

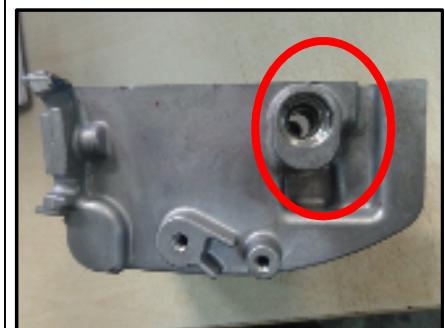
| | | | | | | | | | |
|--------------------|-----------------|----|----|--------|----|-----|----|----|-----|
| TPM CIRCLE NO :- 3 | ACTIVITY | KK | QM | PM | JH | SHE | OT | DM | E&T |
| TPM CIRCLE NAME : | LOSS NO. / STEP | | | | | | | | |
| DEPT :- Q.A | RESULT AREA | P | Q | DEF:-A | C | D | S | M | |

| | | | |
|--------------|------------------------|-----------------------|----------------------|
| CELL :- A361 | CELL NAME:- HG shifter | MACHINE / STAGE :-VMC | OPERATION :- Reaming |
|--------------|------------------------|-----------------------|----------------------|

KAIZEN THEME –To avoid A361 Body Dia.18.0mm Chamfer not ok & unclean at face.

WIDELY/DEEPLY:-

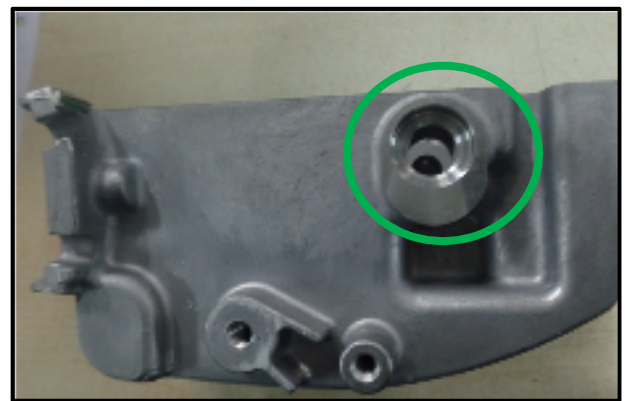
PROBLEM / PRESENT STATUS –A361 Body Dia.18.0mm Chamfer not ok & unclean at face.



BEFORE

IDEA :- Dimension 63.0mm to be corrected in Die.

COUNTERMEASURE: -Dimension 63.0mm corrected in Die



AFTER

| | |
|----------------------|------------|
| BENCHMARK | 17No. |
| TARGET | 0No. |
| KAIZEN START | 05.07.2015 |
| TARGET DATE | 25.07.2015 |
| KAIZEN FINISH | 20.07.2015 |

TEAM MEMBERS :-
 Ganesh Kharmale,Sachin Bhalerao.
 Ganesh Padwalkar ,vijay walunj,
BENEFITS :-

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

KAIZEN SUSTENANCE

WHAT TO DO- Point to added in Sustenance check sheet .

HOW TO DO: Audit
FREQUENCY : Alternate Day

WHY - WHY ANALYSIS :-

Why 1 – A361 Body Dia.18.0mm Chamfer not ok & unclean at face.

Why 2 –Less material stock in casting.

Why3 – Dimn. 63.0mm not maintain in casting

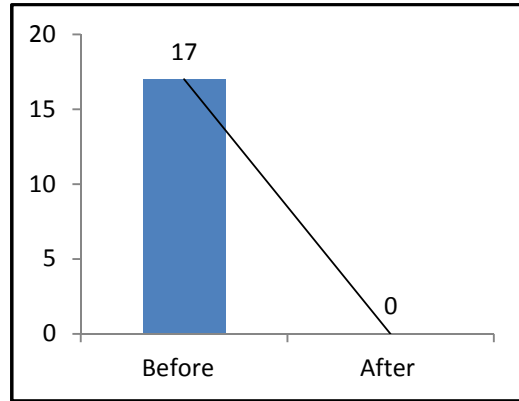
ROOT CAUSE- -- Dimn. 63.0mm not maintain in casting

REGISTRATION NO. & DATE:- 20.07.2015

REGISTERED BY :- Ganesh Padwalkar

MANAGER’S SIGN :- Sunil kinkar

RESULT :-



COST INCURRED FOR MAKING KAIZEN

| MATERIAL COST IN RS | LABOUR COST IN RS | TOTAL COST IN RS |
|---------------------|-------------------|------------------|
| ----- | ----- | ----- |

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

| SR. NO. | CELL | TARGET | RESPONSIBILITY | STATUS |
|---------|------|--------|----------------|--------|
| - | | | | |