

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

CELL :-A157	CELL NAME:-Tensioner	MACHINE / STAGE:- TRUB / 20	OPERATION :- Back Facing
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KAIZEN THEME : To prevent the defect of A157 Tensioner Body Face Back Damage

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS:- 15 No's A157 Tensioner Body Back Face Damage during machining



BEFORE

IDEA :- Electric Foot Pedal to be implemented .

COUNTERMEASURE:- Electric Foot Pedal to be implemented instead of Pneumatic Foot Pedal.



AFTER

BENCHMARK	01 No.
TARGET	0 No.
KAIZEN START	20.09.14
KAIZEN FINISH	10.10.14

TEAM MEMBERS :-
Mr.Ravi, Mr. Sivasankar, Mr. Narayanan.

BENEFITS :-

Avoid the In house Rejections

KAIZEN SUSTENANCE

WHAT TO DO : Electric Foot Pedal to be installed.
HOW TO DO : Electric Foot Pedal to be implemented instead of Pneumatic Foot Pedal
FREQUENCY :-

COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST	LABOUR COST	TOTAL COST
IN RS	IN RS	IN RS
--	N A	--

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A157	10.12.14	Mr. Ravi/Shankar	

WHY - WHY ANALYSIS :-
Why 1 : 15 No's A157 Tensioner Body Back Face Damage during machining .
Why 2 : Excess Material Removed during Back Facing Operation (50).
Why 3 : During Facing Operation Collet holder was De-Clamped.
Why4 : Component get de clamped without completing the back facing cycle .
Why5 : Operator Pressed the Foot Pedal in Running Condition,before completion of Operation.

ROOT CAUSE :- Poka

REGISTRATION NO. & DATE : 259 & 10.10.14

REGISTERED BY :-Guru

MANAGER'S SIGN :- Narayanan

RESULT :-

