

| | | | | | | | | | |
|--------------------|-----------------|----|----|---------|----|-----|----|----|-----|
| TPM CIRCLE NO :- 1 | 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 Body | CELL NAME:- | MACHINE / STAGE :-VMC | OPERATION :-Milling |
|------------------|-------------|-----------------------|---------------------|

KAIZEN THEME : To avoid 12 Nos. A361 Body chatter mark on milling face. (MCV400 –I set up ,Illrd shift)

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS - 12 Nos. A361 Body chatter mark on milling face.



BEFORE

IDEA :- Grease to be apply for insert screw when insert change .

COUNTERMEASURE:- :- 1)Grease applied for insert screw when insert change .
2) Training provided to operator .

| | |
|----------------------|------------|
| BENCHMARK | 12No. |
| TARGET | 0 No. |
| KAIZEN START | 07.07.2014 |
| KAIZEN FINISH | 07.07.2014 |

TEAM MEMBERS :-
Ganesh padwalkar
Umesh Pimple
BENEFITS :-

1. Prevent Re-occurrence of Customer Complaint.
2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO: Add Checkpoint action sustain check sheet
HOW TO DO: Checking during audit
FREQUENCY : once in week

WHY - WHY ANALYSIS :-
Why 1 – 12 Nos. A361 Body chatter mark on milling face.
Why 2 – Milling insert loose .
Why 3 – Milling insert not tight properly .
Why 4 – Milling insert tightening screw head round up .
Why 5 – Insert key slip during tightening & retightening .

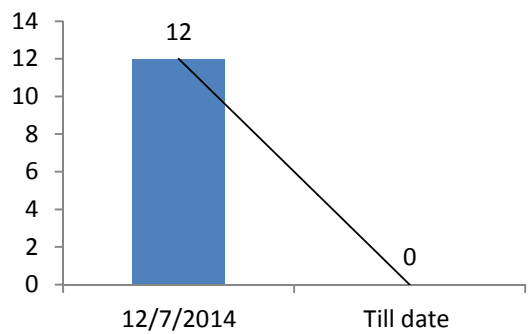
ROOT CAUSE Insert key slip during tightening & retightening

REGISTRATION NO. & DATE: 07.07.2014

REGISTERED BY :- Ganesh

MANAGER'S SIGN :- Sunil kinkar

RESULT :-



COST INCURRED FOR MAKING KAIZEN

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

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

| SR. NO. | CELL | TARGET | RESPONSIBILITY | STATUS |
|---------|------|--------|----------------|--------|
| --- | | ----- | ----- | ----- |