

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

CELL :-A362 | CELL NAME:- A362 Decomp | MACHINE / STAGE :- Toggle press. | OPERATION :- Pin pressing

KAIZEN THEME : To eliminate rejection of wrong pin pressing.

IDEA :- Change the fixture design.

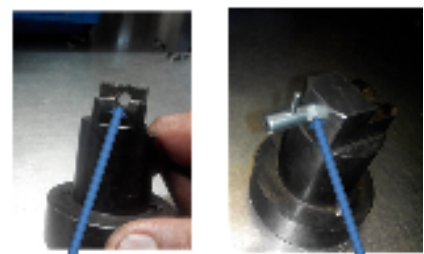
WIDELY/DEEPLY:-

Countermeasure :- Prevention Pokayoka implemented : Design of fixture changed & this is made with D shape at roller insertion stage.

PROBLEM / PRESENT STATUS :- 5 no's found having wrong pin pressing.



BEFORE



Roll of D shape provided in the roller to avoid the wrong insertion of roller in fixture during pin pressing

AFTER

BENCHMARK	62 No.
TARGET	0 No.
KAIZEN START	12.12.2014
KAIZEN FINISH	20.01.2015

TEAM MEMBERS :-
Nitin Sutar,
Sandip Patil

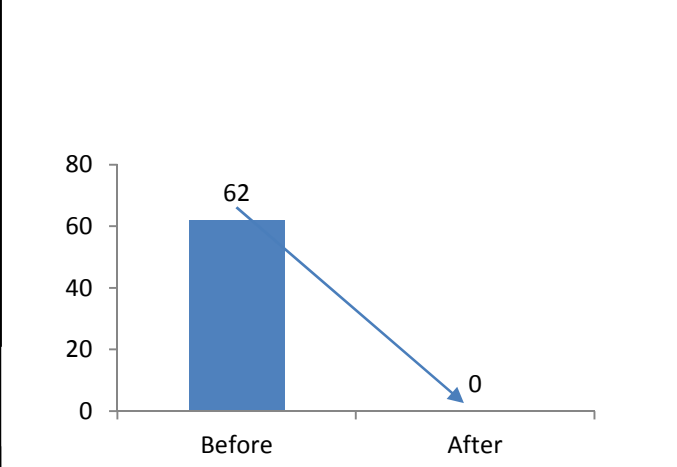
BENEFITS :-

1. Eliminate the wrong pin pressing defect
2. Reduce COPQ.

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why 1 – A362 pin pressing wrong side in roller.
Why 2 – Roller insert in wrong side on fixture.
Why 3 – Stopper used to arrest D'milling of roller is becomes loose.
Why 4 – Design of stopper in fixture is allow to pass the roller in wrong side.
Why 5 - Design of fixture is weak.

RESULT :-



WHAT TO DO: Irreversible.
HOW TO DO: -
FREQUENCY :- - One time activity

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
2000	-----	2000

ROOT CAUSE :- Design of fixture is weak

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTRATION NO. & DATE:12.12.2014

REGISTERED BY :- Sandeep Patil

MANAGER'S SIGN :- Sunil Kinkar

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
01	A317	30.01.15	Sandeep Patil	Completed 1