

TPM CIRCLE NO :- 01	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Challengers	LOSS NO. / STEP								
DEPT :-QA	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :- A315	CELL NAME:- Oil Pump	MACHINE / STAGE:- Supplier End(ACMA)	OPERATION :- Casting
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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.	BENCHMARK	22%
		TARGET	3%
		KAIZEN START	20/09/2015
		KAIZEN FINISH	28/02/2015

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



BEFORE



AFTER

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

1. Increase OEE
2. Increase Quality Rating
3. Reducing Man Power Cost
4. Reducing tooling cost

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.

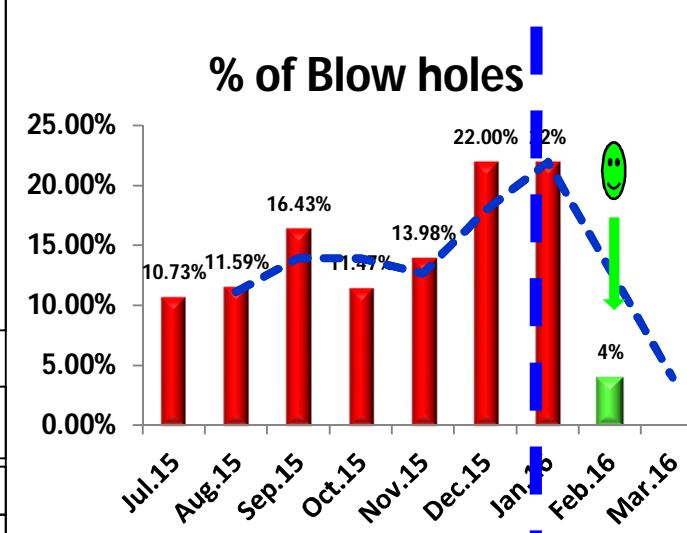
ROOT CAUSE :-Weak Design Of Runner & Gate.

REGISTRATION NO. & DATE: 1309 , 29.02.16

REGISTERED BY :- Guru

MANAGER'S SIGN :- Mr. Vijay Kumar

RESULT :-



WHAT TO DO :- To Revise the Tool Drawing

HOW TO DO : As Per Revised Drawing.

FREQUENCY :100%

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.	Supplier	TARGET	RESPONSIBILITY	STATUS
-	Matrix	Next Tool	Narsaram	