

CELL :- A261 CELL NAME:- Flyweight MACHINE / STAGE :- Drilling /VMC OPERATION :- Reaming

KAIZEN THEME –To eliminate A261 Fly weight Perpendicularity NG.

IDEA :- Clamp design to be modified for even clamping for both side.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS –A261 Fly weight Perpendicularity NG spec 0.015mm, Actual 0.1mm .

COUNTERMEASURE: 1)Clamping pad modified with even resting surface.2) Separate clamp used for A261 & A209 Flyweight.3)Dimension maintain in sintered.

BENCHMARK	5518 No.
TARGET	0 No.
KAIZEN START	10.12.2014
TARGET DATE	08.1.2015
KAIZEN FINISH	13.1.2015

TEAM MEMBERS :- v
 Ajit dekar , Umesh pimple ,
 Vijay Walunj ,Nitin sutar

- BENEFITS :-**
1. Prevent Re-occurrence Defect.
 2. Reduce COPQ.



Clamping pad wear out

BEFORE

Design changed & new clamping pad provided

Identification done on clamp

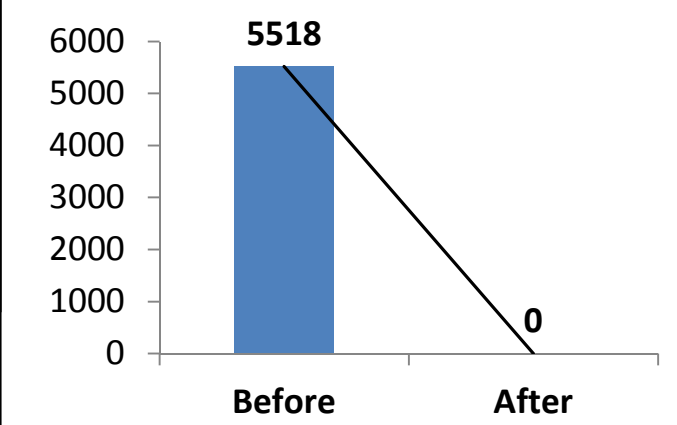
AFTER

KAIZEN SUSTENANCE

WHAT TO DO- Check point added in fixture maintenance check sheet .
HOW TO DO: By checking
FREQUENCY : As per J & F PM plan

WHY - WHY ANALYSIS :-
Why 1 – A261 Fly weight Perpendicularity NG.
Why 2 – Reaming operation not perpendicular to resting face.
Why:3 - Resting face inclined wrt reamer axis.
Why 4: After clamping part gets tilt.
Why 5 – Uneven clamping due to weak clamp design .

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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ROOT CAUSE- -Uneven clamping due to weak clamp design .

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	Flyweight A209	13.1.15	Ajeet Deokar	Completed

REGISTRATION NO. & DATE:- 10.12.2014

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar