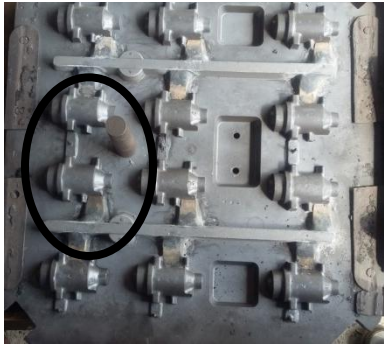


| | | | | | | | | | | | |
|---------------------|------------------------|---------------------------|----|---------|----|-----|----------------------|----|-----|-------------|--|
| TPM CIRCLE NO :- 02 | ACTIVITY | KK | QM | PM | JH | SHE | OT | DM | E&T | KAIZEN NO:- | |
| TPM CIRCLE NAME :- | LOSS NO. / STEP | 10 | | | | | | | | | |
| DEPT :-QA | RESULT AREA | P | Q | DEF :-A | C | D | S | M | | | |
| CELL :-A352 | CELL NAME:-Drum Change | MACHINE / STAGE :-Molding | | | | | OPERATION :- Molding | | | | |

KAIZEN THEME :-To eliminate hole block problem in A352 Drum change.

WIDELY/DEEPLY:-

•PROBLEM / PRESENT STATUS :-hole block in A352



BEFORE

IDEA :-Core Print.

COUNTERMEASURE:-Core locking provided in pattern to lock the core.



AFTER

| | |
|----------------------|------------|
| BENCHMARK | 350 |
| TARGET | 0 |
| KAIZEN START | 02.04.2016 |
| KAIZEN FINISH | 10.04.2016 |

TEAM MEMBERS :-

- 1-R.P.Sharma,Chetendra singh
- 2- Ishu Agrawal, Harikrishna, Rajesh Kumar

BENEFITS :-

Increase Productivity, Reduce Rejection

KAIZEN SUSTENANCE

WHY-WHY ANALYSIS :-

Why1:-Hole block in A352.

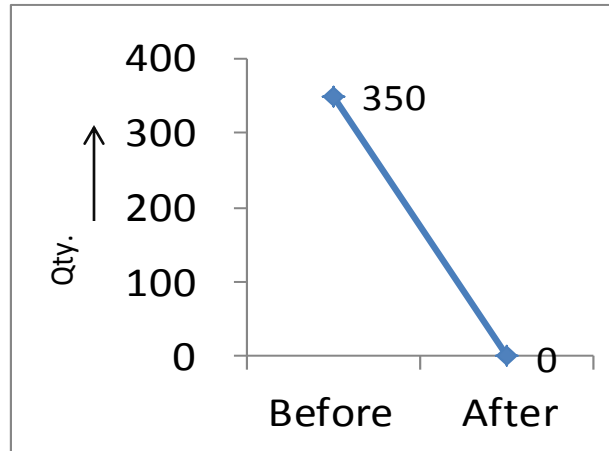
Why 2:- Core Damage.

Why3:- Core locking not available in pattern.

Why4:-Due to touch print of core.

ROOT CAUSE :-Touch Print Of Core.

RESULT :- Eliminated



WHAT TO DO :- Ir-Reversible

HOW TO DO :-While Production

FREQUENCY :-One time activity

COST INCURRED FOR MAKING KAIZEN

| MATERIAL COST RS. | LABOUR COST RS. | TOTAL COST RS. |
|-------------------|-----------------|----------------|
| 1200 /- | 800 /- | 2000 /- |

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

| Sr. NO. | CELL | TARGET | RESPONSIBILITY | STATUS |
|---------|----------------|--------|----------------|--------|
| 01 | A385,A254,A189 | | Chetendra | Done |

REGISTRATION NO&DATE:

REGISTERED BY :-

MANAGER'S SIGN :-