

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

CELL :-Assy CELL NAME:-A337/271 M/C STAGE :-Oil Pump OPERATION :-Free Rotation & Flushing

KAIZEN THEME :- MTBF to be improve

IDEA :- Stopper location to be shift

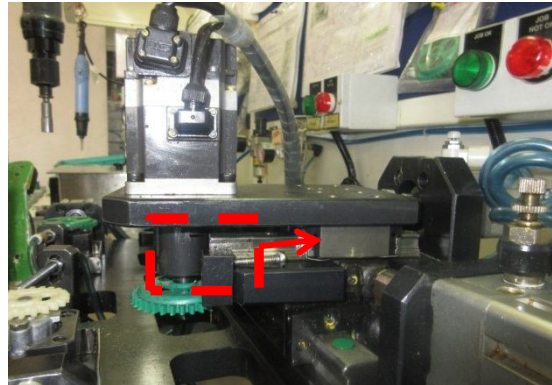
WIDELY/DEEPLY:-

COUNTERMEASURE:- stopper arrangement made at top side of slide by providing 2 angles & a bolt for stroke control

BENCHMARK	15
TARGET	5
KAIZEN START	20.03.2016
KAIZEN FINISH	20.03.2016

PROBLEM / PRESENT STATES:- Stopper provided at the bottom side of cylinder for stroke control which is getting direct contact with LM guide, it intern causing damage on LM guide, & even Hard to set while setup change as there is less space for hand movement.

TEAM MEMBERS :-
Pawan, Chandan



BEFORE



AFTER

BENEFITS :-
1. Set up time will reduce
2. MTBF will increase

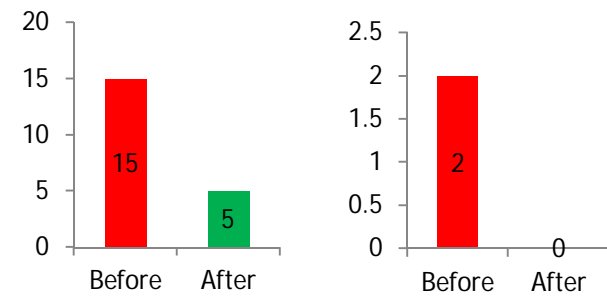
KAIZEN SUSTENANCE

- Why1 :-** Shifted the location of stopper.
- Why2 :-** Slide getting jam
- Why3 :-** Lm guide damage
- Why4 :-** Direct contact with the stopper

RESULT:- 1. Setup time reduced from 15 minutes To 5 minutes
2. Break down eliminated

WHAT TO DO.
HOW TO DO:
FREQUENCY

ROOT CAUSE :- wrong design



COST INCURRED

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
100	---	100

REGISTRATION NO. & DATE: #1064, 20.03.2016

HORIZONTAL DEPLOYMENT

REGISTERED BY :- Dinesha.M

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A478	10.04.16	Pawan	Completed

MANAGER'S SIGN :-