

CELL :- A226 DC CELL NAME:- Drum Change MACHINE / STAGE :- Grinding OPERATION :- OD Grinding

KAIZEN THEME –To avoid A226 DC Dia. 45 & Dia. 32.0 ovality & undersize .

IDEA :- Rail locking screw to be Tight .

WIDELY/DEEPLY:-

COUNTERMEASURE:
1)Tight screw 2)Check point added in PM check sheet 3) SPC done.

PROBLEM / PRESENT STATUS –A226 DC Dia. 45 & Dia. 32.0 undersize . Spec 32-0.025-0.05 & 45-0.025-0.05 mm . Actual observed -44.939mm.



BENCHMARK	35No
TARGET	0No.
KAIZEN START	14.04.2015
TARGET DATE	14.04.2015
KAIZEN FINISH	14.04.2015

TEAM MEMBERS :-
Someshwar ,Vishal chowghule
Ganesh Padwalkar ,vijay walunj,

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

KAIZEN SUSTENANCE

BEFORE

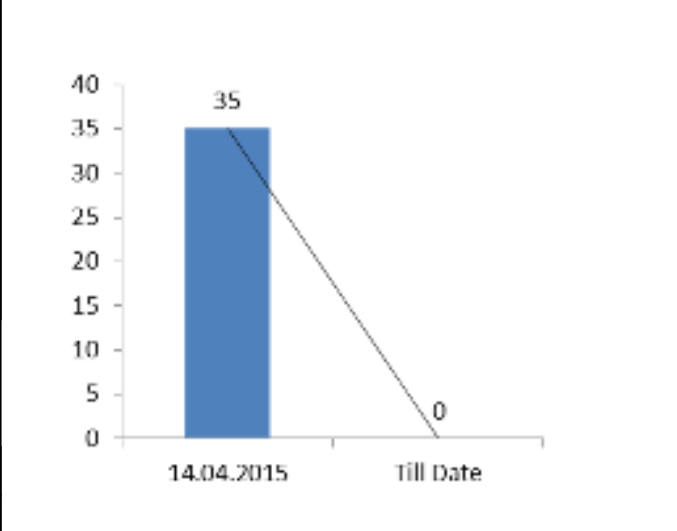
AFTER

WHAT TO DO- Point added in PM check sheet .

HOW TO DO: PM
FREQUENCY : Once in month

WHY - WHY ANALYSIS :-
Why 1 – A226 DC Dia. 45 & Dia. 32.0 ovality & undersize .
Why 2 – After Dressing first part generate taper of 0.05 to 0.08 mm.
Why3 -Play in sliding unit .
Why4 -V type rail locking screw loose .

RESULT :-



ROOT CAUSE-- V type rail locking screw loose

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE:- 14.04.2015

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Ganesh Padwalkar

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-		NA		

MANAGER'S SIGN :- Sunil kinkar