

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 :- A351 Drum Change Line OPERATION :- Hard Part Retapping Stage

KAIZEN THEME : To Prevent defect of M6 Threading Miss in Drum Change.

IDEA :- Poka Yoke

WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided the Poka Yoke at Hart Part Retapping stage by providing contact type limit switch to arrest M6 Thread Miss component.

BENCHMARK	1 No.
TARGET	0 No.
KAIZEN START	10.03.2014
KAIZEN FINISH	15.03.2014

PROBLEM / PRESENT STATUS :- 1 No. Drum Change found at Final Inspection Stage with M6 Thread Miss.

TEAM MEMBERS :-

Ravi Kumar
Sivashankar G.

BENEFITS :-

1. Prevent Potential Customer Complaint
2. Reduce COPQ



BEFORE



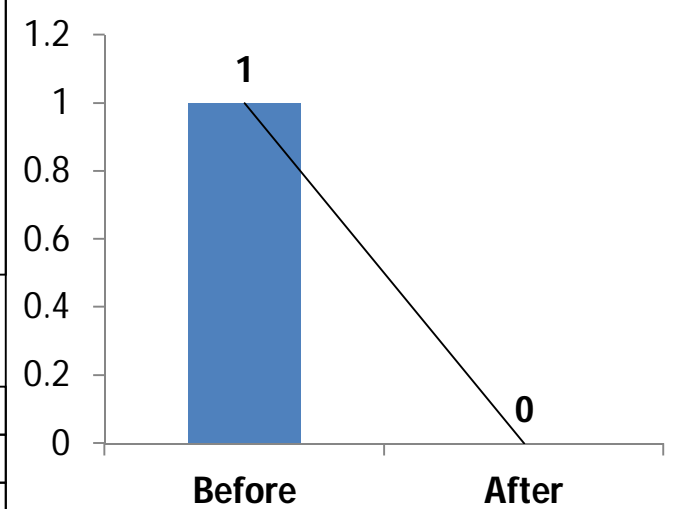
AFTER

KAIZEN SUSTENANCE

WHAT TO DO: Change the Collet Design Drawing
HOW TO DO: -----
FREQUENCY : 1 Time Action.

WHY - WHY ANALYSIS :-
Why1: M6 Thread Miss
Why2 : M6 Thread Miss in Soft Line.
Why3: Poka

RESULT :-



ROOT CAUSE :- Poka

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 3500/-	-----	INR3500/-

REGISTRATION NO. & DATE : 07 & 15.03.14

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Guru Basappa

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	2 nd Cell	10.07.14	Ravi	In-process

MANAGER'S SIGN :- Narayanan