<b>∆   ) ▼   K</b> P1	TPM CIRCLE NAME : Oil pu	mp	LOSS NO. /	STEP			
11D 111X	DEPT : Machine Shop		RESULT AR		Р	Q	DEF :- A
	L NAME: Oil pump	MACI	HINE / STAG	E:- Mach	nine Sh	юр	
KAIZEN THEME - : To	Increase	IDEA	:- Reduce	e Tool C	Chang	ge Ti	me.
Productivity.		L			\ .1 .		l A
WIDELY/DEEPLY:-			NTERMEAS ng in Proរ	_	Advar	ice i	001 1
PROBLEM / PRESENT	STATUS :- In AMS	AFTE		J. •			
Super dart Machin		AFIE	-K				
time is Increased.	erios i souy cycle	Cycl	e time				
Cycle time		37.8	sec/Com	ponent	t		
50 sec/Component	t	95 C	Componer	nt/hr.			
72 Component/hr		761	ns /Shift				
576 ns /Shift		M I		Ø. U T	AP)	;	
WHY - WHY ANALYSIS	:-	ME	91 G28 3 TØ5 ;	Z0. 0			
Why 1 :- A354 body (	cycle time is	MO	08 ; 0 090 C	195 0	55 )	(-8.	23
Increased.		2	25. 0 -1			300	512
Why 2 :- Tool Change	e Time More.	IIGV		•		-	
Why 3:- Tool Take M	ore time to come in	RESU	ILT	out	put	/Sh	ift
Spindle.		800			10 00 0	,	
Why 4:- Advance Too	ol Not Calling in	700					
Program.		600					_
		500					_
<b>ROOT CAUSE</b> :- Advan	ce Tool Not Calling in	400				761	
Program.		300	576	5			
REGISTRATION NO. &	DATE: _26 08 15	200					_
REGISTRATION NO. &	DATE: -20.06.13	100					
REGISTERED BY :- Ume	esh Pimpale	0					
MANAGER'S SIGN :-Su	rendra Kulkarni.	1	befo	re		after	-
		4					

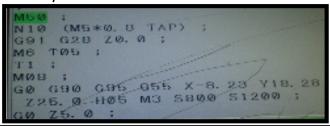
**TPM CIRCLE NO:-04** 

	ACTIVITY	KK	QM	PM	JH	SHE	ОТ	DM	E&T
)	LOSS NO. / STEP								
	RESULT AREA	Р	Q	DEF :- A	A	С	D	S	М

**OPERATION-** Machining

**COUNTERMEASURE**:- Advance Tool Not Calling in Program.

## **AFTER**



RESULT out put/Shif				ft	
800 —					
700					
600		1			
500					
400			761		
300	576				
200					
100					
0 —		1			
before			after		

BENCHMARK	50
TARGET	38
KAIZEN START	26.08.15
KAIZEN FINISH	26.08.15

KAIZEN IDEA SHEET

**TEAM MEMBERS:-**

Dilip Phapale, Nilesh Khadke

**BENEFITS:** Out Put Increased

## **KAIZEN SUSTENANCE**

WHAT TO DO: Not To Change In Program.

**HOW TO DO**: Program to be Lock by Edit Key.

## SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
	- 4nos MC	15.09.15	Dilip Phapale	Inproce ss