

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

CELL :-A372 **CELL NAME:-** A372 Assembly **MACHINE / STAGE :-** A372 flushing **OPERATION :-** Flushing

KAIZEN THEME :- To eliminate rejection of excess flow.

IDEA :-Change flow line of flushing from PVC pipe to metallic pipe.

WIDELY/DEEPLY:-

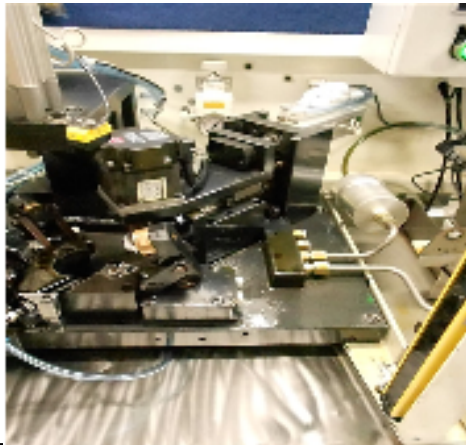
COUNTERMEASURE:- Quick changeover coupling removed & direct metallic pipe connected to flow meter

BENCHMARK	8 nos.
TARGET	0 mins.
KAIZEN START	20.11.2014
KAIZEN FINISH	25.11.2014

PROBLEM / PRESENT STATUS :- Excess flow of oil pump. Observed 5.0 liters/min. Actual req. (1.50 liters/min)

TEAM MEMBERS :-Vishal Chougule, Bhavesh Pednekar

PVC piping of oil flow line for flushing m/c.



BEFORE

AFTER

BENEFITS :-

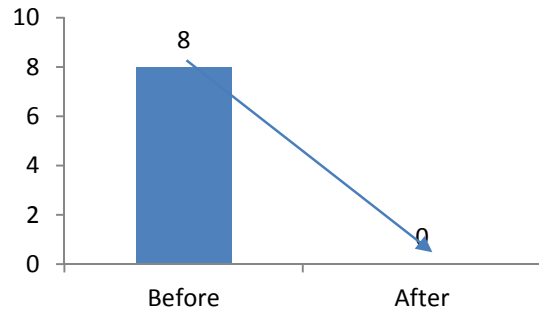
1. Rejection eliminated
2. Loss time reduced

KAIZEN SUSTENANCE

WHAT TO DO: Irreversible
HOW TO DO:
FREQUENCY :

WHY - WHY ANALYSIS :-
Why1: Excess oil flow
Why 2: . Air entrap in oil passing through filter
Why 3:- Air pass with oil through flow meter.
Why4 :- Air entrap in quick changeover coupling in flow line.
Why 5:- Quick changeover coupling is connected with PVC piping.

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
600	200	800

ROOT CAUSE : Quick changeover coupling is connected with PVC piping.

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTRATION NO. & DATE: 20.11.14

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A372 new line	02.12.14	Vishal Chougule	Completed

REGISTERED BY :- Parmeshwar Bansode

MANAGER'S SIGN :- Sunil kinkar