

CELL :- A315 **CELL NAME:-** Oil Pump **MACHINE / STAGE:-** Supplier End(ACMA) **OPERATION :-** Casting

KAIZEN THEME :-To Reduce the % of Blow Holes In A315 Casting .

IDEA :- Robust Design of Runner & Gate.

WIDELY/DEEPLY:-

COUNTERMEASURE:1) 1)To improve the design of Gate By changing the Gate design From Split Type To Fan Type.

PROBLEM / PRESENT STATUS: 16 % of A315Casting Found with Blow Holes After Machining.



BEFORE



AFTER

BENCHMARK	22%
TARGET	2%
KAIZEN START	20/09/2015
KAIZEN FINISH	28/02/2015

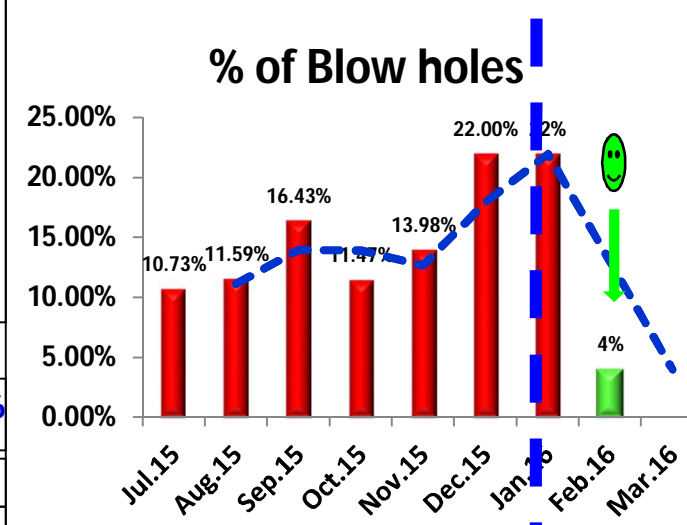
TEAM MEMBERS :-
Mr. Datta.pandre
Mr. Muniraj.(ACMA)

BENEFITS :-
1. Increase RFT

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why 1 : 15233 No's A315 Casting Body .Found With Blow Holes after machining.
Why 2 : Air Entrapped in cavity.
Why 3 : Insufficient Material Flow.
Why4 : Weak Design Of Runner & Gate.
ROOT CAUSE :-Weak Design Of Runner & Gate.

RESULT :-



Non- Reversible

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	1500	1500

REGISTRATION NO. & DATE:1039&29/02/2016

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	Supplier	TARGET	RESPONSIBILITY	STATUS
-	Matrix	22/09/2016	Datta	Completed

REGISTERED BY :- Guru
MANAGER'S SIGN :- Mr. Vijay Kumar