
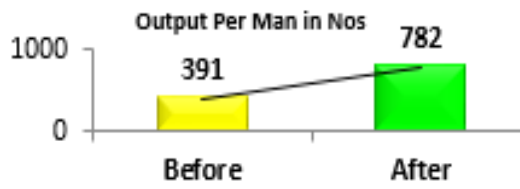


## Success Celebration : Apr 18

### PM Kaizen : To reduce fatigue & Improve Moral

#### Kaizen by : Mr. N S Pujari & Praveen Jannu

 <b>Plant : P14</b>		TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DWI	E & T	KAIZEN IDEA SHEET
		TPM CIRCLE NAME :		LOSS NO./STEP									
CELL :	A545	DEPT :	Production	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M	
CELL NAME :		Tensioner		M/C STAGE:	SPM			OPERATION:			Broaching		
KAIZEN THEME :		KAIZEN IDEA :											
To Increase the Output per Man In A545 plunger. @ Broaching Machining Cell		Non cutting area tool moving time need to reduced											
PROBLEM PRESENT STATUS :		COUNTERMEASURE:											
Present Output per Man is 391 Nos		Non cutting area tool moving speed increased, now 144mm tool moving in rapid travels ..											
WHY-WHY ANALYSIS:		BEFORE					AFTER					KAIZEN SUSTAINANCE	
<b>Why1:</b> Present Output per Man is 391 Nos. <b>Why2:</b> Cycle Time is 60 Sec/Component <b>Why3:</b> Bottleneck Activity – Tool travelling in feed @ non cutting area – 15 sec/Component <b>Why4:</b> Non cutting area tool moving in feed		Shift Length =391 min Cycle Time = 60 Sec/Comp Output per Man(460*60/60*0.85) = 391 Nos  Tool travelling Length 600mm Cutting Area - 456mm in feed Non cutting area - 144mm in feed					Shift Length =782 min Cycle Time = 30 Sec/Comp Output per Man(460*60/30*0.85) = 782 Nos  Tool travelling Length 600mm Cutting Area - 456mm in feed Non cutting area - 144mm in Rapid					WHAT TO DO: Capacity sheet need to update HOW TO DO: Through ME FREQUENCY: One Time Action	
ROOT CAUSE		RESULTS:											
Non cutting area tool moving in feed.													
REGISTRATION NO.:	P14/KK/2018/006												
DATE:													
REGISTERED BY:													
MANAGER SIGN:	Mr. Manas Kumar Dey												
AHPL/QMS/FR/09/E, Rev. No.:03, Rev. Date:23.01.2018													