

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

CELL :-A247 CELL NAME:- CBS assly. MACHINE / STAGE :- RIVETING MACHINE . OPERATION :- RIVETING OPERATION

KAIZEN THEME : TO STRENGTHEN THE SYSTEM FOR EQUALIZER LUG OPEN ISSUE REPORTED BY CUSTOMER.

WIDELY/DEEPLY:-

PROBLEM:- POSSIBILITY OF EQUALIZER LUG OPEN PARTS WITH EARLIER RIVETING FIXTURE.



BEFORE

IDEA :- GAP REDUCED BETWEEN BLOCK AND EQUALIZER.

COUNTERMEASURE:- RIVETING FIXTURE BLOCK PROFILE CHANGE(STEP CREATED).



AFTER

WHY - WHY ANALYSIS :-

- Why 1:** POSSIBILITY OF NG PART(EQUALIZER LUG OPEN) OUTFLOW TO SUBSEQUENT PROCESS.
- Why 2:** RIVETING FIXTURE ALLOWED THE SAME PART.
- Why 3:** GAP BETWEEN THE EQUALIZER AND FIXTURE BLOCK
- Why 4:**
- Why 5:**

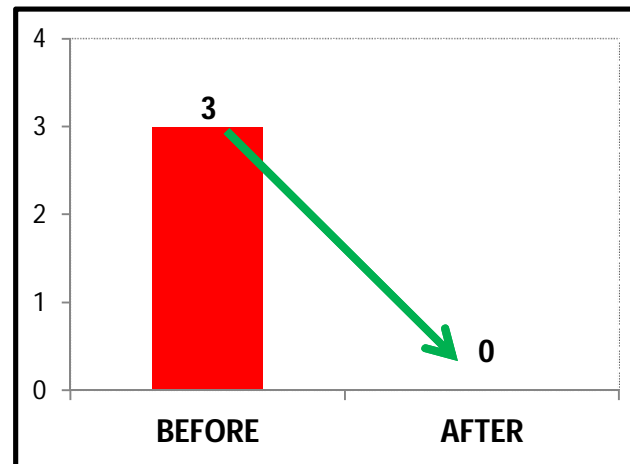
ROOT CAUSE :- GAP BETWEEN EQUALIZER AND FIXTURE BLOCK.

REGISTRATION NO. & DATE: 10.02.2016

REGISTERED BY :- BALWINDER MOR

MANAGER'S SIGN :-PARVEEN BHAYANA

RESULT :-



| | |
|----------------------|------------|
| BENCHMARK | 3 Nos |
| TARGET | 0 Nos |
| KAIZEN START | 06.01.2016 |
| KAIZEN FINISH | 10.02.2016 |

TEAM MEMBERS :-
SANJAY KUMAR

BENEFITS :-

1. POSSIBILITY OF NG PART OUTFLOW ELIMINATED.

KAIZEN SUSTENANCE

WHAT TO DO: UPDATE THE FIXTURE VALIDATION SHEET.

HOW TO DO : VERIFY THE MODIFIED DIMENSION WITH UPDATED VALIDATION SHEET.

FREQUENCY : EVERY 2MONTH.

COST INCURRED FOR MAKING KAIZEN

| MATERIAL COST IN RS | LABOUR COST IN RS | TOTAL COST IN RS |
|------------------------|----------------------|---------------------|
| 2000 | 0 | 2000 |

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

| SR. NO. | CELL | TARGET | RESPONSIBILITY | STATUS |
|---------|---------------|----------|----------------|----------|
| 1 | A247 L1&L3 | 23.02.16 | MR SANJAY | COMPLETE |