

CELL:- Tensioner

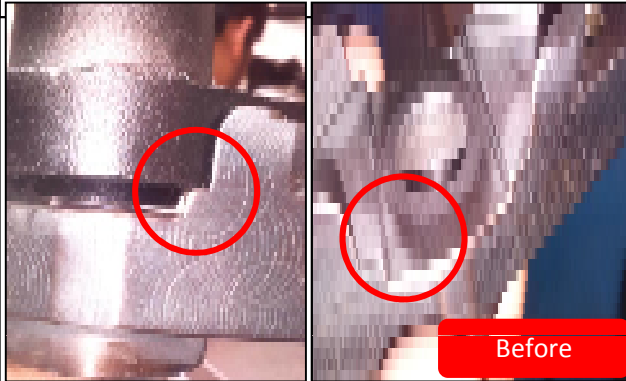
CELL NAME:- 319 Body

MACHINE / STAGE :- CNC M/C

OPERATION :- Facing & Grooving

**KAIZEN THEME :** To eliminate A319 body thickness taper spec 10±0.05 actual 10.04- 10.12 mm.

**Problem present status :-** A319 body thicknesses taper spec 10 ±0.05 actual 10.02-10.01 mm.



**IDEA :-** Relive to be provided on fixture to eliminate taper .

**COUNTERMEASURE:-**

1. Relive provided on fixture to eliminate taper defect .



<b>BENCHMARK</b>	130 no's
<b>TARGET</b>	0 no
<b>KAIZEN START</b>	5.03.2016
<b>TDC</b>	17.03.2016
<b>KAIZEN FINISH</b>	17.03.2016

**TEAM MEMBERS :** Navnath karanjkhile, santosh wakchure , Ganesh Padwalkar, Ashish jagtap, Sachin kadnar.

**BENEFITS :-**

1) In-house rejection eliminated.

**KAIZEN SUSTENANCE**

**WHAT TO DO:-** Check point added in fixture maintenance check sheet

**HOW TO DO:-** Check visually.

**FREQUENCY :-** 03 month .

**WHY - WHY ANALYSIS :-**

**Why1 :-** A319 body thickness taper.

**Why2 :-** Component get tilt after loading .

**Why3 :-** Component boss radius area rest on Fixture.

**Why 4 :-** No relive on fixture .

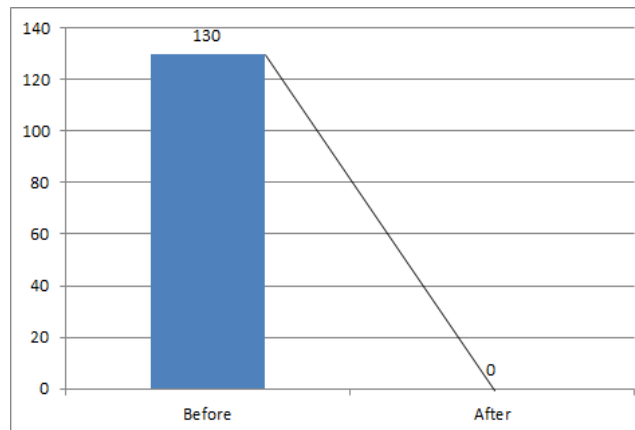
**ROOT CAUSE :** No relive on fixture

**REGISTRATION NO. & DATE : 05.03.2016**

**REGISTERED BY :-** Sachin Kadnar

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

**RESULT :-**



**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A157 A216 A208	18.3.16	Mr. santosh wachure	Completed