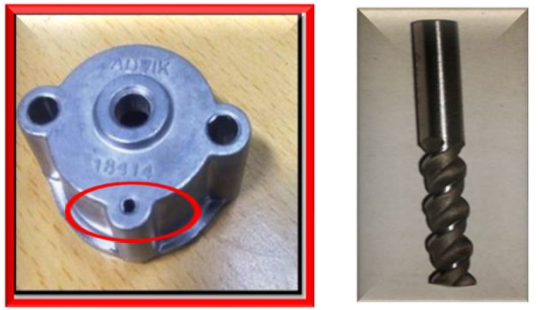


CELL : A271	CELL NAME:- Oil Pump	MACHINE / STAGE :- Brother/ Machining	OPERATION :- Operation No. 10
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KAIZEN THEME : To Reduce the cycle time in A271 oil pump body machining cell.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- :- We are doing Ø2.5 drilling operation at machining stage for removing of flash burr in casting Ø2.5 free hole & cycle time is 37 sec/Component.

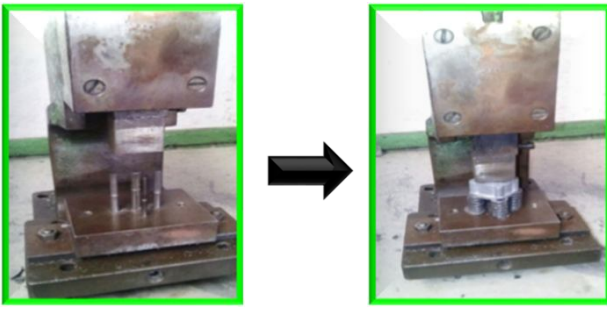


BEFORE

IDEA :- Eliminate the drilling operation at machining stage & Provision to be done at supplier end for removing of flash buss in casting free hole.

COUNTERMEASURE :- Eliminated drilling operation at machining stage & Provision done at supplier end for removing of flash buss in casting free hole & cycle time is 35 sec/ component.

Piercing tool & Pin implemented for Flash removal at supplier end



AFTER

BENCHMARK	37 Sec
TARGET	35 Sec
KAIZEN START	01.05.15
KAIZEN FINISH	01.11.15

TEAM MEMBERS :-
N.S.Pujari, Praveen, Datta

- BENEFITS :-**
1. Productivity increase per shift from 634 Nos to 670 Nos
 2. Save cost INR 376/Annum.
 3. Save tool changing time 176min/Annum.

KAIZEN SUSTENANCE

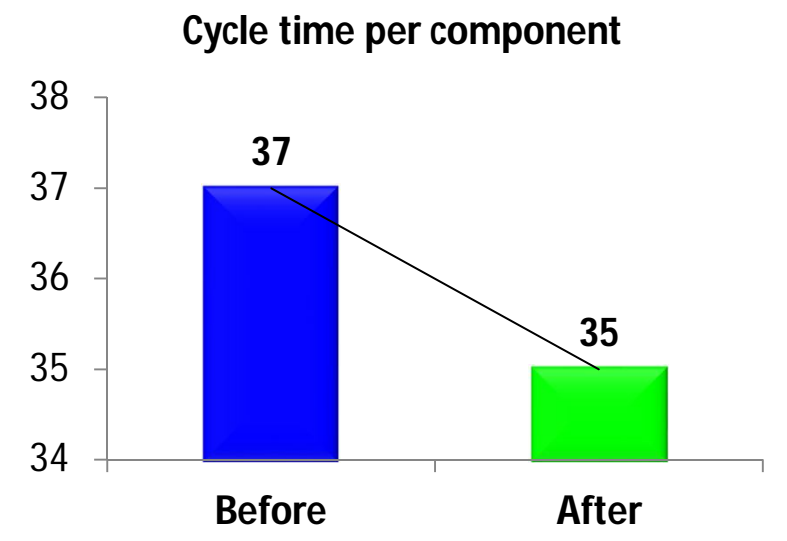
WHAT TO DO: Changed the Tooling Master List & Process Documents.
HOW TO DO:-----
FREQUENCY : 1 Time activity

WHY - WHY ANALYSIS :-
Why1 : Cycle time is 37 sec /component.
Why 2 : Additional Ø2.5 drilling operation at machining stage.
Why 3 : To removing of flash burr in casting Ø2.5 free hole .
Why 4 : No Provision at supplier end.

ROOT CAUSE :- No Provision at supplier end.

REGISTRATION NO. & DATE: 894 & 30.11.15
REGISTERED BY :- Mr. N.S Pujari
MANAGER'S SIGN :- N.S.Pujari

RESULT :-



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
1.	-----	-----	-----	-----

CELL : A177	CELL NAME:- Oil Pump	MACHINE / STAGE :- Clearance/ Assembly	OPERATION :- Operation No. 40
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KAIZEN THEME : To arrest the back facing operation miss of A177 oil pump body.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- In case of back facing operation miss at machining state or operator visual inspection skip, no poka yoke at assembly to arrest NG component.



BEFORE

IDEA :- Poka yoke to be provide at machining or assembly stage

COUNTERMEASURE :- Poka yoke Provided at assembly stage , if in case of back facing operation miss at machining stage it will arrest at clearance checking stage in assembly .



AFTER

If back facing operation miss component kept in clearance machine it will give buzzer because clearance come not ok due to gap at resting like shown if fig.

BENCHMARK	1 Nos
TARGET	Zero
KAIZEN START	26.11.15
KAIZEN FINISH	27.11.15

TEAM MEMBERS :-
Mr. Shanth Kumar Mr. Pramod

BENEFITS :-
1. Prevent customer complaint.

KAIZEN SUSTENANCE

WHAT TO DO : Irreversible.
HOW TO DO:------
FREQUENCY : 1 Time activity

WHY - WHY ANALYSIS :-
Why1 : May customer complaint of back facing operation miss .
Why2 : No Provision at machining & assembly stage to arrest back facing operation miss .
Why3 : No Poka yoke at machining & assembly stage

ROOT CAUSE :- No Poka yoke at machining & assembly stage

REGISTRATION NO. & DATE: 928 & 30.11.15
REGISTERED BY :- Shantha Kumar
MANAGER'S SIGN :- N.S.Pujari

RESULT :-

By luck no customer complaint of back facing Operation miss

Prevent may happen customer complaint by doing improvement

COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
80	40	120

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO	CELL	TARGET	RESPONSIBILITY	STATUS
1.	-----	-----	-----	-----.