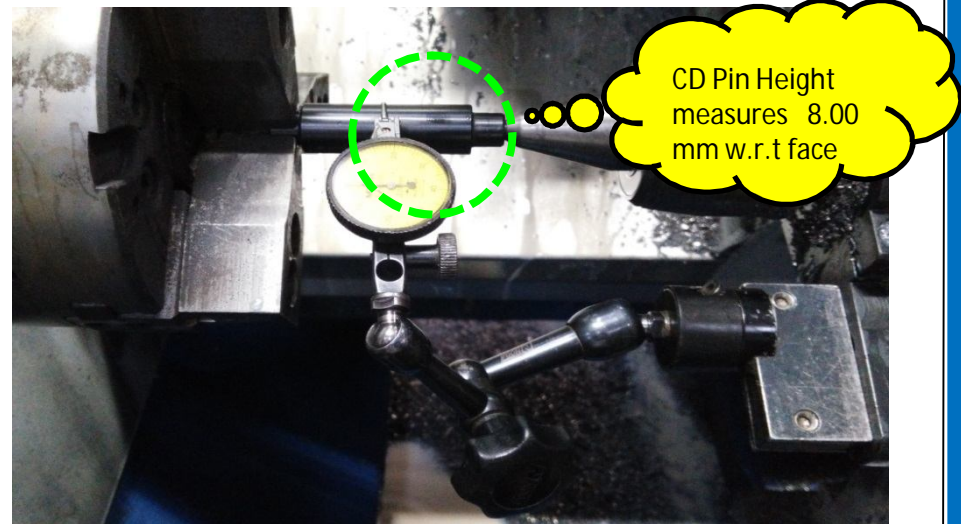


Problem Description 1 :- No Specimen to check the clamping jaws run out, defect probability of Over machining & Taper in dimensions.



Why Why Analysis :-

Why 1 –Defect probability of Over machining & Taper in dimensions,

Why 2 –No Specimen/Mandrel to check the clamping jaws run out,

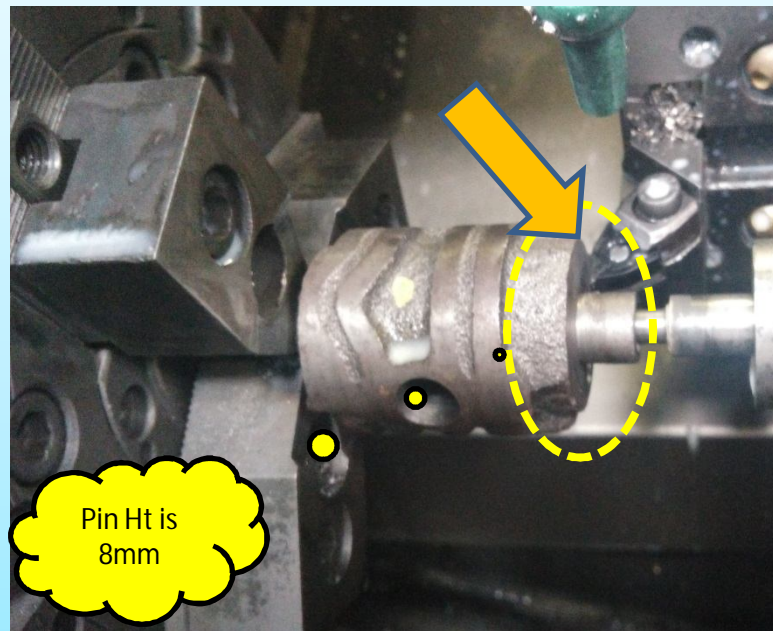
Root Cause :- No Specimen/Mandrel to check clamping jaws run out,

Kaizen Idea :- Provide Run out Test mandrel with 0.001mm Run out,

Countermeasure :- Provided Run out Test mandrel with 0.001mm Run out,

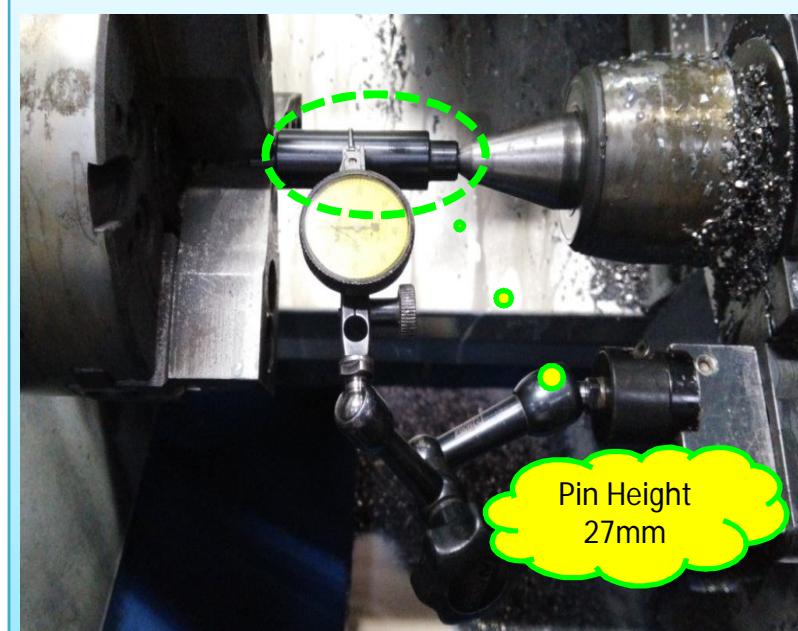
Improvement Point -1 : Provided Run out Test mandrel with Least count 0.005mm

Before



- Before no Control Over Clamping jaws run out,
- Probability of Dimension taper
- Probability of insert breakage, burn as Heavy load.

After



- Control over Clamping jaws run out,
- No Probability of Dimension taper, good result in quality
- No probability of insert breakage, Burn

CELL :- A351

CELL NAME :- Drum Gear shifter

MACHINE / STAGE :- Soft turning-II

OPERATION :- 30

KAIZEN THEME :- To control Machine run out and to avoid taper in dimension

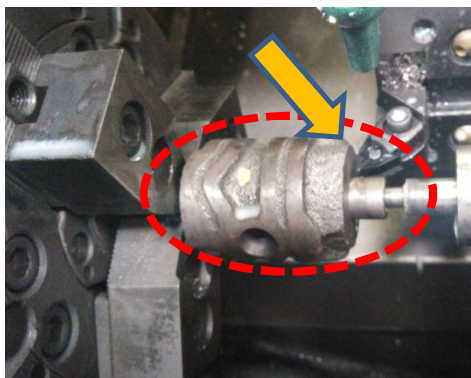
IDEA :- Provide Run out Test mandrel with 0.001mm Run out,

WIDELY/DEEPLY :- Widely

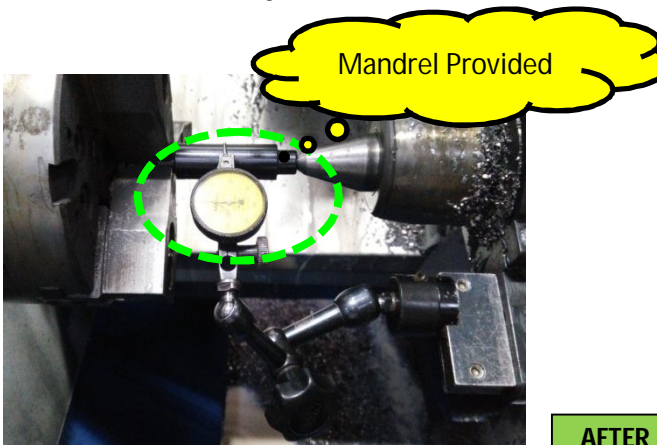
PROBLEM / PRESENT STATUS :- No Mandrel to check machine clamping jaws run out .

COUNTERMEASURE :- Provided Run out Test mandrel with 0.001mm and Clamping jaws s run out & Jaws dia. (2 in 1 Gauge)

BENCHMARK	01 No.
TARGET	0 No.
KAIZEN START	01.10.15
KAIZEN FINISH	15.10.15



BEFORE



AFTER

TEAM MEMBERS :-

Mr, Dashrath, Mr, Chetan
Mr., Satish Kumar

BENEFITS :-

- Control over Clamping jaws run out,
- No Probability of Dimension taper, good result in quality

KAIZEN SUSTENANCE

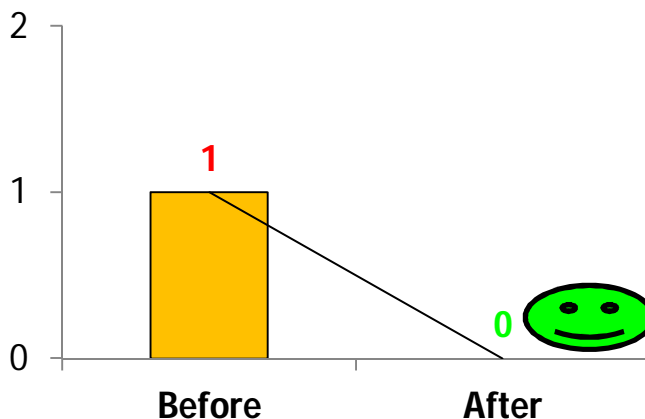
WHY - WHY ANALYSIS :-

Why 1 –Defect probability of Over machining & Taper in dimensions,

Why 2 –No Specimen/Mandrel to check the clamping jaws run out

RESULT :- Result in Quality,

Benchmark



WHAT TO DO : Calibration

HOW TO DO : as per standard

FREQUENCY : as per plan

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
NA	N A	900 aprx

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
	Dashrath	Close

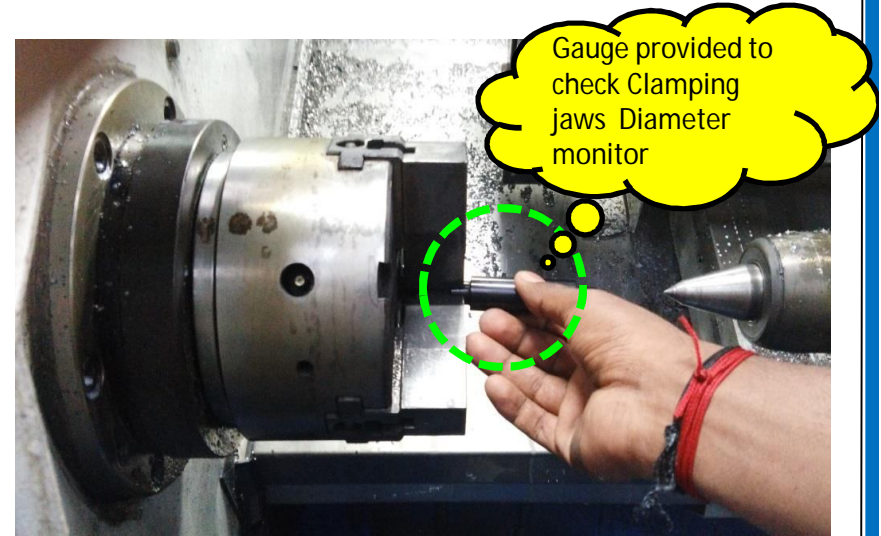
ROOT CAUSE :- No Specimen/Mandrel to check clamping jaws run out

REGISTRATION NO. & DATE: 874 & 15.10.15

REGISTERED BY :- Mr, Dashrath & Mr.Chethan

MANAGER'S SIGN :- Mr, Vijaykumar

Problem Description 1 :- Component slip during machining.



Why Why Analysis :-

Why 1 – Component slip during machining.

Why 2 – Clamping jaws inner diameter oversize,

Why 3 – Wear and tear % more, No gauge to check Clamping jaws Diameter.

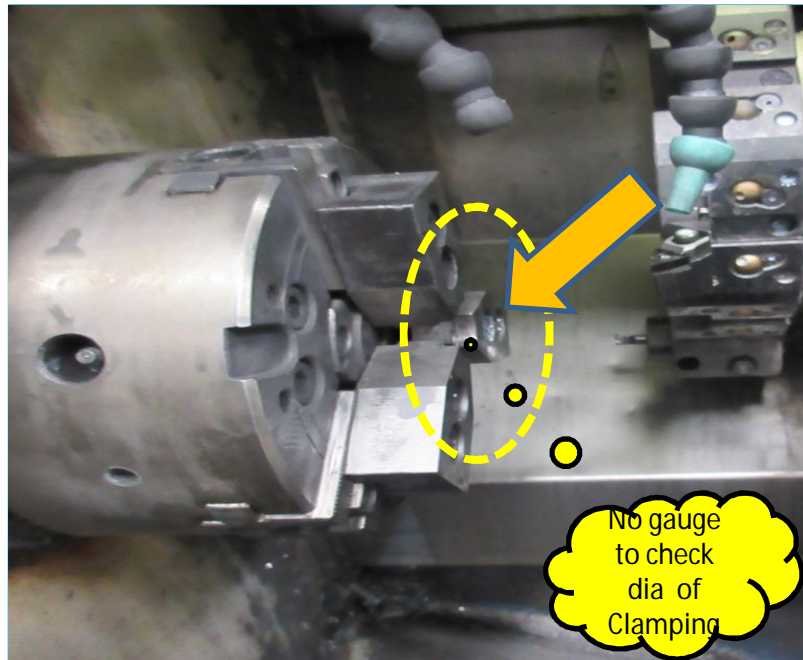
Root Cause :-No gauge to check Clamping jaws Diameter

Kaizen Idea :- Provide gauge to check Clamping jaws Diameter.

Countermeasure :- Provided gauge to check Clamping jaws Diameter oversize.

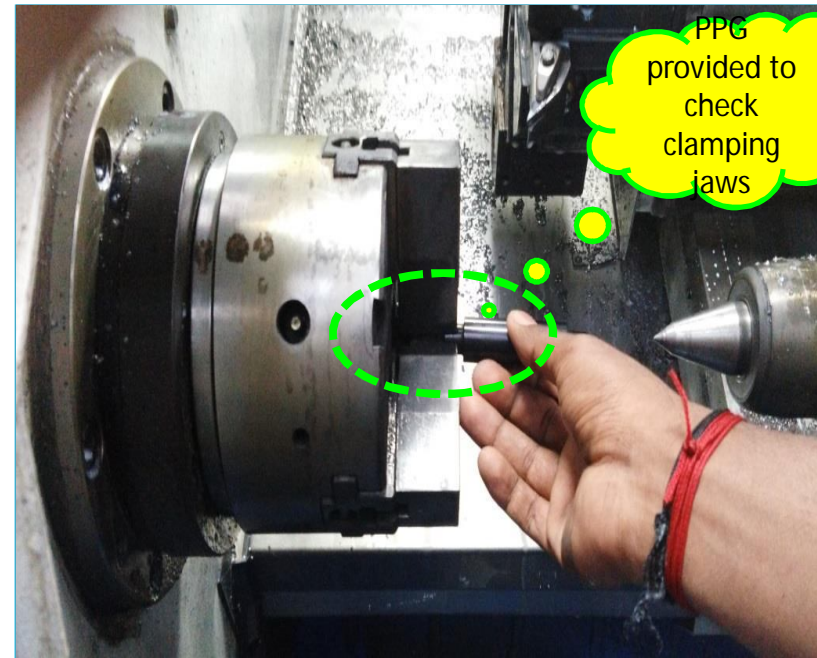
Improvement Point -1 : Provided Run out Test mandrel with Least count 0.005mm Run out

Before



- No Gauge to check Clamping jaws diameter
- In-house rejection
- Machine break-down
- Wrong loading

After



- Gauge provided to check Clamping jaws
- No rejection
- No machine breakdown
- No Wrong loading

CELL :-A351 CELL NAME:- Drum Gear shifter MACHINE / STAGE:- Soft turning-II OPERATION :-30

KAIZEN THEME :- To avoid Component slip during machining

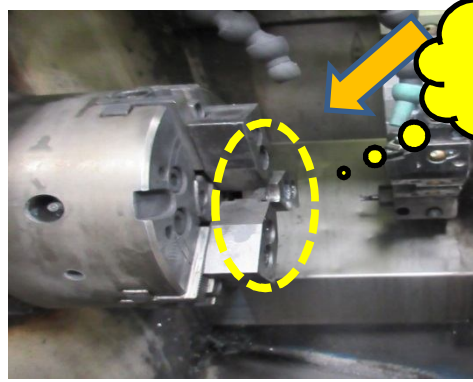
IDEA :- Provide gauge to check Clamping jaws Diameter

WIDELY/DEEPLY:- Widely

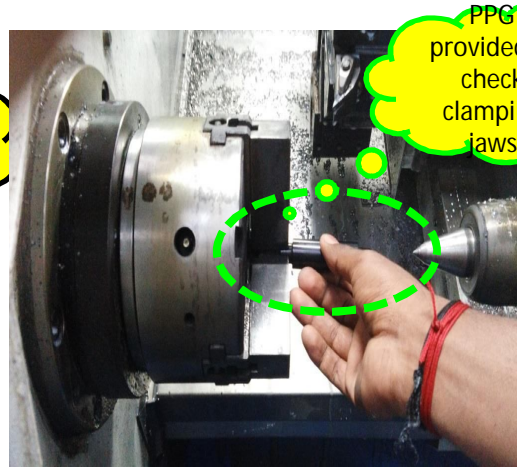
COUNTERMEASURE:- Provided gauge to check Clamping jaws Diameter oversize. (2 in 1 Gauge)

BENCHMARK	01 No.
TARGET	0 No.
KAIZEN START	01.10.15
KAIZEN FINISH	15.10.15

PROBLEM / PRESENT STATUS :- NO Gauge to check Clamping jaws Diameter



No gauge to check dia of Clamping



PPG provided to check clamping jaws

BEFORE

AFTER

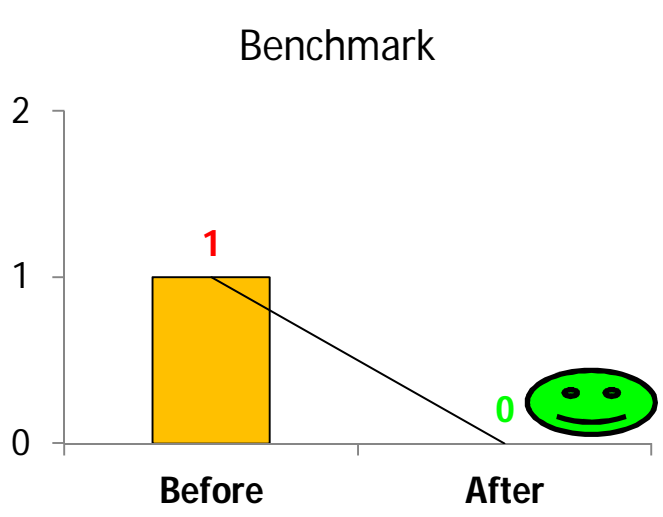
TEAM MEMBERS :-
Mr, Dashrath, Mr, Sharath
Mr., Satish Kumar

- BENEFITS :-**
- No Wrong loading of Component
 - Elimination in in-house rejection
 - Pro-active jaws Boring.

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why 1 – Component slip during machining.
Why 2 – Clamping jaws inner diameter oversize,
Why 3 – Wear and tear % more, No gauge to check Clamping jaws Diameter.

RESULT :- Result in Quality,



WHAT TO DO : Calibration
HOW TO DO : as per standard
FREQUENCY : as per plan

ROOT CAUSE :-No gauge to check Clamping jaws Diameter

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
NA	NA	0000

REGISTRATION NO. & DATE: 874 & 15.10.15
REGISTERED BY :- Mr.Dashrath & Mr.Sharath
MANAGER'S SIGN :- Mr, Vijay Kumar

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
	Dashrath	Close

Note:-

- All Dimension's are in mm
- Light Chamfer over corner
- Use for Clamping jaws 1
- 1) diameter oversize, 2) to check Jaws Run out

