

CELL :- A211 CELL NAME:- Tensioner MACHINE / STAGE :- SPM OPERATION : Drilling

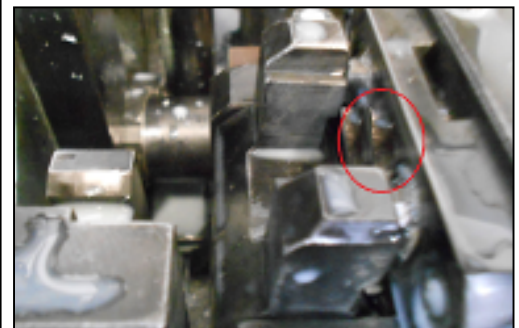
KAIZEN THEME -To avoid A211 Body Dia 2.5 shift

IDEA :- 1) Resting plate to be added in fixture to avoid wrong loading

WIDELY/DEEPLY:-

COUNTERMEASURE:- 1) Resting plate added in fixture to avoid wrong loading

PROBLEM / PRESENT STATUS -6 No's -A247 BKT Dia 4.2 Depth through out. Spec 14.5±0.2 & actual through out .(Setting rejection)



No guide plate

BEFORE

Guide plate

AFTER

WHY - WHY ANALYSIS :-
Why 1 – A211 Body Dia 2.5 shift .
Why 2 –During loading part get shift downward side & part clamp .
Why 3 – During loading operator should be load part in pin .but by mistake operator loading not properly
Why 4 –Current process allowed to wrong loading & No pokayoka to avoid wrong loading

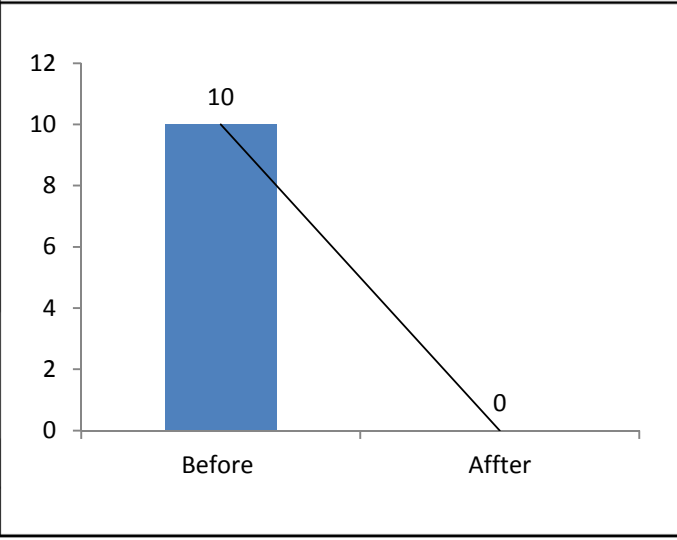
ROOT CAUSE- Current process allowed to wrong loading & No pokayoka to avoid wrong loading

REGISTRATION NO. & DATE:- 25.08.2014.

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar

RESULT :-



BENCHMARK	10 No.
TARGET	0 No.
KAIZEN START	25.08.2014
KAIZEN FINISH	09.09.2014

TEAM MEMBERS :-
 Nitin sutar , Umesh pimple

- BENEFITS :-**
1. Prevent Re-occurrence of Customer Complaint.
 2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO-Check point added in Action sustain check sheet
HOW TO DO: By Auditing
FREQUENCY : once in week

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
---			Not Applicable	