



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

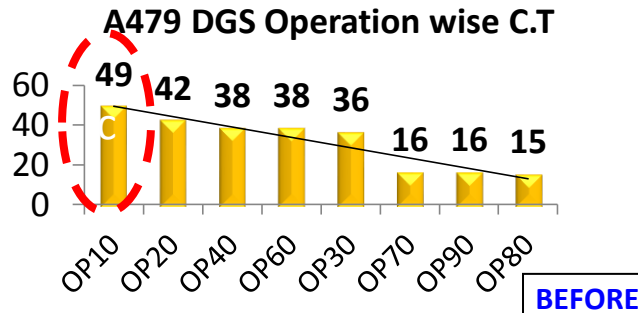
F/IMS/05

CELL: A479 **CELL NAME:** Drum Change **MACHINE / STAGE:** VMC/Machining **OPERATION:** Facing,5 Hole Drilling & Tapping

KAIZEN THEME: To Reduce the cycle time of A479 Drum gear shifter in OP#10 at machining cell.

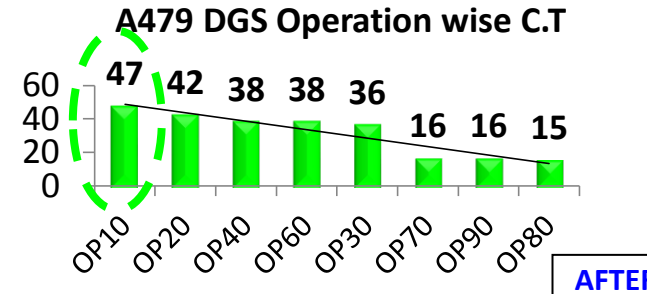
WIDELY/DEEPLY:

PRESENT STATUS : Present A479 Drum gear shifter bottle neck cycle time is 49 sec/comp. at operation 10.



IDEA: OD Tripping tool operation to be eliminate

COUNTERMEASURE : To change the operation method by introducing Ø4.0 hole locating fixture at OP#20 & eliminated OD trepanning tool in OP#10 & C.T is 47 Sec/Comp.



BENCHMARK	C.T 49 Sec
TARGET	C.T 47 Sec
KAIZEN START	20.05.2016
KAIZEN FINISH	20.06.2016

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

- BENEFITS:**
- 1) Increase out Put/hour from 73 Nos to 76
 - 2) Reduce Set-up Changeover time from 25 min to 8 min in Op#10.
 - 3) Save insert changing time 99 min /Annu
 - 4) Save INR 4330/Annum

WHY - WHY ANALYSIS :-

Why1: Present A479 Drum gear shifter bottle neck cycle time is 49sec at operation 10.

Why2: OD Tripping tool operation C.T is 2 Sec/Comp.

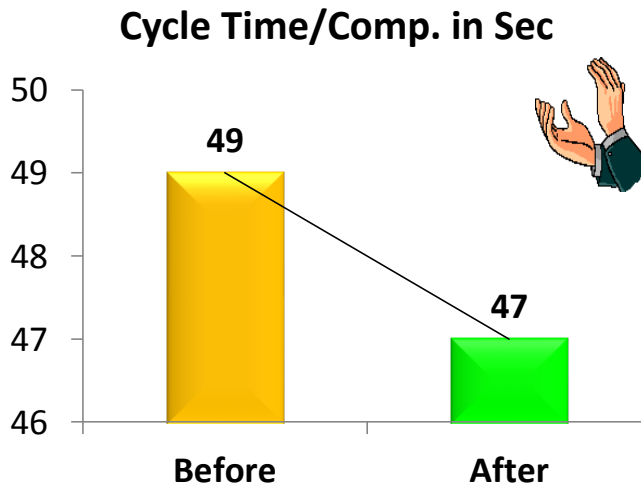
ROOT CAUSE:- OD Tripping tool operation C.T is 2 Sec/Comp.

REGISTRATION NO. & DATE: 1315 ,20.06.16

REGISTERED BY: Mr. Guru Bassappa

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

RESULT:-



KAIZEN SUSTENANCE

WHAT TO DO : Revise the PCP,CP,FPCIR,CPC sheet.
HOW TO DO : ----
FREQUENCY : 1 Time activity

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
200	250	450/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

Sr. No.	CELL	TARGET	RESP.	STATUS
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