


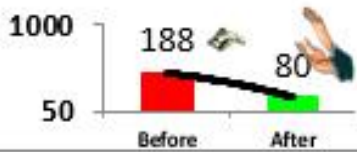


**Success Celebration : Apr18**  
**PM Kaizen : To Improve Quality**  
**Kaizen by : Mr. N S Pujari & Manas dey**

		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 :	A351 DGS	CELL NAME :	Soft Line 1	M/C STAGE:	Winner			OPERATION:			#Op 40 Profile Milling										
KAIZEN THEME :		KAIZEN IDEA :																			
To reduce Cycle time.		MT-3 Carbide blazed dead center to be replaced with MT-3 revolving center .							BENCHMARK:		75 min										
									TARGET:		15 min										
									KAIZEN START:		01.02.18										
									TARGET DATE:		31.03.18										
									KAIZEN FINISH:		31.03.18										
PROBLEM PRESENT STATUS :		COUNTERMEASURE:																			
A611 DGS Cell OP# 40 Cycle time is 188 sec /comp .		Changed from MT-3 Carbide blazed dead center replaced with MT-3 revolving center & increased the Life achieved 1Lakh component /change .																			
WHY-WHY ANALYSIS:		BEFORE					AFTER					KAIZEN SUSTAINANCE									
Why1-> OP# 40 Cycle time is 188 sec /comp												WHAT TO DO:		Tooling others Master List updated							
Why2-> Program feed rate is Low.												HOW TO DO:		Tooling others budget sheet.							
Why3-> Due to Chatter mark getting on track.												FREQUENCY:		One time activity.							
Why4-> Wear & Tear of carbide tip of Dead center.												SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT									
ROOT CAUSE		RESULTS:					<table border="1"> <thead> <tr> <th>SR. N O.</th> <th>CELL/ PRODUCT</th> <th>TDC</th> <th>RESP.</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>1.</td> <td>Widma</td> <td>31.3.18</td> <td>Praveen</td> <td>Closed</td> </tr> </tbody> </table>					SR. N O.	CELL/ PRODUCT	TDC	RESP.	STATUS	1.	Widma	31.3.18	Praveen	Closed
SR. N O.	CELL/ PRODUCT	TDC	RESP.	STATUS																	
1.	Widma	31.3.18	Praveen	Closed																	
Wear & Tear of carbide tip of Dead center.		Cycle time reduced from 188sec/comp to 80sec/comp.																			
REGISTRATION NO.:	P14/KK/2018/003																				
DATE:																					
REGISTERED BY:																					
MANAGER SIGN:	Mr. Manas Kumar Dey																				
AHPL/QMS/FR/09/E, Rev. No.:03, Rev. Date:23.01.2018																					