
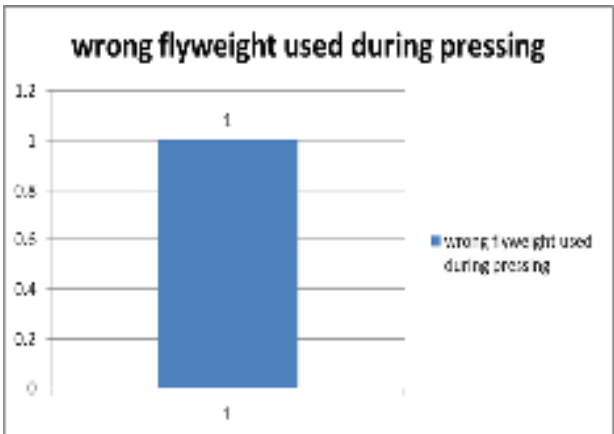


		TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET KAIZEN NO:-01																												
		TPM CIRCLE NAME :	LOSS NO. / STEP	P	Q	DEF:- A	C	D	S	M																														
		DEPT :-M/c Shop QA	RESULT AREA																																					
CELL :-A401	CELL NAME:-Tensioner Assy.	MACHINE / STAGE :Roller Pressing						OPERATION :-Roller Pressing																																
KAIZEN THEME To prevent Occurance of wrong flyweight used during roller pressing ,in A 401 flyweight assembly WIDELY/DEEPLY:- PROBLEM / PRESENT STATUS :- In decompression unit wrong flyweight used during pressing .i.e. A261 Flyweight used in A401 assy.		IDEA :- 1) On pressing fixture model wise flyweight locating cavity to be provided to avoid wrong pressing of flyweight. COUNTERMEASURE:- <ol style="list-style-type: none"> Both flyweight location in stores changed, Keep apart from each other Identification mark started on decompression flyweight after assy. Awareness given to operator & inspector regarding flyweight mix up issue.& each master sample displayed online with identification. Preventive type pokayoka to be implement: On pressing fixture model wise flyweight locating cavity to be provided to avoid wrong pressing of flyweight. 						<table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>BENCHMARK</td><td>1 No.</td></tr> <tr><td>TARGET</td><td>0 No.</td></tr> <tr><td>KAIZEN START</td><td>14.07.2014</td></tr> <tr><td>KAIZEN FINISH</td><td>29.08.2014</td></tr> <tr><td colspan="2">TEAM MEMBERS :-</td></tr> <tr><td colspan="2">Sandeep ,samadhan,Sunil</td></tr> <tr><td colspan="2">BENEFITS :-</td></tr> <tr><td colspan="2">1)No production loss</td></tr> <tr><td colspan="2">2) No Supplier Rejection</td></tr> <tr><td colspan="2">3)No customer complaint</td></tr> <tr><td colspan="2" style="text-align: center;">KAIZEN SUSTENANCE</td></tr> <tr><td colspan="2">WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram</td></tr> <tr><td colspan="2">HOW TO DO : Verify the action plan -</td></tr> <tr><td colspan="2">FREQUENCY – As Per supplier Audit plan.</td></tr> </table>					BENCHMARK	1 No.	TARGET	0 No.	KAIZEN START	14.07.2014	KAIZEN FINISH	29.08.2014	TEAM MEMBERS :-		Sandeep ,samadhan,Sunil		BENEFITS :-		1)No production loss		2) No Supplier Rejection		3)No customer complaint		KAIZEN SUSTENANCE		WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram		HOW TO DO : Verify the action plan -		FREQUENCY – As Per supplier Audit plan.	
BENCHMARK	1 No.																																							
TARGET	0 No.																																							
KAIZEN START	14.07.2014																																							
KAIZEN FINISH	29.08.2014																																							
TEAM MEMBERS :-																																								
Sandeep ,samadhan,Sunil																																								
BENEFITS :-																																								
1)No production loss																																								
2) No Supplier Rejection																																								
3)No customer complaint																																								
KAIZEN SUSTENANCE																																								
WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram																																								
HOW TO DO : Verify the action plan -																																								
FREQUENCY – As Per supplier Audit plan.																																								
 <div style="display: flex; justify-content: space-around; margin-top: 5px;"> BEFORE AFTER </div>		RESULT :- 						<table border="1" style="width:100%; border-collapse: collapse;"> <tr><th colspan="3" style="text-align: center;">COST INCURRED FOR MAKING KAIZEN</th></tr> <tr> <th>MATERIAL COST IN RS</th> <th>LABOUR COST IN RS</th> <th>TOTAL COST IN RS</th> </tr> <tr> <td style="text-align: center;">-----</td> <td style="text-align: center;">-----</td> <td style="text-align: center;">-----</td> </tr> <tr><th colspan="3" style="text-align: center;">SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT</th></tr> <tr> <th>SR. NO.</th> <th>CELL</th> <th>TARGET</th> <th>RESPONSIBILITY</th> <th>STATUS</th> </tr> <tr> <td style="text-align: center;">1</td> <td>A209,A401</td> <td style="text-align: center;">08.09.14</td> <td>Mr. Samadhan</td> <td style="text-align: center;">inprocess</td> </tr> </table>					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	1	A209,A401	08.09.14	Mr. Samadhan	inprocess						
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																																				
1	A209,A401	08.09.14	Mr. Samadhan	inprocess																																				
WHY - WHY ANALYSIS :- Why 1: Cam com decompression angle found not ok at customer end.(Required angle 30° observed 56°20') Why 2: Wrong model flyweight mix up(A261 Flyweight used in A401 assy.during roller pressing. Why 3: Existing process allow to produce such type of parts Why4: No preventive type pokayoka to produce such type of part.																																								
ROOT CAUSE : No preventive type pokayoka to produce such type of part																																								
REGISTRATION NO &DATE: 14.07.2014																																								
REGISTERED BY :- Sandeep Jadhav																																								
MANAGER'S SIGN :- Sunil Kinkar																																								