

		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 :- IQA	RESULT AREA	P	Q	DEF:- A	C	D	S	M												
CELL :-A211	CELL NAME:- PDC	MACHINE / STAGE :- PDC					OPERATION :- PDC															
KAIZEN THEME: To eliminate A211 body Leakage at parting line area on D Holes Back Face			IDEA :- Casting gate land to be increase by 2 mm																			
WIDELY/DEEPLY:-																						
PROBLEM/PRESENT STATUS:- Body Leakage at parting line area on D Holes Back Face			COUNTERMEASURE:- To Prevent or reduce Defect of hole the gate land increased to 1.5mm to 3.5mm with provision of radius																			
<div style="border: 1px solid black; border-radius: 15px; width: 100%; height: 100%; background-color: #4a7ebb; color: white; display: flex; align-items: center; justify-content: center; font-size: 24px; font-weight: bold;">No photo</div>																						
WHY - WHY ANALYSIS :- Why 1 –Body Leakage at parting line area on D Holes Back Face Why 2 –Leakage observed hole through. Why 3 – Casting pull out during body removing from gate casting Why 4 –Casting gate land observed 1.5 mm very less			RESULT :-																			
ROOT CAUSE : Casting gate land observed 1.5 mm very less			WHAT TO DO :- Casting gate land to be increase by 2 mm HOW TO DO : NA FREQUENCY – NA																			
REGISTRATION NO&DATE: 26.02.2016			KAIZEN SUSTENANCE																			
REGISTERED BY : Kashinath Savanji			<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: center;">COST INCURRED FOR MAKING KAIZEN</th> </tr> <tr> <th style="width: 33%;">MATERIAL COST IN RS</th> <th style="width: 33%;">LABOUR COST IN RS</th> <th style="width: 33%;">TOTAL COST IN RS</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">-----</td> <td style="text-align: center;">-----</td> <td style="text-align: center;">-----</td> </tr> </tbody> </table>										COST INCURRED FOR MAKING KAIZEN			MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS	-----	-----	-----	
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MANAGER'S SIGN :- Ganesh Padwalkar			SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																			
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