

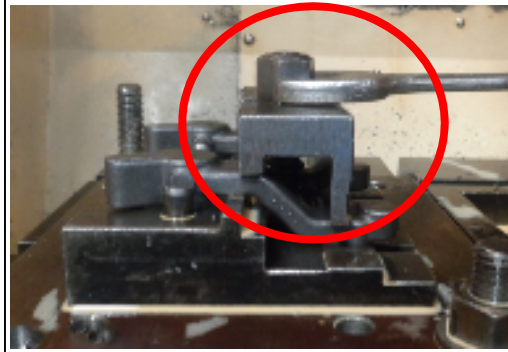
TPM CIRCLE NO :- 3	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :	LOSS NO. / STEP								
DEPT :- Q.A	RESULT AREA	P	Q	DEF:- A		C	D	S	M

CELL :- A361 Lever CELL NAME:- HG shifter MACHINE / STAGE :- VMC OPERATION :- Milling

KAIZEN THEME –To avoid A361 Lever step on milling face.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS –A361 Lever step on milling face.



BEFORE

IDEA :- Torque wrench to be provided in fixture for rigid clamping.

COUNTERMEASURE: -1) Spring washer added in fixture.
2)Torque wrench provided on line .



AFTER

WHY - WHY ANALYSIS :-
Why 1 –A361 Lever step on milling face.
Why 2 –Part get vibrates during machining.
Why 3 – Manual clamping not rigid.

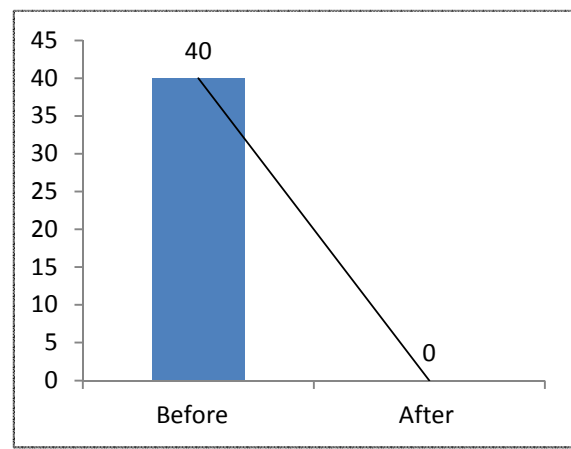
ROOT CAUSE- –Manual clamping not rigid.

REGISTRATION NO. & DATE:-25.07.2015

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar

RESULT :-



BENCHMARK	40 No.
TARGET	0 No.
KAIZEN START	30.07.2015
TARGET DATE	05.08.2015
KAIZEN FINISH	10.08.2015

TEAM MEMBERS :-
 Nitin Sutar, Umesh Pimple
 Ganesh Padwalkar, Vijay Walunj,

- BENEFITS :-**
1. Prevent Re-occurrence Defect.
 2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO- Point to be added in Sustenance check sheet .
HOW TO DO: Audit
FREQUENCY : Alternate Day

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.	CELL	TARGET	RESPONSIBILITY	STATUS
-	A419 Shaft A209 fly A215 DC	30.08.2015	Umesh Pimple	In Process