

CELL :-      CELL NAME:- 449      MACHINE / STAGE:- Combo unit      OPERATION :- Free rotation

**KAIZEN THEME :-** To increased MTBF

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS:-** Frequent hydraulic oil Empty of tank due to continue oil leaked In hydraulic cylinder manifold .



Before

**IDEA:-** Design change.

**COUNTERMEASURE:-** During machining Mail & female part o, ring match due to both hole similar.



After

**WHY WHY ANALYSIS :-**  
**WHY 1:-** Oil leaked in manifold  
**WHY 2:-** O, ring not match in cylinder hole  
**WHY 3:-** Design problem

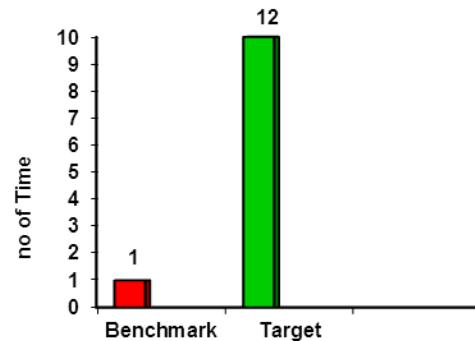
**ROOT CAUSE:-** Design problem

**REGISTRATION NO&DATE:**

**REGISTERED BY :-**

**MANAGER'S SIGN :-**

**RESULT:-** .



<b>BENCHMARK</b>	1 time in month
<b>TARGET</b>	12 time in month
<b>KAIZEN START</b>	10.11.16
<b>KAIZEN FINISH</b>	13.11.16

**TEAM MEMBERS :-** Yogesh

P.sharma

**BENEFITS :-** 1) Oil save  
 2) Break down reduce  
 .3) moral increased of operator.

**KAIZEN SUSTENANCE**

**WHAT TO DO :-** ir-reversible

**HOW TO DO :-**

**FREQUENCY :-**

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.
600/-	0/-	600/-

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS