

CELL :-Assembly CELL NAME:-A271/A337 MACHINE / STAGE :- Free rotation & flushing OPERATION :-Free rotation
KAIZEN THEME :-Productivity improvement **IDEA :-** improve process

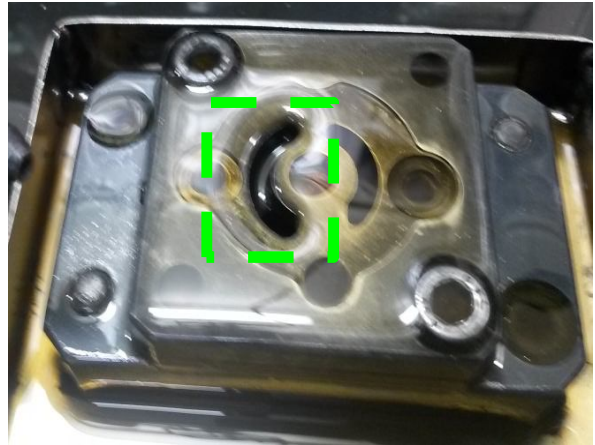
WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :-Free rotation RPM NG due to the accumulation of flushed oil on fixture of previous cycle.



BEFORE

COUNTERMEASURE:- Provided a pilot operated NRV to drain the flushed oil after every cycle.



AFTER

Why1:-Provided a pilot operated NRV
Why2:-Actual rpm not reaching .
Why3:-Flushed oil restricting the speed of the gear
Why4:-No air gap for gear rotation

RESULT :-
 1.Productivity improved

ROOT CAUSE :-

REGISTRATION NO. & DATE : 669 & 16.05.16
REGISTERED BY :- Mr.Pawan
MANAGER'S SIGN :- Mr.Sivasankar.G

| | |
|----------------------|---------|
| BENCHMARK | 0 No. |
| TARGET | 0 No. |
| KAIZEN START | 16.5.15 |
| KAIZEN FINISH | 16.5.15 |

TEAM MEMBERS :-
 Mr.Pawan
 Mr.Dinesh

BENEFITS :-
 1.Productivity improved

KAIZEN SUSTENANCE

WHAT TO DO.
HOW TO DO:
FREQUENCY one time action

COST INCURRED

| MATERIAL COST IN RS | LABOUR COST IN RS | TOTAL COST IN RS |
|---------------------|-------------------|------------------|
| 2934 | | 2934 |

HORIZONTAL DEPLOYMENT

| SR. NO. | CELL | TARGET | RESPONSIBILITY | STATUS |
|---------|------|--------|----------------|--------|
| | | | | |