A DITT		TPM CIRCLE NO :- 3	ACTIVITY	KK	QM	PM	JH	SHE	ОТ	DM	E&T		
<b>ADVIK</b>	P1	TPM CIRCLE NAME:	LOSS NO. / STEP									] KAI/FN	I IDEA SHEET
		DEPT :- Q.A	RESULT AREA	Р	Q	DEF :-	Α	С	D	S	М	الطكالا لا ا	
CELL :- A373	CEL	L NAME:- oil pump Cover	MACHINE / STAGE :- CNC					OPI	OPERATION :- facing				
KAIZEN THEME -To avoid A373 Cover Thickness 5.0 undersize  WIDELY/DEEPLY:-			IDEA :-Wear & Geometry offset to be lock & can not take above 0.1 offset.										
			<b>COUNTERMEASURE:</b> -1) After lock machine,						E	BENCHMARK 47 No.		47 No.	
			- I I ARGEI I I ONO							0No.			
			It should not take offset in Geometry  KAIZEN START						RT	30.07.2015			
PROBLEM / PRESENT STATUS -A373 Cover Thickness 5.0 undersize. Spec - 5.0 ±			offset.						_ T	ARGE	T DA	ΓE	28.08.2015
			2)Wear offset lock above 0.1 can not					ŀ	KAIZEN FINISH				
			TEAM MEMBERS :-										
			TOU DATAL TOU 2. 1/ 8						Harada aireala Varrei Dassi				

0.1, Actual - 4.62mm



**BEFORE** 

BIBINDE TA: AGS	[PACHINE]	0.0000 0.0000
1 X 2.6875 2 X 52.6456 3 X -86.4546	7 -8-8998 2 -116-4298 7 -113-1678	
4 X -86-5138 5 X 147-2072 6 X -76-5880	Z -41.6114 Z -112.7496 Z -111.2048	
9 X -78.5792 9 X -8.1292 10 X -77.9203	Z -185.9748 Z -34.5493 Z 6.8888 Z -66.1888	
(6)X( 15X 10 485 648	Z( ) 至4 )	(15hnev
	NUSE-R LIFE	HENU

**RESULT:-**

Why 1 - A373 Cover Thickness 5.0 undersize

**Why 2** – Wrong offset Taken.

**WHY - WHY ANALYSIS :-**

Why3 - After locking control panel machine take offset in Geometry offset.

Why4 - Current process allows to wrong offset.

**ROOT CAUSE-** — Current process allows to wrong offset.

**REGISTRATION NO. & DATE:- 30.07.2015** 

**REGISTERED BY:- Ganesh Padwalkar** 

**MANAGER'S SIGN :- Sunil kinkar** 

Currently checking 100 %

KAIZEN START	30.07.2015			
TARGET DATE	28.08.2015			
KAIZEN FINISH				
TEAM MEMBERS :-				
Umesh pimple, Yuvraj Desai				
Ganesh Padwalkar ,vijay walunj,				
BENEFITS :-	_			

- 1. Prevent Re-occurrence Defect.
- 2. Reduce COPQ.

## **KAIZEN SUSTENANCE**

WHAT TO DO- Point added in Sustenance check sheet.

**HOW TO DO: Audit** 

**AFTER** 

**FREQUENCY**: Alternate Day

## **COST INCURRED FOR MAKING KAIZEN**

1	MATERIAL COST	LABOUR COST	TOTAL COST
	IN RS	IN RS	IN RS

## SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
,	Mazak 1,2,3	29.08.2015	Umesh Pimple	In process