CELL :- A128	CELL NAME:- Tensioner Body	MACHINE / STAGE :- Mazak/Machining	OPERATION :- Operation No. 10

KAIZEN THEME : **To Prevent the defect at A128 Tensioner Body machining cell.**

IDEA :- Provide Interlock lock system about last operation by macro programing.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- Machining Operation miss while power fail, due to after power recovery operator skipped existing operation & calling next operation Block & machine get start & No message of last operation miss.

No Interlock System In Machine For Operation Miss

BEFORE

COUNTERMEASURE:- Provided interlock system about last operation by macro program & now machine will update last operation status if in case operator skipped existing operation & called next operation.

Macro Program Provided To Arrest Operation Miss

AFTER

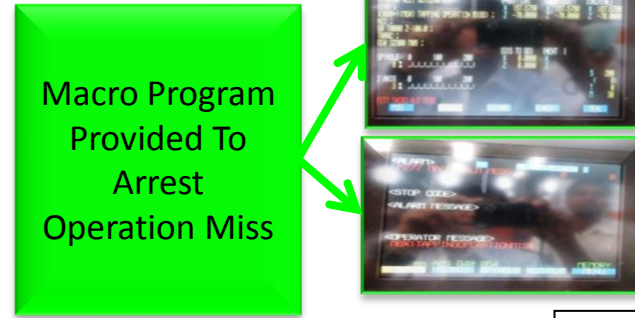| BENCHMARK	10 Nos
TARGET	Zero
KAIZEN START	15.03.2016
KAIZEN FINISH	26.03.2016

TEAM MEMBERS :-
N.S.Pujari , Mr. Shanthkumar
Mr. Praveen

BENEFITS :-

1.Prevent In-house rejection.
2.Prevent Customer Complaints.
3.Saved Machining Cost.

KAIZEN SUSTENANCE

WHAT TO DO: ---
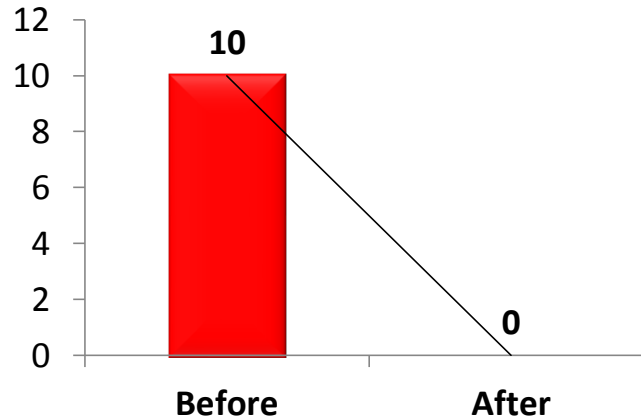**HOW TO DO:** ---
FREQUENCY : Irreversible kaizen.

WHY - WHY ANALYSIS :-
Why1: M6x1 6H Machining Operation Skip.
Why2 : No Interlock in machine about last operation.
Why 3:- Not Provided

ROOT CAUSE :- Not Provided

REGISTRATION NO. & DATE: 1312 ,31.03.16

REGISTERED BY :- Guru Basappa

MANAGER'S SIGN :- N.S.Pujari

RESULT :-

Rejection Trend

Before: 10
After: 0

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.	A157	31.03.16	M.E Dept.	Completed