

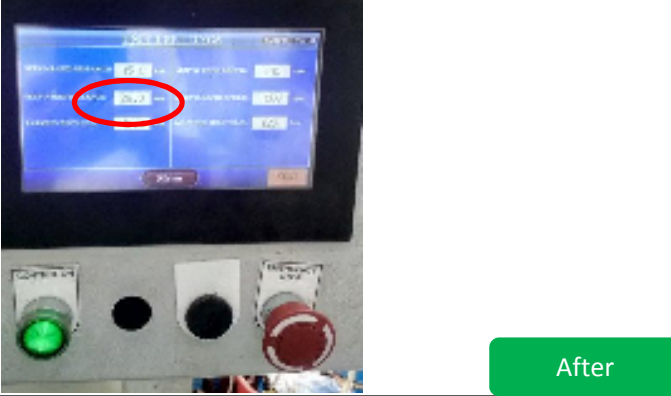
CELL:- A247 lever CELL NAME:- Bkt & lever MACHINE / STAGE :- SPM -2 OPERATION :- Drilling

KAIZEN THEME : To eliminate A247 lever 12.2-0.3 depth oversize , actual found 12.5. **IDEA :-** Poka to be implemented as lock feed rate to eliminate mistake

Problem present status :- A247 lever 12.2-0.3 depth oversize by 0.3 mm .



COUNTERMEASURE:-
 1. Feed rate to be lock to eliminate operator mistake
 2.OPL displayed on line .



BENCHMARK	31 no's
TARGET	0 no
KAIZEN START	14.03.2016
KAIZEN TDC	22.04.2016

TEAM MEMBERS : Ganesh Padwalkar, Ashish Jagtap, Navnath Karanjkhile, Santosh wachure, Sachin choudhari.

BENEFITS :-
 1) In-house rejection eliminated.

KAIZEN SUSTENANCE

WHAT TO DO:- Check point added in sustenance check sheet .

HOW TO DO:- Check part & visual check input value .

FREQUENCY :- Alternate day .

WHY - WHY ANALYSIS :-
Why1 :- A247 lever 12.2-0.3 depth oversize.
Why2 :- During offset correction value input in feed rate against parking distance .
Why3 :- Current process allows input in feed rate .
Why4 :- No Poka

ROOT CAUSE :- No Poka

REGISTRATION NO. & DATE : 14.03.2016

REGISTERED BY :- Ashish Jagtap

MANAGER'S SIGN :- Sunil Kinkar

RESULT :-

Currently 100 % check with gauge

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	NA	NA	NA	NA