KAIZEN IDEA SHEET

Equipment :		**Loss Type :**	Defect loss							**Kaizen ID : 2565**
Department :	Production	**Result :**	N	P	Q	C	D	S	M	
Cell :	Prop Shaft Assly	**Type :**								

Unit Name : POONA FORGE P LTD, Pune

Operation : Milling

Kaizen Theme: To prevent the rejection due to milling twist

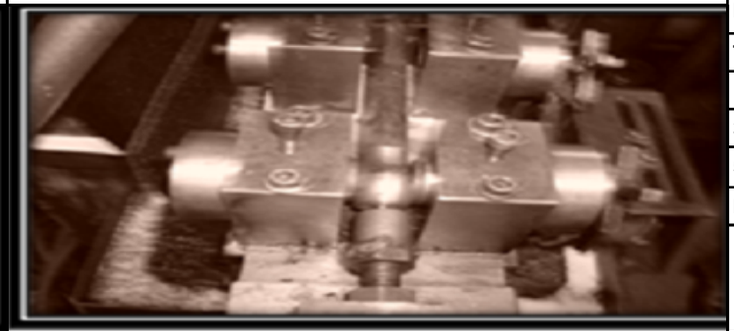
Idea : No tilting

Problem / Present Status

Flatness of two faces is more than +/-1

Counter Measure

Clamping provided for machined face while doing second operation to avoid tilting



Benchmark :	35 nos per month		
Target :	0		
Start :	10/08/2010	**Finished :**	10/08/2010
Note :			

Team Members :

1. Mr. Deshpande	2. Mr. Dhole
3. Mr. Patel	4. Mr. Jadhav
5.	6.

Benefits

Why Why Analysis :

W1 : Why Component getting rejected due to twist ?

A1 : Manual operation given from one side

W2 : Why Manual operation given from one side ?

A2 : No clamping

W3 : Why No clamping ?

A3 : Component getting tilted while machining

W4 : Why Component getting tilted while machining ?

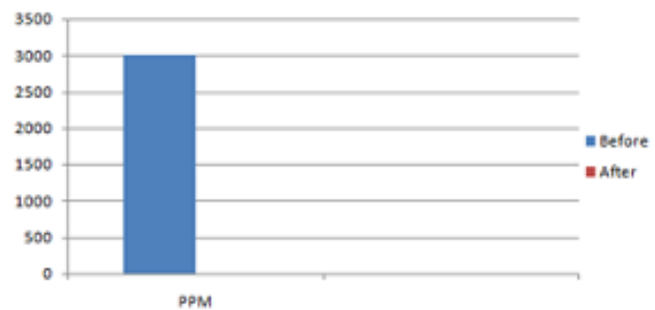
A4 :

Root Cause

Tilting

Result :

Rejection due to tilt reduces to zero



Kaizen Sustenance :

What To Do : Daily monitoring by supervisor

How To Do : To check the plunger operations

Frequency :

Cost Incurred For Making Kaizen :

Material Cost	Labour Cost	Total
0.00	0.00	0.00

Scope & Plan For Horizontal Deployment :

Equipmnet	Target	Status

Date :	**10/08/2010**
Registered By :	Mr. S. Reshmi
Manager's Sign :	Mr. Mohan Gaikwad