



TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :	LOSS NO. / STEP								
DEPT :- IQA	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

KAIZEN IDEA SHEET
KAIZEN NO:-07

CELL :-A157 CELL NAME:- .Tensioner MACHINE / STAGE :- Supplier End Mas die casting OPERATION : PDC

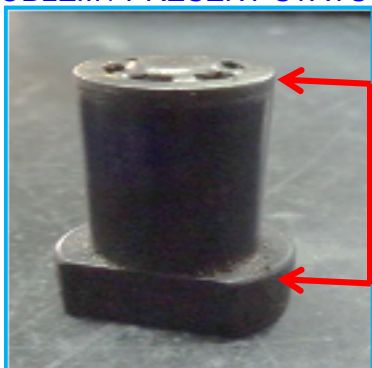
KAIZEN THEME :-To prevent In A157 Body 1.2 ± 0.1 u/s & o/s.

IDEA :-1) Cavity to cavity variation maintain within 0.05 mm (As per Drg 0.05 Max).

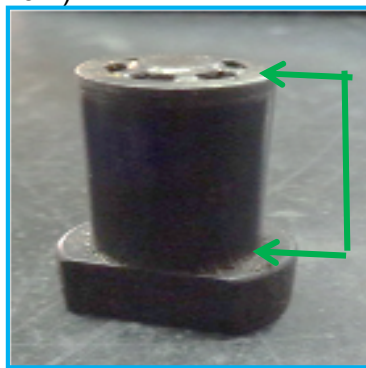
WIDELY/DEEPLY:-

COUNTERMEASURE:1) Cavity to cavity variation maintain within 0.05 mm (As per Drg 0.05 Max).

PROBLEM / PRESENT STATUS :-



BEFORE



AFTER

Why Why Analysis –
Why 1 –In A157 Body 1.2 ± 0.1 u/s & o/s.
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 maintain in casting.

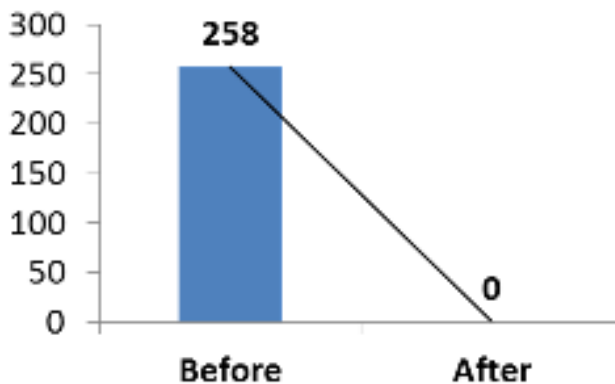
ROOT CAUSE: Dimension not maintain in casting.

REGISTRATION NO&DATE: 14.10.2014

REGISTERED BY :- Mohan Kate

MANAGER'S SIGN :- Sunil Kinkar

RESULT :-



BENCHMARK	258No.
TARGET	0 No.
KAIZEN START	14.10.2014
KAIZEN FINISH	23.10.2014

TEAM MEMBERS :-
Santosh Auti, Shedge Krishnat, Mohan Kate

- BENEFITS :-**
- 1) No Supplier Rejection for dimn 1.7
 - 2) No production loss
 - 3) No customer complaint

KAIZEN SUSTENANCE

WHAT TO DO :-
HOW TO DO : check point Add in die handover report during die loading
FREQUENCY – Every die loading.



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
1	A319 A267 CA Body	Next Tool	Mohan Kate / Sameer kolte	-----