

TPM CIRCLE NO :-1	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Josh	LOSS NO. / STEP								
DEPT :- QA	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :-A351 CELL NAME:- Drum Change MACHINE / STAGE :- Drum Change Machining OPERATION :- CNC 2nd Turning Stage

KAIZEN THEME : To Prevent defect of A351 Drum Change damage at 2nd Turning Stage.

IDEA :- Input Material Dia. Within Spec.

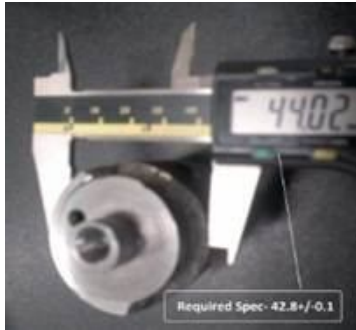
WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided the Poka Yoke Block at supplier end at Drilling Stage to arrest Excess Diameter Casting before Drilling Process itself.

BENCHMARK	18 Nos.
TARGET	0 No.
KAIZEN START	07.06.2014
KAIZEN FINISH	10.06.2014

PROBLEM / PRESENT STATUS :- 18 Nos. Drum Change get damaged in Machining at 2nd CNC Turning Stage in Apr. & May.14

TEAM MEMBERS :-
 Datta Pandrey
 Deepak – Supplier Representative
BENEFITS :-



BEFORE



AFTER

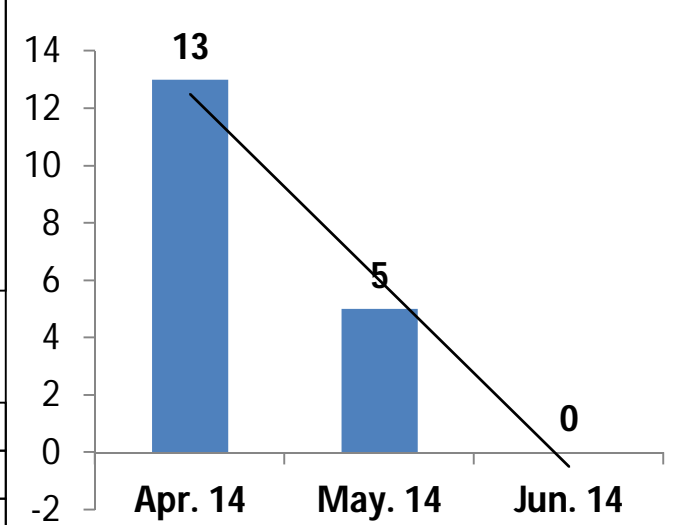
- 1. Reduce In-house PPM
- 2. Reduce COPQ

KAIZEN SUSTENANCE

WHAT TO DO: Change the Drilling Fixture Design
HOW TO DO: Drilling in modified Fixture
FREQUENCY : 1 Time Action.

WHY - WHY ANALYSIS :-
Why1: 18 Nos. Drum Change damaged.
Why2 : Damaged at 2nd Turning Stage.
Why3: Excess load on Insert during Turning.
Why4 : Excess Material on O.D during Turning.
Why5 : Input material Dia. > Spec. (44 against 43)

RESULT :-



ROOT CAUSE :- Input Material Dia.>Spec.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 500/-	-----	INR 500/-

REGISTRATION NO. & DATE: 76 & 10.06.14
REGISTERED BY :- Guru Basappa
MANAGER'S SIGN :- Narayanan

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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