

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 :-A315 CELL NAME:- Drum Change MACHINE / STAGE :- A351 Drum Change Machining Line OPERATION :- CNC Turning 1st & 2nd Stage

KAIZEN THEME : To Prevent defect of Face Unclean on both Sides Dia. 13 & Dia. 22 .00

IDEA :- Locating Hole should not be Oblong.

WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided the Drilling operation at supplier end after completion of rough machining to ensure locating hole should not be Oblong.

BENCHMARK	84 Nos.
TARGET	0 No.
KAIZEN START	21.03.2014
KAIZEN FINISH	16.04.2014

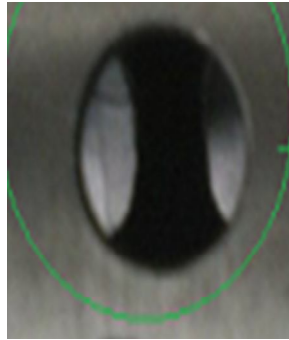
PROBLEM / PRESENT STATUS :- 84 Nos. Drum Change rejected on account of Face unclean in March & Apr. 14.

TEAM MEMBERS :-
Datta Pandrey
Supplier Team

BENEFITS :-



BEFORE



AFTER



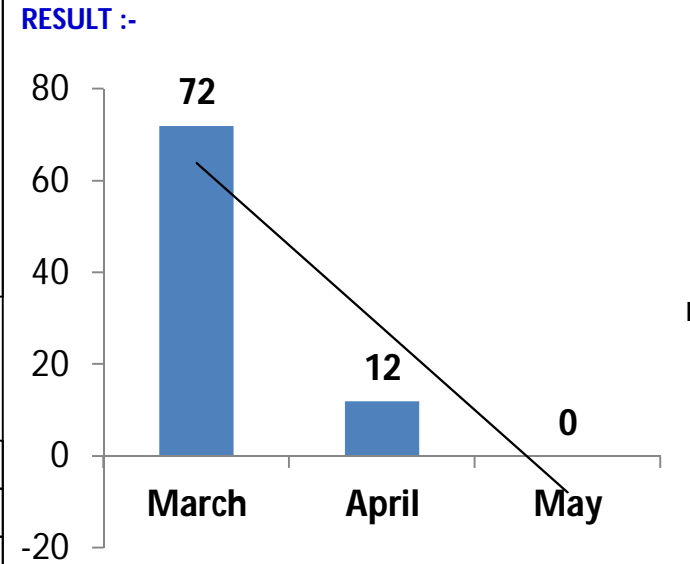
1. Prevent Potential Customer Complaint.
2. Reduce COPO

WHY - WHY ANALYSIS :-
Why1: Face Unclean
Why2: No Matl. for Facing operation.
Why3: Excess Material removed at 1st VMC Stage.
Why4: No proper locating at 1st VMC Stage.
Why5: Locating Hole oblong.

KAIZEN SUSTENANCE

WHAT TO DO: Revise the PFC & Control Plan.
HOW TO DO: -----
FREQUENCY : 1 Time Action

ROOT CAUSE :- Locating Hole Oblong.



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE: 10 & 16.04.14
REGISTERED BY :- Guru Basappa
MANAGER'S SIGN :- Narayanan

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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