

CELL :- A247 B CELL NAME:- Bracket MACHINE / STAGE :- SPM OPERATION :- Tapping

KAIZEN THEME –To avoid A247 Bracket M5 Tapping shift.

IDEA :- Spring to be Replace.

WIDELY/DEEPLY:-

COUNTERMEASURE:-
 1) Clamping spring Replaced.
 2) Spring changing frequency changed from 3 month to two month .

PROBLEM / PRESENT STATUS –A247 Bracket M5 Tapping shift



BEFORE

BENCHMARK	19 No.
TARGET	0 No.
KAIZEN START	07.02.2015
KAIZEN FINISH	23.02.2015

TEAM MEMBERS :-
 Nana ugle, Ganesh Padwalkar ,vijay walunj,

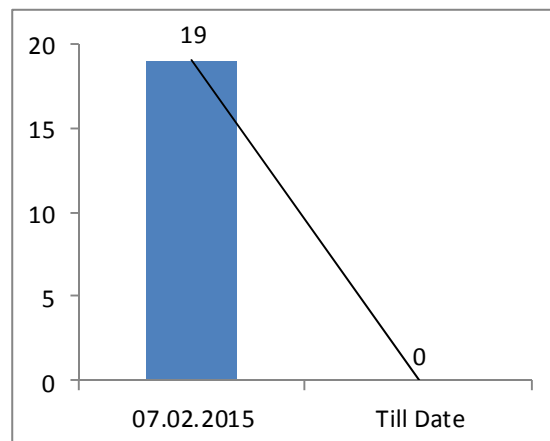
BENEFITS :-
 1. Reduce Rej.
 2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO- Point added in Supervisor check sheet
HOW TO DO: By Audit .
FREQUENCY : Once in week

WHY - WHY ANALYSIS :-
Why 1 – A247 Bracket M5 Tapping shift
Why 2 –Part get shifted upward during 9.7 hole machining.
Why 3 –Clamping spring tension week.
Why 4 –Spring length Reduce, spring Compress.

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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ROOT CAUSE—Spring length Reduce, spring Compress.

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTRATION NO. & DATE:- 07.02.2015

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
---	BKT	23.02.15	Nana	Completed

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar