

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

KAIZEN THEME –To avoid A361 Lever Thickness 11.0 variation ,taper & step on milling face.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS –A361 Lever Thickness 11.0 variation ,taper & step on milling face.



BEFORE

IDEA :- Clamping link to be replace.

COUNTERMEASURE: -Clamping link to be replace

BENCHMARK	29 No.
TARGET	0 No.
KAIZEN START	25.07.2015
TARGET DATE	25.08.2015
KAIZEN FINISH	

TEAM MEMBERS :-
Nitin Sutar, Vasudev Rawool
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

WHY - WHY ANALYSIS :-
Why 1 – A361 Lever Thickness 11.0 variation ,taper & step on milling face.
Why 2 –part vibrate during milling operation in 2nd set up.
Why 3 – Clamping not rigid.
Why 4 – Clamping link broken

RESULT :-

Currently manual clamping fixture running.

ROOT CAUSE- –Clamping link broken

REGISTRATION NO. & DATE:-25.07.2015

REGISTERED BY :- Ganesh Padwalkar

MANAGER’S SIGN :- Sunil kinkar

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
-			NA	