

AD  IK		TPM CIRCLE NO :-	5	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET						
		TPM CIRCLE NAME :-	Unique	LOSS NO./STEP															
Plant : P3		DEPT :-	Production	RESULT AREA	C	Q	P	P,C	S	M,D	P,C	M							
CELL : A352	CELL NAME :-	Drum Change		MACHINE STAGE:	VMC Spark Machine			OPERATION:	Drilling & Tapping										
KAIZEN THEME :		KAIZEN IDEA :																	
To Reduce pin change time.		whole fixture not open.						BENCHMARK:	25-30 minute										
		TARGET:							5 -10 minute										
PROBLEM PRESENT STATUS :		COUNTERMEASURE:						KAIZEN START:	20.12.17										
Drum change spark Machine loceting Pin change time more 25-30 min per change time		To Change the Design Ring fixture to square fixture						TARGET DATE:	20.01.18										
								KAIZEN FINISH:	16.01.18										
								TEAM MEMBERS:											
								Jasbir Kumar											
								Yogendra singh											
								Ashok											
		BENEFITS:-						Productivity Increase Operator Moral Increase In House rejection reduced											
WHY-WHY ANALYSIS:		BEFORE			AFTER			KAIZEN SUSTAINANCE											
<b>WHY-1:-</b> Pin change time more 25-30 min per change time  <b>WHY-2:-</b> Pin change time the whole fixture to be opened								WHAT TO DO:											
								Ir-reversible kaizen											
		HOW TO DO:						One Thime Activity											
		FREQUENCY:						6 month Validation											
		SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																	
		SR.NO.	CELL/ PRODUCT	TDC	RESP.	STATUS													
		3	3	Feb.18	M.E	Inprocess													
		HD SCOPE INFORMATION IN OTHER PLANT																	
		SR.NO.	PLANT	WHEN	WHOM	STATUS													
		1	1500	15-Feb	Snehal	Open													
ROOT CAUSE:-		RESULTS:																	
whole fixture opened.																			
		Pin change time in min.																	
REGISTRATION NO.: P3/KK/2018/002																			
DATE: 14.3.18																			
REGISTERED BY: Bipin Dixit																			
MANGERS SIGN: Mr. Amreesh Chauhan																			
AHPL/QMS/FR/09/E, Rev. No.:03, Rev. Date:23.01.2018																			