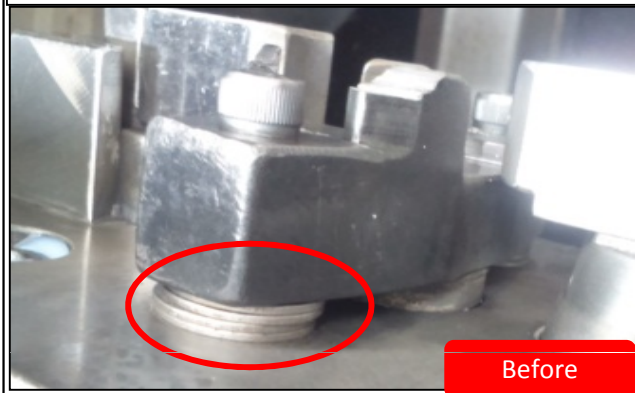


CELL:- Tensioner **CELL NAME:-** 319 Body **MACHINE / STAGE :-** CNC M/C **OPERATION :-** Facing & Grooving

KAIZEN THEME : To eliminate A319 body thickness taper spec 10±0.05 actual 10.04- 10.12 mm. **IDEA :-** Fixture to be modified Fixture Modified resting block instead of washer at same height to eliminate v

Problem present status :-
A319 body Width taper spec 10±0.05 actual 10.04- 10.12 mm.



COUNTERMEASURE:-
1. Resting Block Modified at same height.

BENCHMARK	130 no's
TARGET	0 no
KAIZEN START	5.03.2016
TDC	20.04.2016
KAIZEN FINISH	
TEAM MEMBERS :	Navnath karanjkhile, santosh wakchure , Ganesh Padwalkar, Ashish jagtap, Sachin kadnar.
BENEFITS :-	1) In-house rejection eliminated.

WHY - WHY ANALYSIS :-
Why1 :- A319 body width taper.
Why2 :- Locater height not same.
Why3 :- Washer introduced between locater & fixture .
Why4 :- Week fixture design .

RESULT :-

Awareness given to operator .

KAIZEN SUSTENANCE

WHAT TO DO:- Check point added in fixture audit check sheet .

HOW TO DO:- Check visually.

FREQUENCY :- Alternate day .

ROOT CAUSE : Week fixture design .

REGISTRATION NO. & DATE : 05.03.2016

REGISTERED BY :- Sachin Kadnar

MANAGER'S SIGN :- Sunil Kinkar

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	All Tensioner	TARGET	Mr. Navnath	Pending