

TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :-	LOSS NO. / STEP	10							
DEPT :- ME	RESULT AREA	P	Q	DEF :- A/B/C	C	D	S	M	

KAIZEN NO:- 13-04

CELL :- A216 | CELL NAME:-Tensioner | MACHINE / STAGE :- Toggle Press | OPERATION :- Number Punching

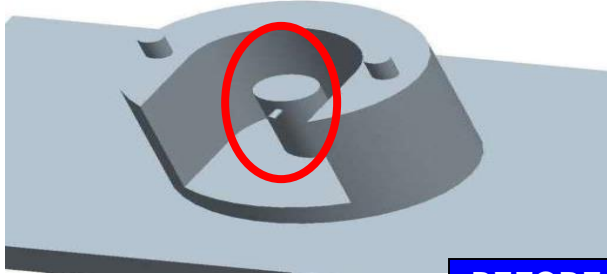
KAIZEN THEME :- To eliminate the COPQ

IDEA:- Strong

WIDELY/DEEPLY:-

COUNTERMEASURE:- We provided a strong pin at number punching fixture A216

PROBLEM / PRESENT STATUS :- We were facing wrong side number punching on part no A-216 per month 10pcs at Number punching station in assemble line Plant-3.



BEFORE



AFTER

BENCHMARK	10 Nos.
TARGET	0 Nos.
KAIZEN START	05.12.14
KAIZEN FINISH	08.12.14

TEAM MEMBERS :-
 Jasbir Kumar - ME
 Parbakar - M.E

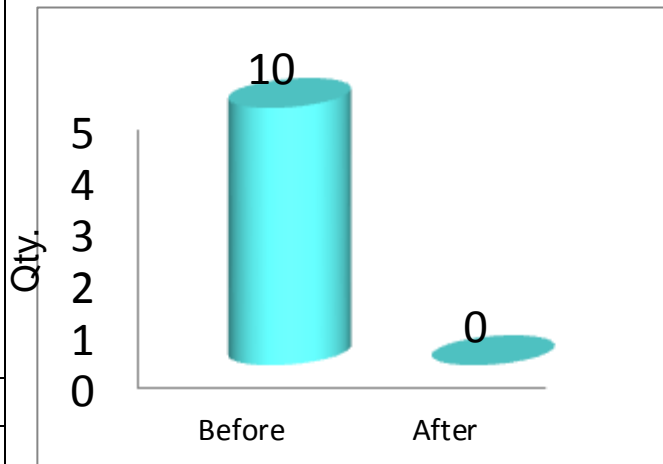
BENEFITS :-
 Improve the Quality

KAIZEN SUSTENANCE

WHY-WHY ANALYSIS :-

- WHY 1 :- Wrong punching.
- WHY 2 :- Part location shift.
- WHY 3 :- Location pin broken.
- WHY 4 :- Pin strength was weak

RESULT :- Eliminated the COPQ.



WHAT TO DO :- Point add in JH check sheet

HOW TO DO :- Visual

FREQUENCY :- Daily

ROOT CAUSE :- weak

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.
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REGISTRATION NO&DATE:

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :-

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS

MANAGER'S SIGN :-