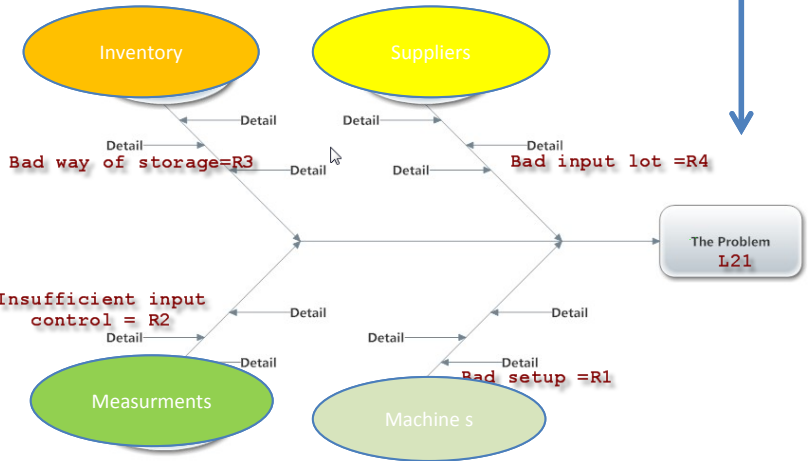
- Reject statistics
- Final product /Rejects
- MachineCenters/Rejects
- Rejects in time
- Final products/Rejects in time
- Machine centers/Rejects in time

Statistika zmetkovosti

Zmetky celkem **9 485 283** Filtr Data

Filtr čísla zboží.

Kód	Popis	Množství zmetků	Poměr zmetkovosti
L14	Sekje	116 579	1%
L15	Propadliny-polotovar	94 515	1%
L16	Deformace klipu	48 382	1%
L17	Deformace	61 782	1%
L21	Hrudky	848 556	9%
L23	fleky	195 791	2%
L24	Flek - kráter	4	0%
L30	kropenatě	21 654	0%



Reject type (effects);	R1	R2	R3	R4
L19	8	9	2	4
L20	0	1	4	6
L21	7	2	3	5

} Score



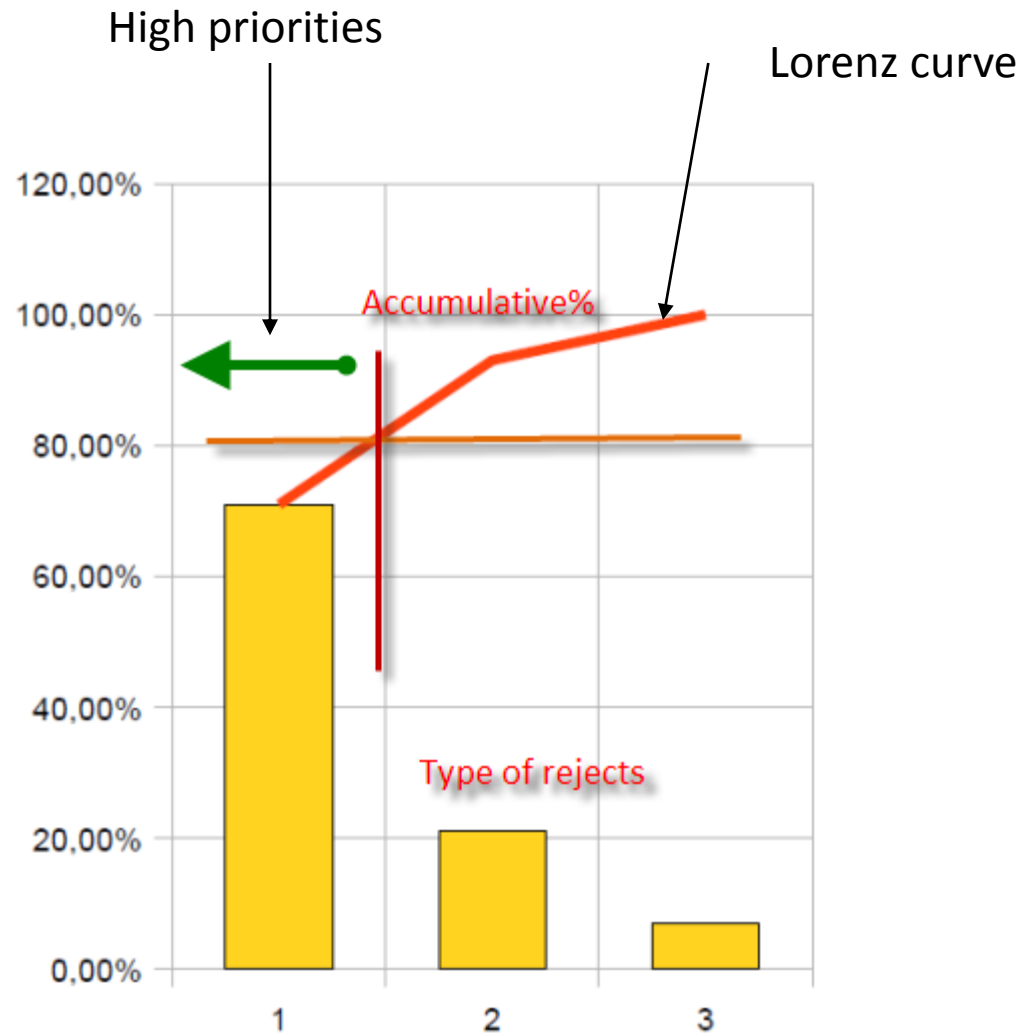
Manual for urgent reject cause elimination



(to establish correct priority of remedy actions)

Every reject type ->one Ishikawa diagram (electronic version)

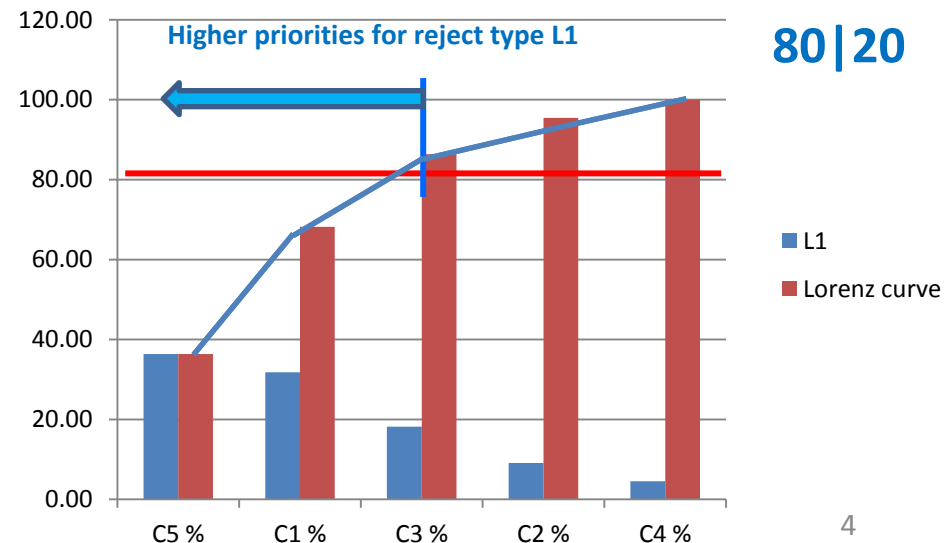
Pareto chart : a possibility to split up reject and setup priorities



Pareto analysis per every type of reject

Type of reject	Cause 1	Cause 2	Cause 3	Cause 4	Cause 5	Cause 6	Total
L1	7	2	4	1	8	0	22
L2	2	4	6	8	0	9	29
L3	4	0	0	5	6	7	22
L4	5	7	2	0	1	3	18
L5	0	2	7	3	0	1	13
L6	9	7	5	2	3	6	32
L7	0	7	0	2	3	4	16
L8	1	8	6	2	4	0	21
L9	2	0	5	7	1	4	19
L10	7	2	8	9	7	5	38
C	C5 %	C1 %	C3 %	C2 %	C4 %	C6%	
L1	36,36	31,82	18,18	9,09	4,55	0,00	100
Lorenz curve	36,36	68,18	86,36	95,45	100,00		

Type – what happened
 Cause – the reason why we have got it
 $22 = 7 + 2 + 4 + \dots + 8 + \dots$
 $36,36 = 7 / 22; \dots$
 $68,18 = 36,36 + 31,82; \dots$



Good day to everybody

