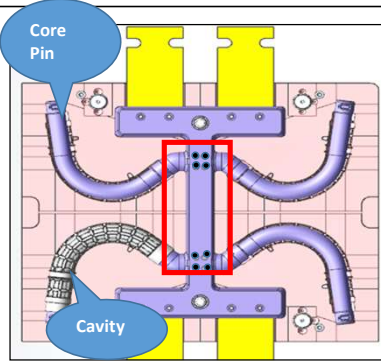
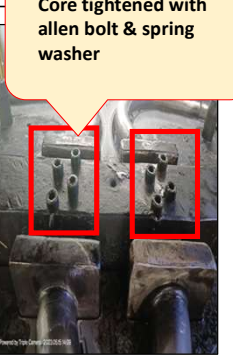



CIRCLE NO.\NAME :		Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	PPC	KAIZEN IDEA SHEET
DEPT : Quality		Loss no.			7							
EQP NO. : Desma No. 66		Result :		P	Q	C	D	S	M			
EQP NAME : Moulding		Type :		√	√	√	√		√			
CELL NO.: 2	CELL NAME : Duct-Cell No.2				OPERATION : Moulding							
KAIZEN THEME: To Reduce In-house rejection.				Idea :- Soild Core								
PROBLEM / PRESENT STATUS: Part no. AA121197 Duct operator facing wall thickness variation that is 2.28~2.40mm against specification 3 ± 0.40 mm during moulding process at machine No.52. Inhouse Rej - 247 Nos/month				COUNTERMEASURE: On machine.52 - Soild core pin mould implemented eliminate wall thickness variation, thus CC & IHR eliminated for part no. AA121197				BENCH MARK 247 nos				
								TARGET 0				
				KAIZEN START 24.05.23				FINISHED : 16.06.23				
 <p>Core Pin</p> <p>Cavity</p> <p>Before</p>				 <p>Core tightened with allen bolt & spring washer</p> <p>After</p>				NOTE : TEAM MEMBERS: 1. Samrat Lokhare 2. Prakash Deshmukh 3. Rupesh Shete 4. Gorakh Rathod BENEFITS: P: Productivity increased. Q: CC reduced C: Rejection cost reduced. D: Delivery improved. S: M: Operator morale increased.				
WHY WHY ANALYSIS : W1. Wall thickness variation observed W2. Due to cavity core pin loose W3. Bolt of core pin are getting loose after some molding cycle W4. Spilt Core				RESULTS :  <p>IHR- AA121197</p> <p>Before: 247, After: 0</p>				KAIZEN SUSTENANCE : WHAT TO DO : HOW TO DO : FREQUENCY :				
ROOT CAUSE : Spilt Core								COST INCURRED FOR MAKING KAIZEN				
Reg. No. /Date : 16.06.23								MATERIAL COST Rs. 700000 Rs		LABOUR COST Rs. 5000 Rs		TOTAL COST Rs. 7500000 Rs
Registered By : Samrat Lokhare								SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
Manager's Sign: Sudhir Salunkhe								EQUIPMENT		RESPONSIBILITY		STATUS
												TARGET DATE