

K2

TPM CIRCLE NO: 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME: Joshile	LOSS NO. / STEP								
DEPT: Manufacturing Engineering	RESULT AREA	P	Q	DEF:- A		C	D	S	M

KAIZEN IDEA SHEET

F/IMS/05

CELL: A315 CELL NAME: Oil Pump Body MACHINE / STAGE: VMC/Machining OPERATION: Facing, Reaming & Back Facing

KAIZEN THEME: : To Prevent the fixture break down of A315 Body Machining cell

WIDELY/DEEPLY:

PRESENT STATUS : A315 Body Machining fixture break down , Cylinder seal Damage.

Before



BEFORE

IDEA: Protective cover to be provide

COUNTERMEASURE :- To provided the protective cover for eliminate burr enter in to the fixture Cylinder seal plug taper cam .
After



AFTER

BENCHMARK	1 Nos
TARGET	Zero
KAIZEN START	26.10.16
KAIZEN FINISH	27.10.16

TEAM MEMBERS:
N.S.Pujari, Mr. Ambarish, Mr. Pavan

- BENEFITS:**
- 1) Eliminated may happen in House Rejection account of Jigs/Fixture
 - 2) Reduce Fixture PM time 45 min to 40 min.
 - 3) Improved J.H (HTA)

WHY - WHY ANALYSIS :-

- Why1:** A315 Body Machining fixture break down cylinder seal damage
- Why2:** In Fixture burr enter in to the cylinder seal
- Why3 :** Fixture in open condition.
- Why4:** No Protective cover.

ROOT CAUSE:- No Protective cover.

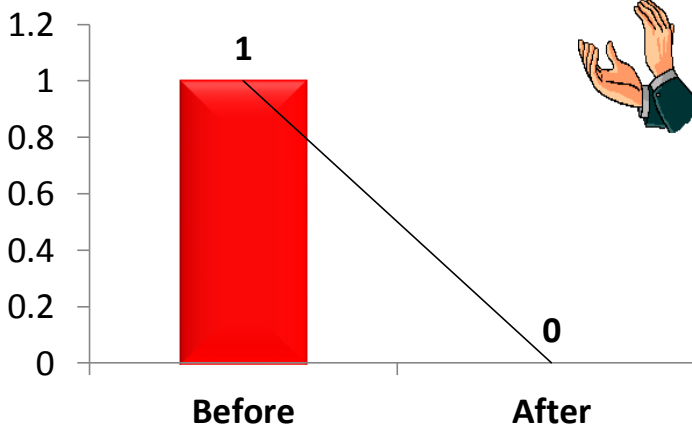
REGISTRATION NO. & DATE: 1303, 28.10.16

REGISTERED BY: Mr. Guru Bassappa

MANAGER'S SIGN: Mr. N.S.Pujari

RESULT:-

A315 Machining Fix. BD



KAIZEN SUSTENANCE

WHAT TO DO : To Check the Projective Cover Presence
HOW TO DO : Visual
FREQUENCY : While Fixture PM.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 100	-----	INR100

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS
1	A337/374/A271	15.11.16	N.S.Pujari	Ongoing