

CELL :- A239 B CELL NAME:- Oil Pump MACHINE / STAGE :- VMC OPERATION :- Tripping

KAIZEN THEME –To avoid A239 Body line mark observed on Dia. 60.0

IDEA :-Procedure to be displayed on line .

WIDELY/DEEPLY:-

COUNTERMEASURE: 1) Tool loading direction corrected. Tool position marking (arrow)done on boring bar by itching.
2)OPL Display.

PROBLEM / PRESENT STATUS –A239 Body line mark observed on Dia. 60.0



BEFORE



AFTER

BENCHMARK	56 No.
TARGET	0
KAIZEN START	14.07.2015
TARGET DATE	14.07.2015
KAIZEN FINISH	14.07.2015

TEAM MEMBERS :-
Nilesh Khadke, 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

WHY - WHY ANALYSIS :-

Why 1 – A239 Body line mark observed on Dia. 60.0mm.

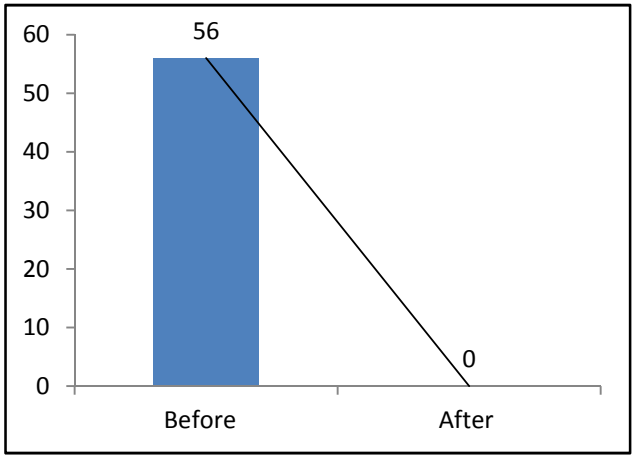
Why 2 – Line mark occur during tool homing Position.

Why 3 – Wrong direction select for tool loading.

Why 4 –No procedure displayed on line .

ROOT CAUSE- –No procedure displayed on line .

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	-----	-----

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-	A240	14.07.2015	Nilesh	C

REGISTRATION NO. & DATE:-14.07.2015

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar