

TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN NO:-	
TPM CIRCLE NAME :-	LOSS NO. / STEP										
DEPT :-Assy.-P3	RESULT AREA	P	Q	DEF :- B		C	D	S	M		
CELL :- Tensioner A379	CELL NAME:- Tensioner A379	MACHINE / STAGE:- Plug pressing						OPERATION :- Plug pressing			

**KAIZEN THEME** To reduce set-up & adjustment loss at plug pressing m/c in Tensioner discover Cell.

**IDEA :-** No setting time.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Change the sensor position. Thread sensor mount in Batch code marking m/c.

**PROBLEM / PRESENT STATUS :-** Set-up time per occurrence 5 minutes



**BEFORE**



**AFTER**

<b>BENCHMARK</b>	5
<b>TARGET</b>	2
<b>KAIZEN START</b>	10.08.15
<b>KAIZEN FINISH</b>	10.08.15

**TEAM MEMBERS :-**  
Mukesh Singh, Parmeshwar ,Parbhaker

**BENEFITS :-**  
Set up change time reduce.

**KAIZEN SUSTENANCE**

**WHAT TO DO :-** Check on daily basis

**HOW TO DO :-** Check point add in Daily sustenance check sheet.

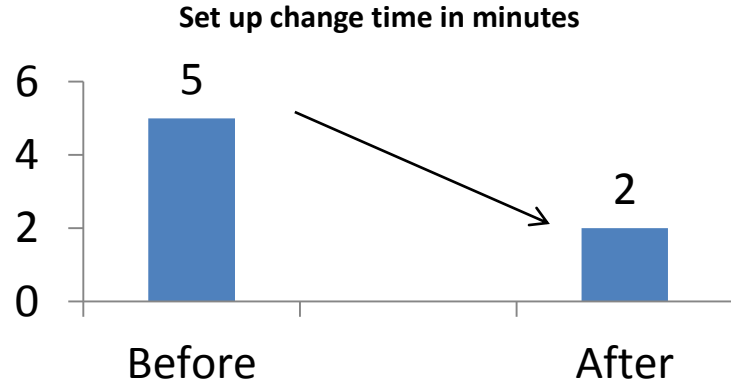
**FREQUENCY :** Daily

COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.
0	0	0

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	NA			

**WHY - WHY ANALYSIS :-**  
**Why 1:-** Set up time more  
**Why 2:-** Plug pressing fixture setting time more.  
**Why 3:-** thread sensor setting time more.  
**Why 4:-** sensor setting time more.

**RESULT :-** Set Up time Per Occurrence 2 Minutes



**ROOT CAUSE:-** Setting time more.

**REGISTRATION NO&DATE:** 10.08.15

**REGISTERED BY :-** Mukesh Singh

**MANAGER'S SIGN :-**