

CELL :-A345Rotor CELL NAME:- Rotor Grinding MACHINE / STAGE :- Rimaco / 50 OPERATION : Face grinding

KAIZEN THEME :- To avoid A345 Outer & inner rotor thickness taper (Spec 30-0.02 mm & actual observed by 29.985 -29.975)

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :-A345 Outer & inner rotor thickness taper (Spec 30-0.02 mm & actual observed by 29.985 -29.975)



BEFORE

IDEA :- Surface Bed to be Grinding & Taper to be removed.

COUNTERMEASURE:- 1) Surface bed grinding done & taper maintain in 0.005 mm.2) Defined part loading area on bed.



AFTER

WHY - WHY ANALYSIS :-
Why 1 :- A345 Outer & inner rotor thickness taper spec 30-0.02 mm & actual observed by 29.985 -29.975)
Why 2 :- During grinding on surface grinder excess material remove from one side of face.
Why 3 :- 0.030 mm taper observed in surface grinding bed.

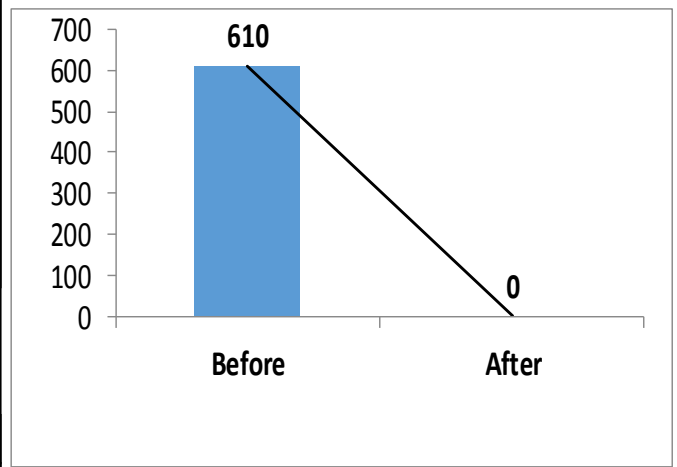
ROOT CAUSE- :-0.030 mm taper observed in surface grinding bed.

REGISTRATION NO. & DATE:-15.1.2015

REGISTERED BY :- Ashish Jagtap

MANAGER'S SIGN :- Sunil kinkar

RESULT :-



BENCHMARK	610 Nos.
TARGET	0 No.
KAIZEN START	15.01.2015
TARGET DATE	29.01.2015
KAIZEN FINISH	29.01.2015

TEAM MEMBERS :-
 Ashish Jagtap,sandip
 Ajeet deokar

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

KAIZEN SUSTENANCE

WHAT TO DO:- Check point added in supervisor check sheet .

HOW TO DO:- Using dial ,taper check

FREQUENCY : Once in week

COST INCURRED FOR MAKING KAIZEN

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

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	Grinding cell	29.01.15	Ajit devokar	Completed