

K1

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

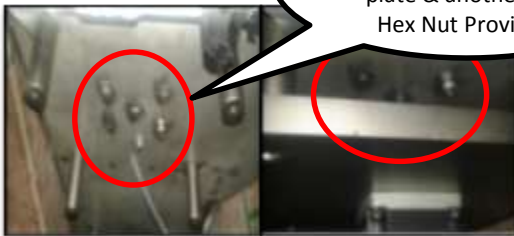
CELL: A530 CELL NAME: Tensioner Assy. MACHINE / STAGE: Winding / Assembly OPERATION: Winding

KAIZEN THEME: To Reduce Set-up change over time of A530 Tensioner Assy. @ Assy. Stage in Winding Station

WIDELY/DEEPLY:

PRESENT STATUS : Set-up changeover time is 20 min for changeover of Winding Fixture from Model A530 to A627 or vice versa

Two HTA area one is Servo Motor bottom plate & another one Hex Nut Provision



BEFORE

IDEA: Provision to be provided @ Top plate for Nut Holding (For Removing & tightening) .

COUNTERMEASURE : Provided Fixed Bottom plate with Hex nut Provision , Now No need to remove bottom servo motor plate for changeover of fixture

Fixture Plate There is no Hot to access area for changeover Fixture



AFTER

BENCHMARK	20 min
TARGET	5 min
KAIZEN START	18.12.17
KAIZEN FINISH	22.12.17

TEAM MEMBERS:
Mr. Mallikarjuna & Mr.Murali

BENEFITS:

- 1) Fixture Change over time reduced from 20 min to 5 min.
- 2) Hot to access to easy to access.
- 3) Setter Friendly .
- 4) Easy to Change Fixture by operator also

WHY - WHY ANALYSIS :-

Why1: Set-up changeover time is 20 min for changeover of Winding Fixture from Model A530 to A627 or vice versa

Why2: Bottom Assy. Servo Motor plate need to remove every time.

Why3No Provision @ top plate for Nut Holding (For Removing & tightening) .

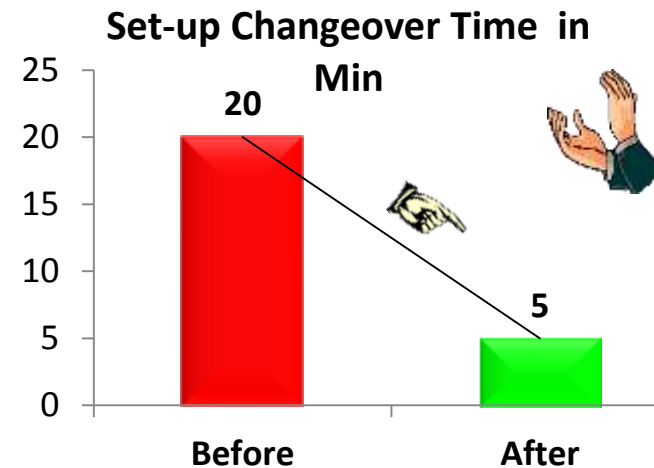
ROOT CAUSE:- No Provision @ top plate for Nut Holding (For Removing & tightening) .

REGISTRATION DATE: 23.12.17
REGISTRATION NO : P14/KK/2018/014

REGISTERED BY: Mr. Manas KP

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

RESULT:-



KAIZEN SUSTENANCE

WHAT TO DO :- --

HOW TO DO :- --

FREQUENCY : One time 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 in P14 , Kaizen share to CME for HD Implementation @ other plants