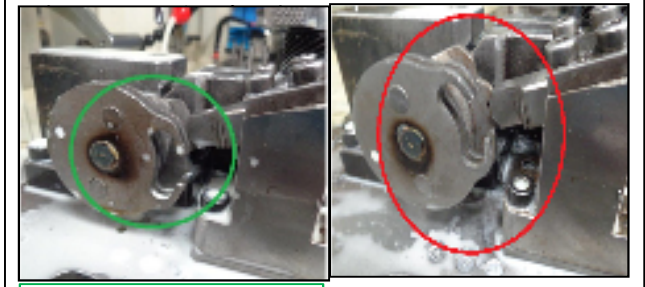


CELL :- A294 CELL NAME:- Sector MACHINE / STAGE :- Drilling OPERATION :- Drilling

KAIZEN THEME –To avoid A294 sector Dia. 4.0 hole shift

WIDELY/DEEPLY:-

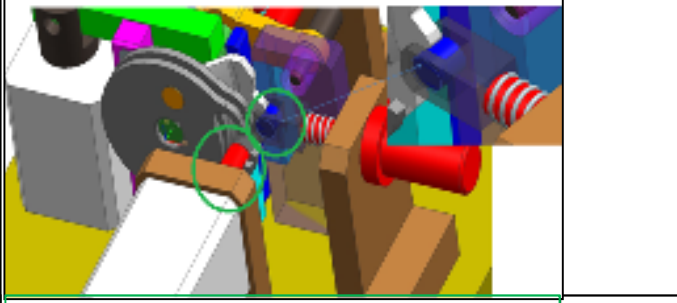
PROBLEM / PRESENT STATUS –A294 sector Dia. 4.0 hole shift spec 49.4 degree ±20 minute actual observed 30



Position ok Position NG **BEFORE**

IDEA :- 1) Poka yoke to be implemented (Guide plate to be provided on fixture to avoid wrong loading Restrict anti clockwise wrong load direction)

COUNTERMEASURE: 1) Poka yoke to be implemented (Locking arrangement to be provided on fixture to avoid wrong loading Restrict as a anti clockwise)



Fixture to be modified to avoid wrong loading . **AFTER**

BENCHMARK	25 No.
TARGET	0 No.
KAIZEN START	25.12.2014
TARGET DATE	5.3.2015/25.5.2015
KAIZEN FINISH	

TEAM MEMBERS :-
Ajit Devkar, 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

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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WHY - WHY ANALYSIS :-
Why 1 – A294 sector Dia.4.0 Hole shift.
Why 2 – Part load at wrong position for Dia.4.0 hole operation.
Why 3 – Poka

RESULT :-

Currently fixed operator & awareness given to operator

ROOT CAUSE- –Poka

REGISTRATION NO. & DATE:- 25.12.2014

REGISTERED BY :- Ganesh Padwalkar

MANAGER’S SIGN :- Sunil kinkar

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-		NA		