

CELL :- 157	CELL NAME:- Tensioner	MACHINE / STAGE :- PDC	OPERATION :- Die casting
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KAIZEN THEME –To eliminate depth variation in A157 body.

IDEA: Dimension to be control in casting.

WIDELY/DEEPLY:-

COUNTERMEASURE:1) Implement the integral pin Dia 13.5 & Dia 20.00 mm avoid the 1.7 variation & maintain the Cavity to cavity variation within 0.05 mm

PROBLEM / PRESENT STATUS –




Pin in Single step **BEFORE**

Pin in double step **AFTER**

BENCHMARK	227 No.
TARGET	0 No.
KAIZEN START	03.02.2015
TARGET DATE	22.02.15
KAIZEN FINISH	22.02.15

TEAM MEMBERS :- v
Mohan, Santosh, Krishna.
Vijay Walunj ,Nitin sutar

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

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why 1 –In A157 Body 1.2 ± 0.1 depth variation
Why 2 – As cast cavity wise 1.7 depth get variation.(1.48 – 1.85) (Spec Cavity wise variation should be within 0.05 max & actual 0.37)
Why 3 –Dimension not control in casting

RESULT :-

Under Monitoring

WHAT TO DO- Check point added in Die maintenance check sheet .
HOW TO DO: By checking
FREQUENCY : During every Die loading

ROOT CAUSE- –Dimension not control in casting.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE:- 03.02.2015

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Mohan kate

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	For all A103 Model	After getting result		

MANAGER’S SIGN :- Sunil kinkar