

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

KAIZEN IDEA SHEET

F/IMS/05

CELL: 128/A467 CELL NAME: Tensioner MACHINE / STAGE: MTR15E OPERATION: Thread Rolling

KAIZEN THEME: To reduce JH time of removal of chips @ thread rolling m/c.

WIDELY/DEEPLY:

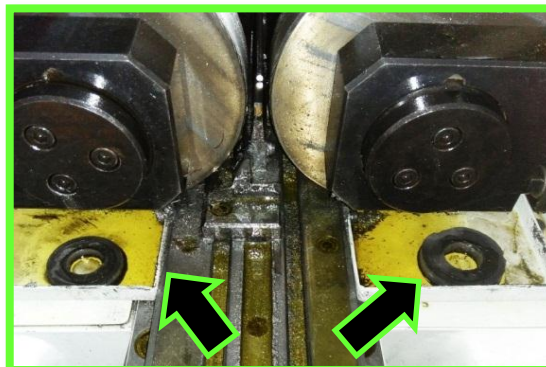
PRESENT STATUS: Operator takes 10min to clean the chips .



BEFORE

IDEA: Easy to access.

COUNTERMEASURE : Provided magnets below the thread rolls which extracts chips & easy to extracted chips.



AFTER

BENCHMARK	10 min
TARGET	4min
KAIZEN START	12.01.17
KAIZEN FINISH	13.01.17

TEAM MEMBERS:

Mr. Sridhar
Miss Aruna V

BENEFITS:

1. Cleaning time reduced.
2. Operator moral increased.

KAIZEN SUSTENANCE

WHAT TO DO : Place magnets below the thread rolls for chip cleaning.

HOW TO DO : Manually

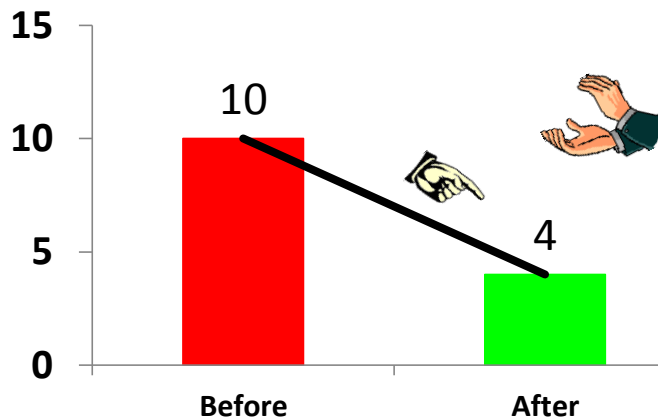
FREQUENCY : Once in a shift.

WHY - WHY ANALYSIS :-

- Why1:** Operator takes 10min to clean the chips
- Why2:** Chip accumulation below the thread rolls.
- Why3:** Hard To access..

ROOT CAUSE:- Hard to access.

RESULT:- Chips Cleaning time reduced from 10min to 4min



REGISTRATION NO. & DATE: 1446 & 16.01.17

REGISTERED BY: Mr. Guru Bassappa

MANAGER'S SIGN: Mr. Chamaraj

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 140/-	-----	INR 140/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS

No Scope in P14