

CELL :- A361 CELL NAME:- Sector MACHINE / STAGE :- Drilling OPERATION :- Drilling

KAIZEN THEME –To avoid A361 Dia. 4 Drill shift spec 68° 54' & actual 72° 35'

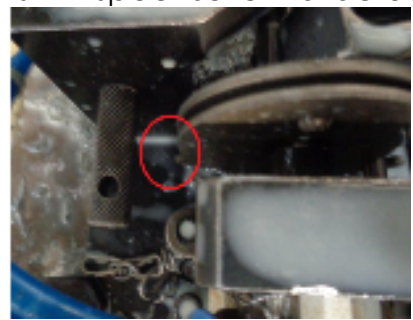
IDEA :- Poka to be added to avoid wrong loading .

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS –A361 Dia. 4 Drill shift spec 68° 54' & actual 72° 35'

COUNTERMEASURE: 1) Fixture design changed (After loading clamp pushed to sector plate clock wise & sector plate knob rest to guide rod .)

BENCHMARK	24No.
TARGET	0No.
KAIZEN START	22.12.2014
TARGET DATE	5.3.15/17.4.15/27.04/15
KAIZEN FINISH	27.04/15



No locking

BEFORE



Modified Fixture (Assembly & machining reference same, & avoid wrong loading)

AFTER

TEAM MEMBERS :-
Ajit Deokar, Umesh Pimple
Ganesh Padwalkar, Vijay Walunj,

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

KAIZEN SUSTENANCE

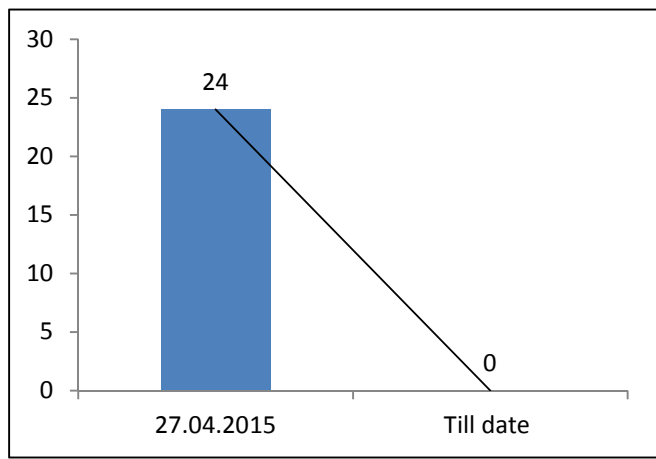
WHAT TO DO- Point added in Sustenance check sheet .
HOW TO DO: Audit
FREQUENCY : Alternate Day

WHY - WHY ANALYSIS :-

- Why 1** – A361 dia 4 hole shift spec 68° 54' & actual 72° 35' .
- Why 2** - Wrong loading during set for operation.
- Why 3** – No poka

ROOT CAUSE- – No poka

RESULT :-



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	A294 Sector	25.05.2015	Ajeet Deokar	In process

REGISTRATION NO. & DATE:- 22.12.2014

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar