

# KAIZEN CT REDUCTION – A247 VMC

<b>ADVIK</b>	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	<b>KAIZEN IDEA SHEET</b>						
Plant-1, Chakan.	TPM Circle Name:	Loss no.	✓									<b>Kaizen No.:</b>					
	Dept.: Machine Shop.	Step															
Cell No.: A247	Cell Name: BKT	Result Area	P	Q-Def. A / B / C			C	D	S	M	<b>Operation : Machining</b>						
<b>Kaizen Theme:</b> To reduce cycle time per components.		<b>Idea :</b> To reduce air cut time.															
		<b>Counter Measure:</b> Air cutting time reduce by modifying program & cutting parameter to be adjust.															
<b>Problem / Present Status:</b> 1.A247 bkt not feed customer line as per requirement .		<b>Before :</b> 49 sec/component 74 nos component/hr					<b>Bench Mark</b>		49 sec								
							<b>Target</b>		40 sec								
							<b>Kaizen Start</b>		25.08.2014								
							<b>Kaizen Finish</b>		28.08.2014								
							<b>Team Members With Sign :</b> 1)Nana Ugale 2)Nitin Sutar										
							<b>Benefits:</b>										
							P	Productivity improved									
							Q										
							C										
							D	Loss at customer end reduced									
							S	_____									
							M	_____									
							<b>Kaizen Sustenance :</b>										
							<b>What to do :</b> 1. Not to change in Program. 2. Inspection as per frequency.										
							<b>How to do :</b> 1. Program lock by edit key.										
<b>Root Cause :</b> Excess Air cutting time		<b>Result :</b> Cycle Time Reduced By 9 sec/ Component.															
		<table border="1" style="margin: auto; border-collapse: collapse;"> <caption>Cycle Time Comparison</caption> <thead> <tr> <th>Phase</th> <th>Cycle Time (sec)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>49</td> </tr> <tr> <td>After</td> <td>40</td> </tr> </tbody> </table>										Phase	Cycle Time (sec)	Before	49	After	40
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Before	49																
After	40																
Registration no.& dt :28/08/2014		<b>Scope &amp; Plan for Horizontal Deployment</b>															
Submitted by : Nana Ugale																	
Manager's Sign :Suresndra Kulkarni																	
Sr. no.	Model	Target Date	Responsibility	Status													
-	-	-	-	-													