

KAIZEN CT REDUCTION – A215

ADVIK	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	KAIZEN IDEA SHEET																																																										
Plant-1, Chakan.	TPM Circle Name:	Loss no.	✓								Kaizen No.: 01																																																										
	Dept.: Machine Shop.	Step																																																																			
		Result Area	P	Q-Def. A / B / C			C	D	S	M																																																											
Cell No.: A215	Cell Name: Drum Change	Process / Stage : LMW M/C								Operation : Machining																																																											
Kaizen Theme: To Increase Productivity.		Idea : Centre Height to be Corrected.																																																																			
		Counter Measure: LMW Machine Centre Height to be Corrected with help of Maint Team within 0.015mm.																																																																			
Problem / Present Status: 1.A215 Drum Change Critical to feed Customer line due to Cycle time Excess (229 ns /Shift).		Before : Cycle time 120 sec/Component 30 Component/hr. 229 ns /Shift					<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td colspan="2" style="text-align: center;">Bench Mark</td><td style="text-align: center;">229</td></tr> <tr><td colspan="2" style="text-align: center;">Target</td><td style="text-align: center;">275</td></tr> <tr><td colspan="2" style="text-align: center;">Kaizen Start</td><td style="text-align: center;">25.11.2014</td></tr> <tr><td colspan="2" style="text-align: center;">Kaizen Finish</td><td style="text-align: center;">26.11.2014</td></tr> <tr><td colspan="3">Team Members With Sign : 1) Someshwar Salunkhe. 2) Bharat Pable.</td></tr> <tr><td colspan="3" style="text-align: center;">Benefits:</td></tr> <tr><td style="text-align: center;">P</td><td colspan="2">Productivity improved</td></tr> <tr><td style="text-align: center;">Q</td><td colspan="2"></td></tr> <tr><td style="text-align: center;">C</td><td colspan="2"></td></tr> <tr><td style="text-align: center;">D</td><td colspan="2">Loss at custoer end reduced</td></tr> <tr><td style="text-align: center;">S</td><td colspan="2" style="text-align: center;">---</td></tr> <tr><td style="text-align: center;">M</td><td colspan="2" style="text-align: center;">---</td></tr> <tr><td colspan="3" style="text-align: center;">Kaizen Sustenance :</td></tr> <tr><td colspan="3">What to do : 1. Not to change in Process. 2. Inseption as per frequency.</td></tr> <tr><td colspan="3">How to do : 1. Program lock by edit key.</td></tr> <tr><td colspan="3" style="text-align: center;">Scope & Plan for Horizontal Deployment</td></tr> <tr> <td style="text-align: center;">Sr. no.</td> <td style="text-align: center;">Model</td> <td style="text-align: center;">Target Date</td> <td style="text-align: center;">Responsi bility</td> <td style="text-align: center;">Status</td> </tr> <tr> <td style="text-align: center;">—</td> <td style="text-align: center;">—</td> <td style="text-align: center;">—</td> <td style="text-align: center;">—</td> <td style="text-align: center;">—</td> </tr> </table>					Bench Mark		229	Target		275	Kaizen Start		25.11.2014	Kaizen Finish		26.11.2014	Team Members With Sign : 1) Someshwar Salunkhe. 2) Bharat Pable.			Benefits:			P	Productivity improved		Q			C			D	Loss at custoer end reduced		S	---		M	---		Kaizen Sustenance :			What to do : 1. Not to change in Process. 2. Inseption as per frequency.			How to do : 1. Program lock by edit key.			Scope & Plan for Horizontal Deployment			Sr. no.	Model	Target Date	Responsi bility	Status	—	—	—	—	—
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Why Why Analysis : Why1: A215 D/C Cycle time Excess (120 sec). Why2: Centre Drill Cutting Time Excess. Why3: Centre Drill Machining in Dwell time . Why4: Centre Drill Breakage & Shift Problem. Why5: Centre Height Disturb by 0.2mm.		After : Cycle time 100 sec/Component 36 Component/hr. 275ns /Shift.																																																																			
Root Cause : Centre Height Disturb by 0.2mm.		Result : Cycle Time Reduced By 20 sec. Out put Increased 46 ns /Shift																																																																			
		<table border="1" style="margin: auto; border-collapse: collapse;"> <caption>Bar Chart Data</caption> <thead> <tr> <th>Category</th> <th>Out Put/Shift</th> <th>Cy. Time</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>229</td> <td>120</td> </tr> <tr> <td>After</td> <td>275</td> <td>100</td> </tr> </tbody> </table>										Category	Out Put/Shift	Cy. Time	Before	229	120	After	275	100																																																	
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