

Success Celebration : Apr 18
PM Kaizen : To reduce Lead time
Kaizen by : Mr. Praveen N S Pujari & Manas dey

ADVIK		TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPA	DM	E & T	KAIZEN IDEA SHEET
Plant : P14		TPM CIRCLE NAME :		LOSS NO./STEP									
CELL :	A545	DEPT :	Production	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M	
CELL NAME :	Tensioner			M/C STAGE:	AC Colt -2			OPERATION:	Fadng/Grooving				
KAIZEN THEME :	To Increase the Output per Man in A545 Tensioner Assy. @ Machining Cell												
PROBLEM PRESENT STATUS :	Present Output per Man is 920 Nos												
KAIZEN IDEA :	To modify the component Clamping & de-clamping System.												
COUNTERMEASURE:	Changed the clamping & de-clamping system of Comp. from manual to auto by utilizing current machine tail stock with addition of Face resting block considering eccentric requirement of comp., Hence now no need of manual clamping & de-clamping of comp.												
WHY-WHY ANALYSIS:	<p>Why1: Present Output per Man is 920 Nos. Why2: Cycle Time is 30 Sec/Component Why3: Bottleneck Activity – Comp. Clamping & De-clamping Time – 16 sec/Component Why4: Component clamping system is Manual</p>												
ROOT CAUSE	Component clamping & de-clamping system .												
RESULTS:	<p>Before: Manual clamping system by mechanical bolt. Shift Length = 460 min, Cycle Time = 30 Sec/Comp, Output per Man (460*60/30) = 920 Nos.</p> <p>After: Auto clamping system by Tail Stock with eccentric block. Shift Length = 460 min, Cycle Time = 15 Sec/Comp, Output per Man (460*60/15) = 1840 Nos.</p>												
REGISTRATION NO.:	P14/KK/2018/005												
DATE:													
REGISTERED BY:													
MANAGER SIGN:	Mr. Manas Kumar Dey												
HPL/QMS/FR/09/E, Rev. No.:03, Rev. Date:23.01.2018													

BENCHMARK:	920 Nos
TARGET:	1840 Nos
KAIZEN START:	21.04.18
TARGET DATE:	05.05.18
KAIZEN FINISH:	26.04.18
TEAM MEMBERS:	
Mr. N.S.Pujari	
Mr. Manas Dey	
BENEFITS:-	Productivity improved

KAIZEN SUSTAINANCE
WHAT TO DO:
Fixture & Process Design to be Updated
HOW TO DO:
Through MP Sheet
FREQUENCY:
One Time Action

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
Sr.No	CELL/PRODUCT	TDC	RESP.	STATUS
1.	A545/60		N.S.Pujari	Closed

HD SCOPE INFORMATION IN OTHER PLANT				
Sr.No.	PLANT	WHEN	WHOM	STATUS
1				

