

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: A467 CELL NAME: Tensioner MACHINE / STAGE: Ace Colt 2 OPERATION: Facing Grooving & ID Boring

KAIZEN THEME: To reduce cycle time in A467 Tensioner machining cell.

WIDELY/DEEPLY:

PRESENT STATUS: Current Cycle time @ machining stage is 30 sec.



BEFORE

IDEA: M/c tool change over should not be indexing type.

COUNTERMEASURE : Changed m/c make from indexing type to gang type make & reduced tool indexing time to approx. 1.5 sec / tool.



AFTER

BENCHMARK	30 sec
TARGET	25 sec
KAIZEN START	10.01.2017
KAIZEN FINISH	20.03.2017

TEAM MEMBERS:
Mr. N.S.Pujari,
Mr. Praveen Jannu

- BENEFITS:**
1. Productivity increased.
 2. Cycle time reduced.

KAIZEN SUSTENANCE

WHAT TO DO : Ir reversible Kaizen.
HOW TO DO : -----
FREQUENCY : One time action.

WHY - WHY ANALYSIS :-

- Why1:** Current Cycle time @ machining stage is 30 sec.
- Why2:** Tool indexing time is approx. 2.5 sec / tool.
- Why3:** Tool change over is indexing type.

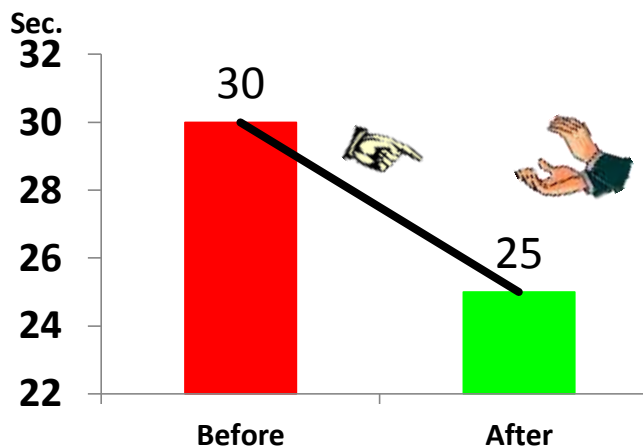
ROOT CAUSE:- Tool change over is indexing type.

REGISTRATION NO. & DATE: 1579 & 22.03.17

REGISTERED BY: Mr. Nigamananda

MANAGER'S SIGN: Mr. Chamaraj

RESULT:- Cycle time reduced from 30 sec to 25



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	-----	-----

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS

Implemented in all Tensioner cells