

CELL :- A361 L CELL NAME:- Lever MACHINE / STAGE :- VMC OPERATION :- Drilling.

KAIZEN THEME –To avoid Neutral position NG (At assembly stage neutral position NG) .

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS –Neutral position NG (At assembly stage neutral position NG) .



Manual Clamping

BEFORE

IDEA :- Hydraulic clamping to be provided to avoid dia 2.3 hole shift .

COUNTERMEASURE:1) Hydraulic clamping to be provided 2) Training given to operator

BENCHMARK	473No.
TARGET	0 No.
KAIZEN START	15.07.2014
TARGET DATE	04.06.2015
KAIZEN FINISH	

TEAM MEMBERS :-
Umesh Pimple, Ajit Deokar
Ganesh Padwalkar ,Vijay Walunj

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

KAIZEN SUSTENANCE

WHAT TO DO- Point to be added in Fixture maintenance check sheet .
HOW TO DO: Audit
FREQUENCY : Alternate Day

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-	A294 Sector	25.05.15	Mr.Ajeet Deokar	In-Process

WHY - WHY ANALYSIS :-

Why 1 – Neutral position NG (After assembly stage neutral position NG) .

Why 2 – During drilling part get vibrate .

Why 3 –Clamping in complete .

Why 4 –Current process allows in complete clamping .(Manual clamping)

ROOT CAUSE- –Current process allows in complete clamping .

REGISTRATION NO. & DATE:- 15.07.2014

REGISTERED BY :- Ganesh Padwalkar

MANAGER’S SIGN :- Sunil kinkar

RESULT :-

Currently 100 % inspection with relation gauge