

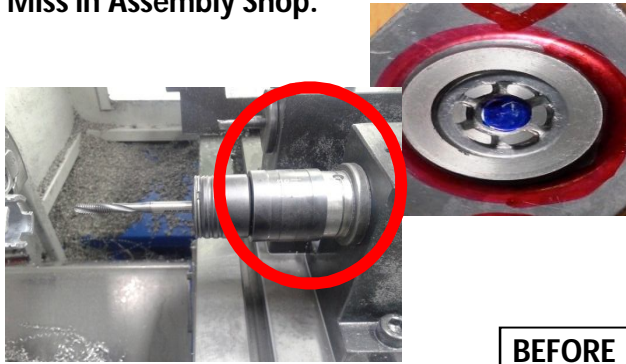
TPM CIRCLE NO :- 1	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Josh	LOSS NO. / STEP								
DEPT :- Maintenance	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :- A128      CELL NAME :- Tensioner Machining      MACHINE / STAGE :- A128 Tensioner Machining Line      OPERATION :- CNC Machining

**KAIZEN THEME :** To Prevent defect of M6 Thread miss in Tensioner Body during Machining.

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-** 1 No. Tensioner Body observed with M6 Thread Miss in Assembly Shop.



BEFORE

**IDEA :-** No Flash on pre-cast hole.

**COUNTERMEASURE:-** Provided interfacing on CNC Machine by providing Sensor so-that such NG Piece captured on Machine itself.



AFTER

<b>BENCHMARK</b>	1 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	14.05.2014
<b>KAIZEN FINISH</b>	12.06.2014

**TEAM MEMBERS :-**  
 Dinesh Kumar  
 Sivashankar G.  
**BENEFITS :-**

1. Prevent Potential Customer Complaint.
2. Reduce COPO.

**KAIZEN SUSTENANCE**

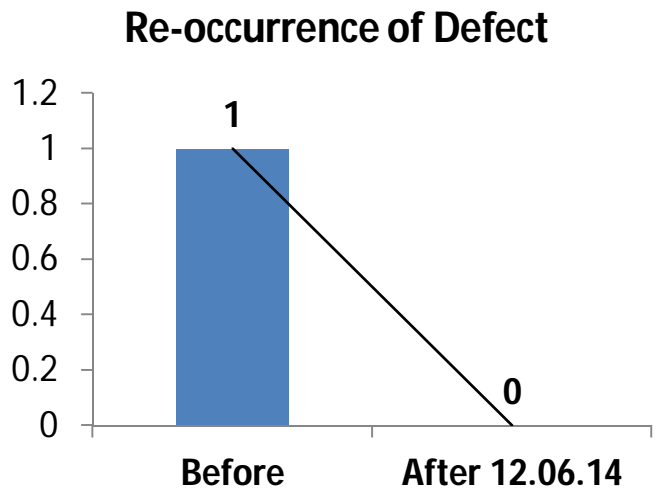
**WHAT TO DO:** Added JH Check point  
**HOW TO DO:** As per JH Checkpoint.  
**FREQUENCY :** Daily start of Shift.

**WHY - WHY ANALYSIS :-**  
**Why1:** M6 Thread Miss in Tensioner Body.  
**Why2:** M6 Threading not done by M6 Tap  
**Why3:** M6 Tap gone for Tapping and without Tapping come back in Home Position.  
**Why4:** Heavy Flash on pre-cast hole.

**ROOT CAUSE :-** Heavy Flash on pre-cast hole.

**REGISTRATION NO. & DATE :** 81 & 12.06.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** A.Shaivashankar

**RESULT :-**



<b>COST INCURRED FOR MAKING KAIZEN</b>		
<b>MATERIAL COST</b>	<b>LABOUR COST</b>	<b>TOTAL COST</b>
IN RS	IN RS	IN RS
1000/-	-----	1000/-

<b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b>				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	2 <sup>nd</sup> Cell	30.06.14	Shankar	In-Process