

K2

TPM CIRCLE NO: 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME: Joshile	LOSS NO. / STEP								
DEPT: Manufacturing Engineering	RESULT AREA	P	Q	DEF:-A	C	D	S	M	

# KAIZEN IDEA SHEET

F/IMS/05

CELL: A490    CELL NAME: CBS    MACHINE / STAGE: Riveting/Assembly    OPERATION: Riveting

**KAIZEN THEME:** To reduce tool changeover time of A490 CBS in riveting process

**WIDELY/DEEPLY:**

**PRESENT STATUS :** Present Riveting tool change over time is average 20 min / month .

- 1) Tool Description : Riveting Tool
- 2) Tool Life ` : 40000 Nos
- 3) Tool Change Over time : 10 Min
- 4) Average Production/Month : 80000 Nos
- 5) Insert Change over time : 20 Min /Month



There Is slot for tool Holding

**BEFORE**

**IDEA:** Slot to be provided for tool holding .

**COUNTERMEASURE :** Slot provided for holding tool for easy removing & Now tool changeover time is average 10min/Month

- 1) Tool Description : Riveting Tool
- 2) Tool Life ` : 40000 Nos
- 3) Tool Change Over time : 5 Min
- 4) Average Production/Month : 80000 Nos
- 5) Insert Change over time : 10 Min /Month



slot for tool Holding by spanner

**AFTER**

<b>BENCHMARK</b>	20 Min
<b>TARGET</b>	10 Min
<b>KAIZEN START</b>	10.09.2017
<b>KAIZEN FINISH</b>	25.09.2017

**TEAM MEMBERS:**  
Mr.Prabhakar & Mr. Girish

**BENEFITS:**

- 1) Tool Change over time is save 10 min / Month

**WHY - WHY ANALYSIS :-**

**Why1:** Present Riveting tool change over time is average 20 min / month .

**Why2:** There is no slot for tool holding for easy removing.

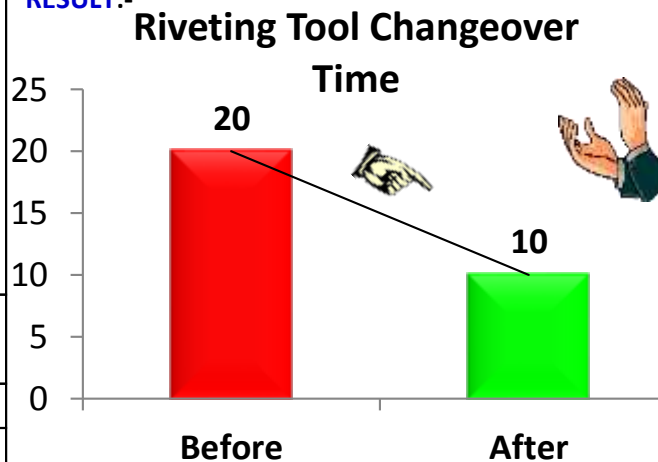
**ROOT CAUSE:-** There is no slot for tool holding for easy removing.

**REGISTRATION NO. & DATE:** 1863 & 31.08.2017

**REGISTERED BY:** Mr. Shivaramu.Mahadevu

**MANAGER'S SIGN:** Mr. N.S.Pujari

**RESULT:-**



**KAIZEN SUSTENANCE**

**WHAT TO DO :-** Tool to be change by respective spanner

**HOW TO DO :** Manual

**FREQUENCY :-** Regular Activity

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESP.	STATUS

No Scope @P14 Case Study Shared to Other Plant for HD