| | | TRA AIRAI F.N.O. A4 | | L A OTTIVITY | 1717 | 0.5 | D. 4 | | Louis | OT | D | For | | | | | | |
|--|---------|--|-----------------|--|------|-----|--------|------------|------------|----|------------------------------------|---|---|-----------|--------|--------|--|--|
| A DVIIZ | D1/ | TPM CIRCLE NO :- 01 TPM CIRCLE NAME : Challe | | ACTIVITY LOSS NO. / STEP | KK | QM | PM | JH | SHE | ОТ | DM | E& I | ŀΚΔ17⊑ | IN IDE | IN CHI | FFT | | |
| ADVIK | F 14 | DEPT :-QA | rigers | RESULT AREA | P | 0 | DEF :- | Δ | С | D | S | М | ╎╵Ѵ╲╽᠘┖ | .IN IUL | | | | |
| CELL :- A315 | CELI | L NAME:- Oil Pump | MAC | HINE / STAGE:- Supplie | | | | | + ۲ | | - | | Casting | | | | | |
| KAIZEN THEME:-To Reduce the % of Blow Holes In A315 Casting. | | | | IDEA :- Robust Design of Runner & Gate. | | | | | | | | | | | | | | |
| | | | | COLUMN TERM TARGET AL ALTER AND A STATE OF THE ALLER AND A STATE OF THE | | | | | | | | BENCHMARK 22% | | | | | | |
| WIDELY/DEEPLY:- | | | | COUNTERMEASURE:1) 1)To improve the design | | | | | | | | | TARGET 3% KAIZEN START 20/09/2015 | | | | | |
| | | | | of Gate By changing the Gate design From Split | | | | | | | | KAIZEN START 20/09/2015 KAIZEN FINISH 28/02/2015 | | | | | | |
| PROBLEM / PRESENT STATUS: 16 % of | | | | Type To Fan Type. | | | | | | | | 100 02/ 2013 | | | | | | |
| A315Casting Found with Blow Holes After | | | | | | | | | | | | TEAM MEMBERS :- | | | | | | |
| Machining. | | | | 0 | 0- | O | | | | | | | andre | | | | | |
| (2. S) | | | | | | | | | | | | Mr. Muniraj.(ACMA) | | | | | | |
| BEFORE | | | | COLUMN TO THE REAL PROPERTY OF THE PARTY OF | | | | | | | BENEFITS :- | | | | | | | |
| | | | | | | | | | | | | 1. Increase OEE | | | | | | |
| | | | | | | | | | | | | 2. Increase Quality Rating | | | | | | |
| | | | | | | | | | | | | 3. Reducing Man Power Cost | | | | | | |
| | | | | | | | | | | | | 4. Reducing tooling cost | | | | | | |
| | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | KAIZEN SUSTENANCE | | | | | | |
| | | | | AFTER | | | | | | | | | | | | | | |
| WHY - WHY ANALYSIS :- | | | | RESULT :- | | | | | | | | WHAT TO DO : - To Revise the Tool Drawing | | | | | | |
| Why 1: 15233 No's A315 Casting Body .Found | | | | | | | | | | | | | | | | | | |
| With Blow Holes after machining. | | | 0/ 601 | | | | | | | | HOW TO DO: As Per Revised Drawing. | | | | | | | |
| Why 2: Air Entrapped in cavity. | | | % of Blow holes | | | | | | | | FREQUENCY:100% | | | | | | | |
| Why 3: Insufficient Material Flow. | | | | 25.00% 7 | | | | | | | | | | | | | | |
| Why4: Weak De | esign | Of Runner & Gate. | | | | 22 | 2.00% | 2% | | | | | | | | | | |
| | | | 20.0 | 0% - 16.43% | | | | F . | lacksquare | | | | | | | | | |
| | | | | 15.00% 13.98% 10.73% 11.59% 171.77% 10.00% 4% 0.00% 4% 0.00% 10.73% 12.50% 0ct. 12.70% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 10.73% 11.59% 15.00% 15.00% 10.73% 11.59% 15.00% | | | | | | | | COST INCURRED FOR MAKING KAIZEN | | | | | | |
| | | | | | | | | | | | | MATERIAL COST LABOUR COST TOTAL COST | | | | | | |
| | | | | | | | | | | | | IN RS IN RS IN RS | | | | | | |
| ROOT CAUSE:-Weak Design Of Runner & Gate. | | | | | | | | | | | | | | | | | | |
| REGISTRATION NO. & DATE: 1309, 29.02.16 | | | | | | | | | | | | SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT | | | | | | |
| REGISTERED BY :- Guru | | | | | | | | | | | | lier | TARGET | RESPONSIE | BILITY | STATUS | | |
| MANAGER'S SIGN :- Mr. Vijay Kumar | | | | in bing sex oc | 40, | Des | 19, | ter | Ma | - | Mat | rix N | lext Tool | Narsara | am | | | |
| IVIANAGER'S SI | GN :- I | ıvır. Vijay Kumar | | | | | | | | | | | | | | | | |