

TPM CIRCLE NO :-04	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Oil pump	LOSS NO. / STEP								
DEPT : Machine Shop	RESULT AREA	P	Q	DEF:-A		C	D	S	M

CELL :- A 373	CELL NAME: Oil Pump	MACHINE / STAGE :- CNC Mazak	OPERATION- Machining
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KAIZEN THEME - : To Increase Productivity.

WIDELY/DEEPLY:-

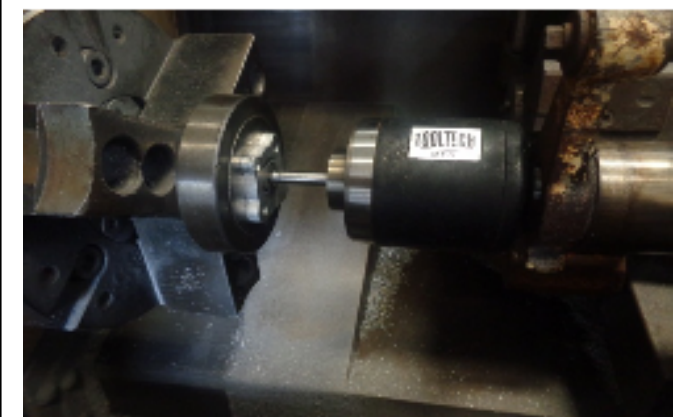
PROBLEM / PRESENT STATUS :- A373 Cover Loading Unloading Time More due to Manual Clamping.(Cy time – 55sec/job)



IDEA :- Provide Auto Clamping.

COUNTERMEASURE- Revolving Centre provide in Tailstock for Auto Clamping

AFTER (Cy time – 25sec/job)



BENCHMARK	Manual Clamping
TARGET	Auto Clamping
KAIZEN START	06.08.15
KAIZEN FINISH	27.08.15

TEAM MEMBERS :-
Umesh Pimple ,Someshwar Salunke
Nitin Sutar

BENEFITS :- Production /hr. Increased.

KAIZEN SUSTENANCE

WHAT TO DO : Use Auto Clamping

HOW TO DO : Provide Revolving Centre.

WHY - WHY ANALYSIS :-
Basic Design of Process is Manual Clamping.

ROOT CAUSE :- Basic Design of Process is Manual Clamping.

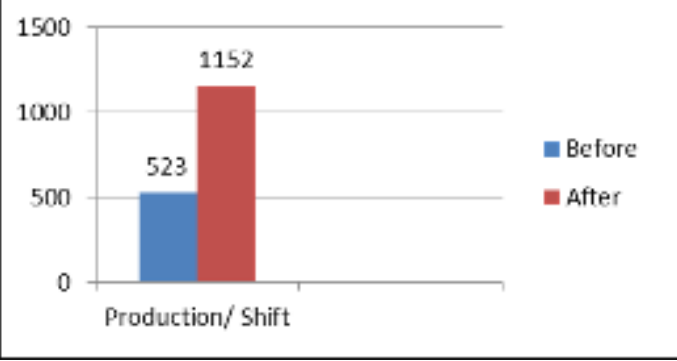
REGISTRATION NO. & DATE: - 27.08.2015

REGISTERED BY :- Umesh Pimple

MANAGER'S SIGN :-Surendra Kulkarni.

RESULT :-
1)Loading / Unloading Time decreased.

2) Rejection Due to Loose Clamping Eliminated.



SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
	A373 Cy 1 st set up	14.10.15	Umesh	Inprocess