


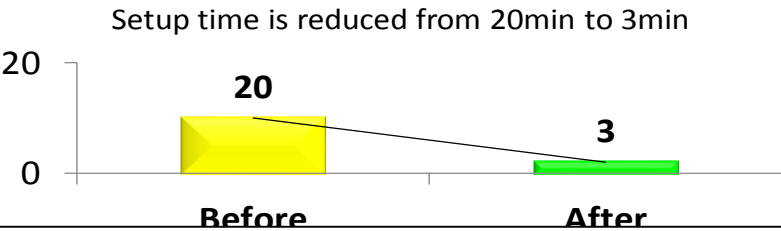


AD  IK		TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET
		TPM CIRCLE NAME :		LOSS NO./STEP									
Plant : P14		DEPT :	Production	RESULT AREA	C	Q	P	P,C	S	M,D	P,C	M	
CELL :	A665/A627	CELL NAME :	TENSIONER		M/C STAGE:	ACE COLT CUB			OPERATION:	Facing, Tapping Grooving			
KAIZEN THEME :		KAIZEN IDEA :											
To reduce setup time in A665/A627 Line		Jaws design has be changed to use two parts at a time without Change the jaws						<b>BENCHMARK:</b>		20 min			
								<b>TARGET:</b>		3min			
								<b>KAIZEN START:</b>		05.10.18			
PROBLEM PRESENT STATUS :		COUNTERMEASURE:						<b>TARGET DATE:</b>		09.10.18			
Setup time is more by 20min		Made a curve on face of the jaws for A627 part						<b>KAIZEN FINISH:</b>		08.10.18			
								TEAM MEMBERS:					
								Mr.Anirudh		Mr. Satish			
								BENEFITS:-					
								Cycle time is reduced from 1min 23 sec to 1min 16sec					
WHY-WHY ANALYSIS:		BEFORE			AFTER			KAIZEN SUSTAINANCE					
<b>Why1:-</b> Setup time is more by 20min <b>Why2:-</b> Jaws need to change during setup. <b>Why3:-</b> Found clamping mark on part after machining <b>Why4:-</b> Part to part design is different								<b>WHAT TO DO:</b> It reversible Kaizen..					
								<b>HOW TO DO:</b> -----					
								<b>FREQUENCY:</b> One time activity					
								SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT					
								SR. NO	CELL/ PRODUCT	TDC	RESP.	STATUS	
								1	A337	30.09.18	Prod	Close	
ROOT CAUSE		RESULTS:											
Jaws design was not made for both part													
REGISTRATION NO.: P14/KK/2018/38 DATE: 15.11.2018 REGISTERED BY: Mr. Omprakash Barik MANAGER SIGN: Mr. Manas Kumar Dey		Setup time is reduced from 20min to 3min 						<b>HD SCOPE INFORMATION IN OTHER PLANT</b>					
								SR.NO.	PLANT	WHEN	WHOM	STATUS	