
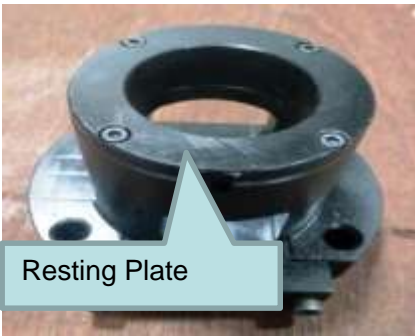
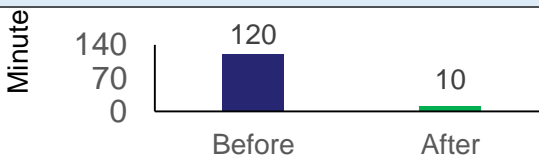


TPM CIRCLE NO :-	5	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET
TPM CIRCLE NAME :	Unique	LOSS NO./STEP									
Plant : P3	DEPT :	Heat Treatment	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	
CELL : A352	CELL NAME :	Drum Change	MACHINE STAGE:	VMC Spark			OPERATION:	Drilling & Tapping			

KAIZEN THEME :	KAIZEN IDEA :	BENCHMARK:	120 - 130 Minutes
To Reduce the Set up Time	Design Appropriate	TARGET:	10 - 15 Minute

PROBLEM PRESENT STATUS :	COUNTERMEASURE:	KAIZEN START:	20.12.17
We are facing the Problem that Setup time more 120 min. at Drilling & Tapping Machine	To Change the Design of Drilling & Tapping Fixture - Resting Ring to Resting Plate	TARGET DATE:	20.01.18
		KAIZEN FINISH:	16.01.18
		TEAM MEMBERS:	
		Jasbir Kumar	
		BENEFITS:-	
		1. Productivity Increase	
		2. Operator Moral Increase	
		3. In House rejection reduced	

WHY-WHY ANALYSIS:	BEFORE	AFTER	KAIZEN SUSTAINANCE										
WHY-1:- Set up Time More 120 min.			WHAT TO DO:										
WHY-2:- Pin Change time activity more i) Block Remove ii) Ring Remove iii) Pin Change iv) again Fit Ring v) again fit Block vi) Setting			Ir-reversible kaizen										
WHY-3:- Design Not Appropriate			HOW TO DO: One Time Activity										
			FREQUENCY: 6 month Validation										
			SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT										
			<table border="1"> <thead> <tr> <th>SR.NO.</th> <th>CELL/PRODUCT</th> <th>TDC</th> <th>RESP.</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>3</td> <td>3</td> <td>Feb. 18</td> <td>M.E</td> <td>In Process</td> </tr> </tbody> </table>	SR.NO.	CELL/PRODUCT	TDC	RESP.	STATUS	3	3	Feb. 18	M.E	In Process
SR.NO.	CELL/PRODUCT	TDC	RESP.	STATUS									
3	3	Feb. 18	M.E	In Process									

ROOT CAUSE:-	RESULTS:	HD SCOPE INFORMATION IN OTHER PLANT										
Design Not Appropriate		<table border="1"> <thead> <tr> <th>SR.NO.</th> <th>PLANT</th> <th>WHEN</th> <th>WHOM</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>15</td> <td>Feb. 15</td> <td>PME</td> <td>Pending</td> </tr> </tbody> </table>	SR.NO.	PLANT	WHEN	WHOM	STATUS	1	15	Feb. 15	PME	Pending
SR.NO.	PLANT	WHEN	WHOM	STATUS								
1	15	Feb. 15	PME	Pending								
REGISTRATION NO.: P3/KK/2018/005												
DATE: 14.3.18												
REGISTERED BY: Bipin Dixit												
MANGERS SIGN: Mr. Amreesh Chauhan												