

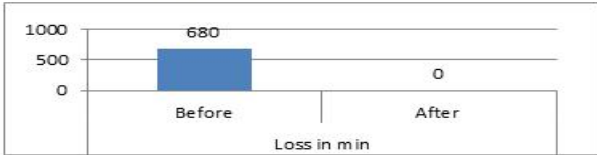


# KAIZEN - Minor stoppage

PROD

<b>ADVIK</b>	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	<b>KAIZEN IDEA SHEET</b>						
	TPM Circle Name:	Loss no.															
Plant-1 Chakan		Step									<b>Kaizen No.:</b>						
	Dept.: Machine Shop	Result Area	P	Q-		C	D	S	M								
Cell No.: 01	Cell Name: A380 rotor grinding	Process / Stage : Grinding m/c								Operation : Machining							
<b>Kaizen Theme:</b> To reduce minor stoppage on rotor grinding machine.		<b>Idea :</b> Manual chute provided on machine to avoid machine minor stoppage.															
		<b>Counter Measure:</b> Chute provided on machine to avoid minor stoppage of machine.															
<b>Problem / Present Status:</b> 1) After every cycle operator stop the machine & moved to machine back side to collect aluminum support block. 2) Additional manpower used on grinding machine.		<b>Before :</b> NO Chute available. One operator required to collect stopper OR operator stop machine and collect stopper by his own.				<b>Bench Mark</b>		680 min									
						<b>Target</b>		0 min									
						<b>Kaizen Start</b>		15-May-14									
		<b>Kaizen Finish</b>		28-May-14		<b>Team Members With Sign :</b> 1 Dinesh kakad 2 Surendra kulkarni 3. Nana ugale											
		<b>Benefits:</b>															
		P		One additional manpower saved.													
		Q		No rejection.													
		C		One man save													
		D															
		S															
		M															
		<b>Kaizen Sustenance :</b>															
		<b>What to do :</b> 1. Chute installed on machine.															
		<b>How to do :</b> Collect support block from front side of machine.															
<b>Why Why Analysis :</b> Why 1): Operator required to stop machine after every cycle 2) To collect support block he stop machine. 3) No provision available on machine to collect block from machine back side.		<b>After :</b> Chute installed on machine to collect stopper.															
																	
<b>Root cause-</b> No provision available on machine to collect support block.		<b>Result :</b> Minor stoppage loss reduced from 680 min to 0 min.															
		 <table border="1"> <caption>Loss in min</caption> <thead> <tr> <th>Category</th> <th>Loss (min)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>680</td> </tr> <tr> <td>After</td> <td>0</td> </tr> </tbody> </table>										Category	Loss (min)	Before	680	After	0
Category	Loss (min)																
Before	680																
After	0																
Registration no.& dt : :30/05/14																	
Submitted by : Nana ugale																	
Manager's Sign : Surendra Kulkarni																	
<b>Scope &amp; Plan for Horizontal Deployment</b>																	
Sr. no.	Model	Target Date	Responsibility	Status													
1																	