

K1

TPM CIRCLE NO: 2
TPM CIRCLE NAME: Joshile
DEPT: Manufacturing Engineering

ACTIVITY KK QM PM JH SHE OT DM E&T
LOSS NO. / STEP
RESULT AREA P Q DEF:- A C D S M

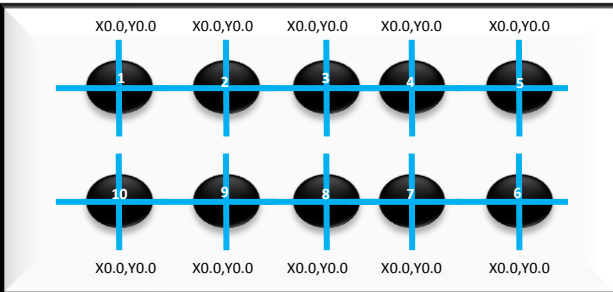
KAIZEN IDEA SHEET
 F/IMS/05

CELL: A374 **CELL NAME:** Oil Pump **MACHINE / STAGE:** VMC/Machining **OPERATION:** Face Milling & Reaming

KAIZEN THEME: To Reduce the Set-up Change Over Time of A374 Oil pump body.

WIDELY/DEEPLY:

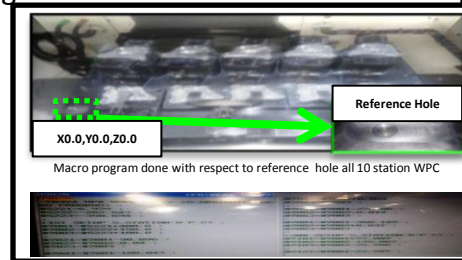
PRESENT STATUS : Present set-up change over time is 480 min for change over of machining fixture from one model to another model



BEFORE

IDEA: One hole reference point provision to be provide in fixture for all 10 station WPC

COUNTERMEASURE : Provided the One Hole reference point provision in fixture for & macro program done with respect to reference hole all 10 station WPC (w.r.t reference hole & Now Fixture Setting time is time is 30 min each set-up change over.



AFTER

BENCHMARK	480 Min.
TARGET	410 Min.
KAIZEN START	15.12.2016
KAIZEN FINISH	23.12.2016

TEAM MEMBERS:
 N.S.Pujari
 Mr. Ambarish

- BENEFITS:**
- 1.Reduce set-up changeover time from 480 Min to 410 Min
 2. Setter Friendly.
 3. Availability increase by reducing Set-up Change over time

WHY - WHY ANALYSIS :-

- Why1:** Present set-up change over time is 480 min for change over of machining fixture from one model to another model
- Why2:** Fixture setting time is more
- Why3:** No of station is 10 Nos for WPC.
- Why4:** No one hole reference point provision in fixture for all 10 station WPC

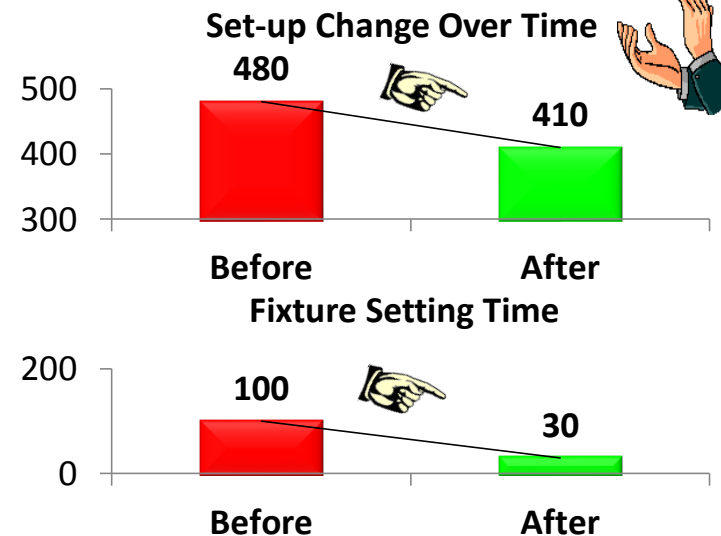
ROOT CAUSE:- No one hole reference point provision in fixture for all 10 station WPC

REGISTRATION NO. & DATE: #1404, 30.12.2016

REGISTERED BY: Mr. Guru Bassappa

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

RESULT:-



KAIZEN SUSTENANCE

WHAT TO DO : WPC to be take from 1 hole reference point
HOW TO DO : Manually
FREQUENCY : while set-up changing

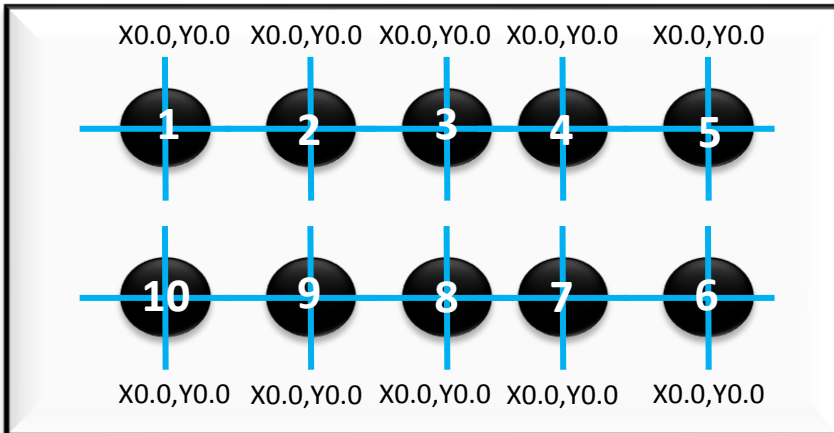
COST INCURRED FOR MAKING KAIZEN

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
1	A177	25.01.17	N.S.Pujari	Open

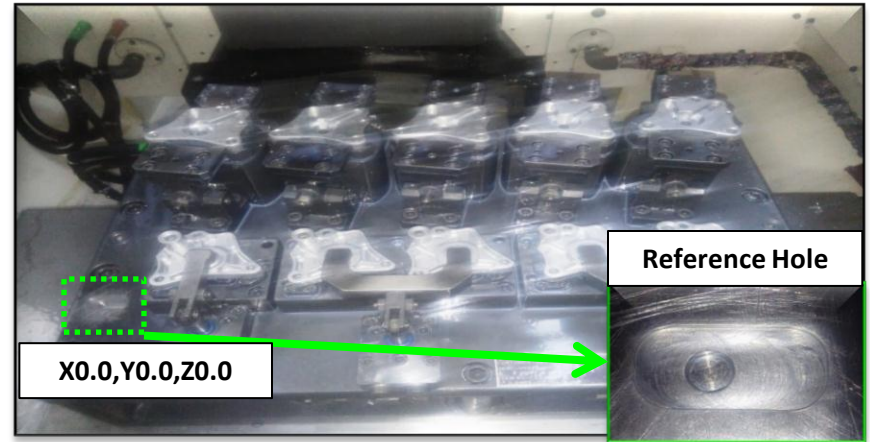
Before



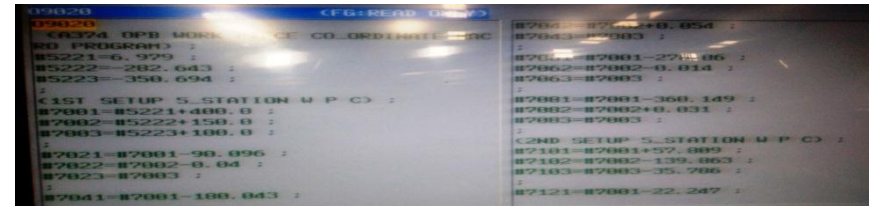
No one hole reference point provision in fixture for all 10 station WPC

WPC to take all 10 station Individually (X0.0,Y0.0)

After



Macro program done with respect to reference hole all 10 station WPC



Provided the one Hole reference point provision in fixture for all 10 station WPC

WPC to take 1-Hole for reference for all 10 station (X0.0,Y0.0)