

CELL :- A177 CELL NAME:-Oil Pump MACHINE / STAGE:- Supplier End(Addesh) OPERATION :- D-Milling

KAIZEN THEME :-To prevent the defect of Dimn 18.50-0.20 mm In A177 Control Shaft.

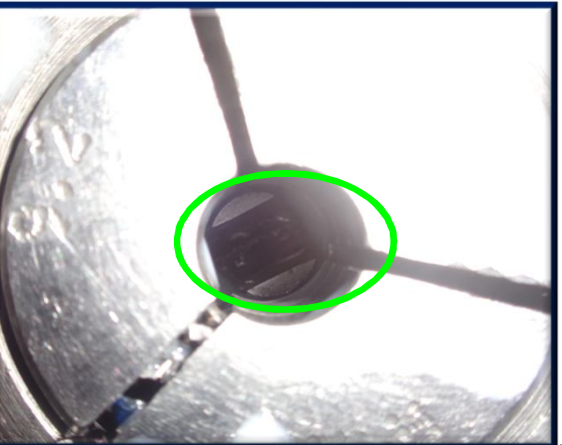
IDEA :- To Improve the Fixture Design.

BENCHMARK	1661
TARGET	0
KAIZEN START	01/09/2015
KAIZEN FINISH	20/11/2015

WIDELY/DEEPLY:-

COUNTERMEASURE:

PROBLEM / PRESENT STATUS:- 3947(998 U/s & 2949 O/s)& No's A177 Control Shaft Found with Dimn 18.50-0.20mm Under Size & Over Size.



TEAM MEMBERS :-
Mr. Datta.pandre
Mr. Nagraj.R

BENEFITS :-



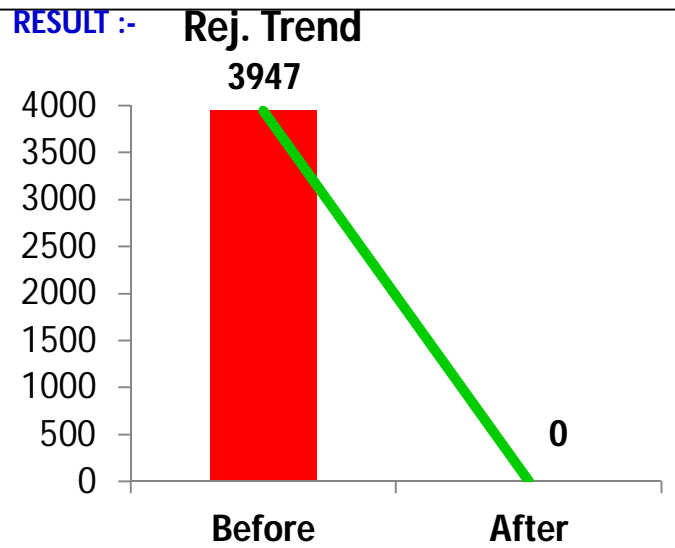
BEFORE

AFTER

1. Increase RFT

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why 1 : 3947(998 U/s & 2949 O/s)& No's A177 Control Shaft Found with Dimn 18.50-0.20mm Under Size & Over Size.
Why 2 : Part Tilt at the time of D-milling Operation.
Why 3 : Component Hold with Point Contact.
Why 4 : Part Holding Fixture Design Weak.



WHAT TO DO :- To Revise the PCP.
HOW TO DO : As Per Revised PCP.
FREQUENCY : 100%

Part Holding Fixture Design Weak.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
5000	500	5500

REG. NO. & DATE : #920 & 02/11/2015

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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REGISTERED BY :- Dattatrey Pandre

MANAGER'S SIGN :- Mr. Vijay Kumar