
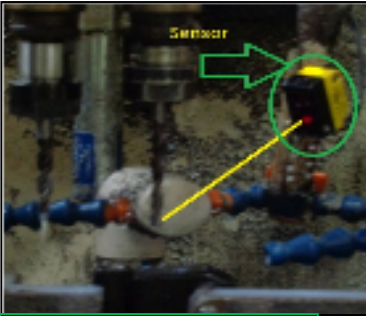


		TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET KAIZEN NO:-07																
		TPM CIRCLE NAME :-	LOSS NO. / STEP																									
		DEPT :- QA	RESULT AREA	P	Q	DEF :- A	C		D	S	M																	
CELL :-A247	CELL NAME:- BKT	MACHINE / STAGE :- Tapping						OPERATION :- Tapping																				
KAIZEN THEME :- To avoid A247 BKT M6 tapping damage .			IDEA :- Pokayoke to be implemented to reduce rejection (Sensor to be provided)																									
WIDELY/DEEPLY:-			COUNTERMEASURE: 1) Laser beam sensor provided (If Drill 5 broken then immediate stop cycle)																									
PROBLEM / PRESENT STATUS :- A247 BKT M6 tapping damage .																												
																												
No sensor			BEFORE	Tool break sensor provided						AFTER																		
WHY - WHY ANALYSIS :-			RESULT :-																									
Why 1 – A247 M6 x1 Tapping damage .			<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; text-align: center;">30</td> <td style="width:50%;"></td> </tr> <tr> <td style="text-align: center;">25</td> <td style="text-align: center;">24</td> </tr> <tr> <td style="text-align: center;">20</td> <td style="text-align: center;">15</td> </tr> <tr> <td style="text-align: center;">15</td> <td style="text-align: center;">10</td> </tr> <tr> <td style="text-align: center;">10</td> <td style="text-align: center;">5</td> </tr> <tr> <td style="text-align: center;">5</td> <td style="text-align: center;">0</td> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> </tr> </table>										30		25	24	20	15	15	10	10	5	5	0	0	0	0	0
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15	10																											
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Why 2 – M6 Tapping broken .																												
Why 3 – Before M6 tapping operation Drill 5 broken & operator not understand that drill broken & cycle continue & no of rejection part produce .																												
ROOT CAUSE; Before M6 tapping operation Drill 5 broken & operator not understand that drill broken & cycle continue & no of rejection part produce																												
REGISTRATION NO&DATE: 15.10.2014																												
REGISTERED BY :- Ganesh Padwalkar																												
MANAGER'S SIGN :- Sunil Kinkar																												
BENCHMARK												24 No.																
TARGET												0 No.																
KAIZEN START												15.10.2014																
KAIZEN FINISH												11.11.2014																
TEAM MEMBERS :-												Yuvraj Desai , Nana ugle , Vijay walunj																
BENEFITS :-												<ol style="list-style-type: none"> 1. Prevent Re-occurrence of Customer Complaint. 2. Reduce COPQ. 																
KAIZEN SUSTENANCE																												
WHAT TO DO-Check point added in Action sustain check sheet																												
HOW TO DO: By Auditing																												
FREQUENCY : Alternate day																												
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	A247 .SPM B2	15.11.14	Yuvraj									Complete d																