

TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Joshile	LOSS NO. / STEP								
DEPT :- Manufacturing Engg.	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :-A351	CELL NAME:- Drum Change Line	MACHINE / STAGE :- VMC/Machining	OPERATION :- Operation No. 10
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KAIZEN THEME : To Reduce the cycle time In A351 DGS Machining cell at OP#10.

IDEA :- Combination Tool to be Provide for OD trepanning & Chamfering Operation.

WIDELY/DEEPLY:-

COUNTERMEASURE:- Combination tool provided for OD trepanning & Chamfering Operation & Cycle time is 40 Sec Per Component.

BENCHMARK	42 Sec
TARGET	40 Sec
KAIZEN START	05.01.2016
KAIZEN FINISH	31.01.2016

PROBLEM / PRESENT STATUS :- For OD trepanning & Chamfering Operation using one tool with multi program. & Cycle time is 42 sec per Component.

TEAM MEMBERS :-

N.S.Pujari , Mr. Praveen Jannu.
Mr. Shanth Kumar



BENEFITS :-

1. Cycle Time Reduced 42 Sec To 40 Sec
2. Production Increased per Shift from 558 no's to 586 nos .
3. Tool Life Increased 1800 Nos / Insert

Video Clip

Video Clip

BEFORE

AFTER

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why1 :- Cycle time is 42 Sec Per Component
Why 2:- Using single tool with multi program.
Why 3:- No Combination tool.

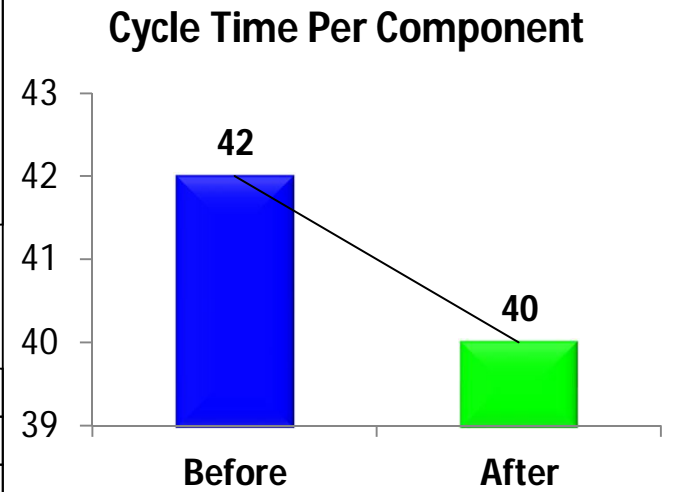
RESULT :-

WHAT TO DO: Change the tool life In PCP.

HOW TO DO: -----

FREQUENCY : One time Action.

ROOT CAUSE :- No Combination tool.



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE: #1004, 30.01.16

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- N.S Pujari

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	A351 L2	30-03-16	M.E & Prod.	Open.

MANAGER'S SIGN :- N.S.Pujari