

CELL :- D.C. CELL NAME:-Drum change All models MACHINE / STAGE:- VMC spark machine. OPERATION:- 5-Hole drilling.

KAIZEN THEME :- To increase the MTBF of Hole Seal.

IDEA :-To make Bush from PU material

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS:-We had provided a O ring to prevent the 5 hole depth oversize But O ring removed from hole in every 2 hours.Aprox.

COUNTERMEASURE:-Changed the o ring of Rubber and using PU bush at Drilling & Tapping A352 & A422 Resting ring above the metallic face of 5-hole drilling fixture, then if any metallic chips comes on the drilling fixture then air pressure not drop and reach the specific pressure which use for prevention of 5 depth over size of drum change all models

BENCHMARK	1 -2 stoppage
TARGET	Zero
KAIZEN START	02.02.15
KAIZEN FINISH	05.05.15

TEAM MEMBERS :-

Jasbir Kumar

BENEFITS :-

- 1) Eliminate the stoppage
- 2) Eliminate the time loss.

KAIZEN SUSTENANCE

WHAT TO DO :-Physically validation

HOW TO DO :-Check points add in sustenance check sheet

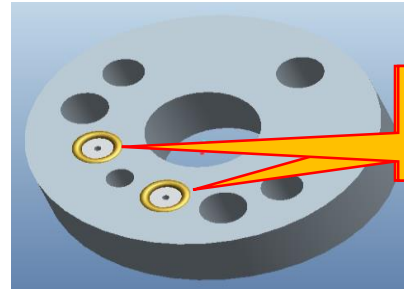
FREQUENCY :- Daily

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.
500	100	600

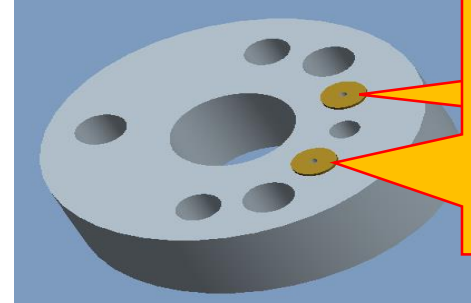
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
2	All DC Line	15.02.15	Jasbir Kumar	Done



'O' ring

BEFORE



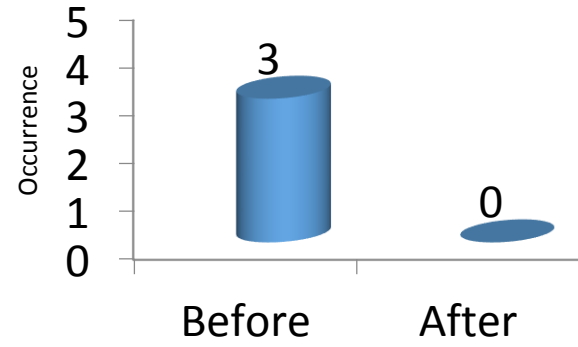
'PU Bush' provided in Resting Ring in which air pass which is used for prevention of 5-hole depth over size.

AFTER

WHY - WHY ANALYSIS :-

- WHY 1:- O ring removed in every 2 hours.Aprox.
- WHY 2:- Which was not fixed with hole.
- WHY 3:-It was made from rubber material.

RESULT :- No stoppage



ROOT CAUSE :- O Ring made from Rubber material

REGISTRATION NO&DATE:

REGISTERED BY :-

MANAGER'S SIGN :-