

TPM CIRCLE NO: 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME: Joshile	LOSS NO. / STEP								
DEPT: Manufacturing Engineering	RESULT AREA	P	Q	DEF:- A		C	D	S	M

KAIZEN IDEA SHEET

F/IMS/05

CELL: A529 CELL NAME: Oil Pump Body & Cover MACHINE / STAGE: VMC/Machining OPERATION: Face Milling , Reaming, Drilling & Taping

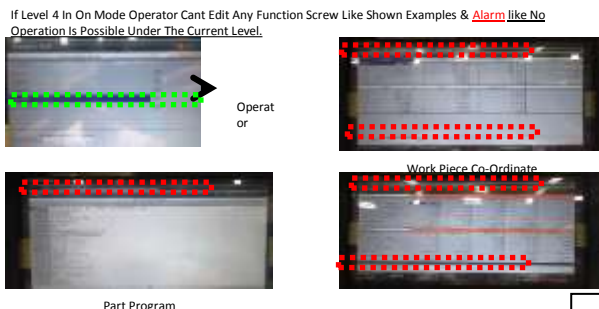
KAIZEN THEME: To eliminate may happen machine accident.

WIDELY/DEEPLY:

PRESENT STATUS : Present In Brother Machine there is no any interlock System for process tools (Like Program interlock, Tool life, Tool Offset ,WPC offset etc..)

IDEA: Process Interlock System to be Implemented

COUNTERMEASURE :- Process Interlock system implemented by Level wise password & Now there is no any may happen accident due to operator errors.



BEFORE

AFTER

BENCHMARK	01 Nos
TARGET	Zero
KAIZEN START	29.04.2017
KAIZEN FINISH	29.04.2017

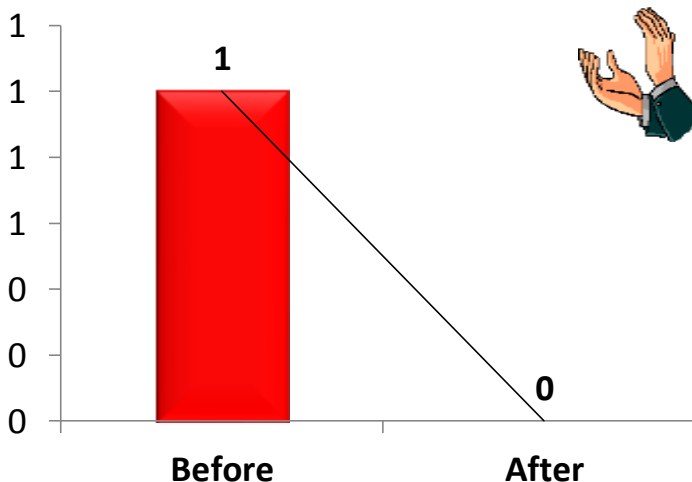
TEAM MEMBERS:
Mr. N.S.Pujari.

BENEFITS:
1) Eliminated May happen machine accident

WHY - WHY ANALYSIS :-

- Why1:** Present In Brother Machine there is no any interlock System for process tools (Like Program interlock, Tool life, Tool Offset ,WPC offset etc..)
- Why2:** Chance of may happen machine accident.
- Why3:** Process Interlock System not Implemented.

RESULT:- May Happen Machine Accident



KAIZEN SUSTENANCE

WHAT TO DO : ---
HOW TO DO : ----
FREQUENCY : 1 Time activity

COST INCURRED FOR MAKING KAIZEN

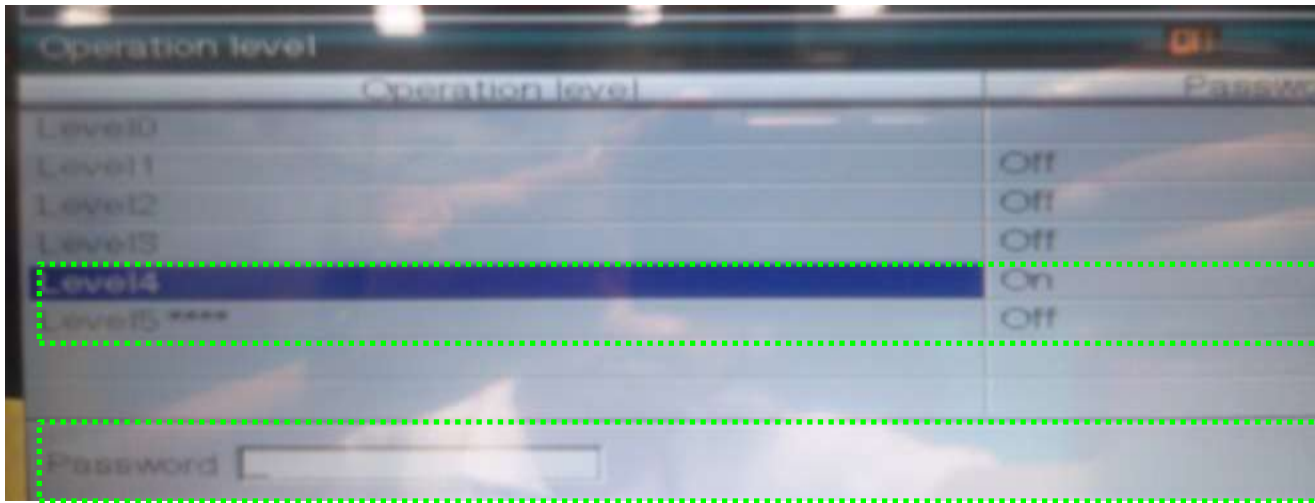
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

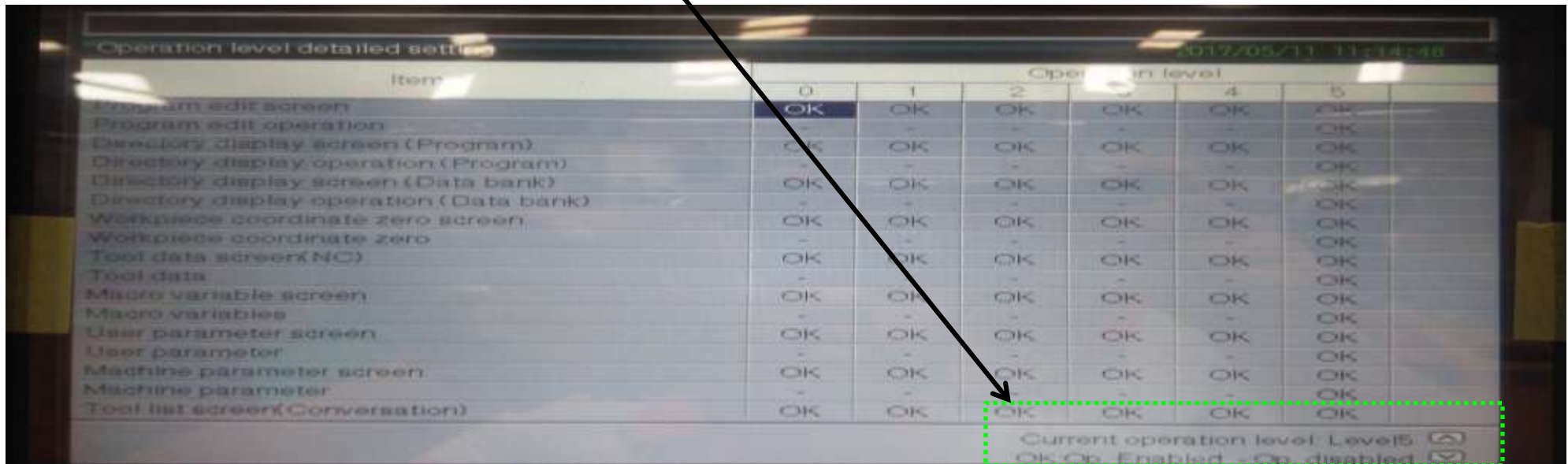
SR. NO.	CELL	TARGET	RESP.	STATUS
1	All Brother	30.05.17	N.S.Pujari	Open

ROOT CAUSE:- Process Interlock System not Implemented.

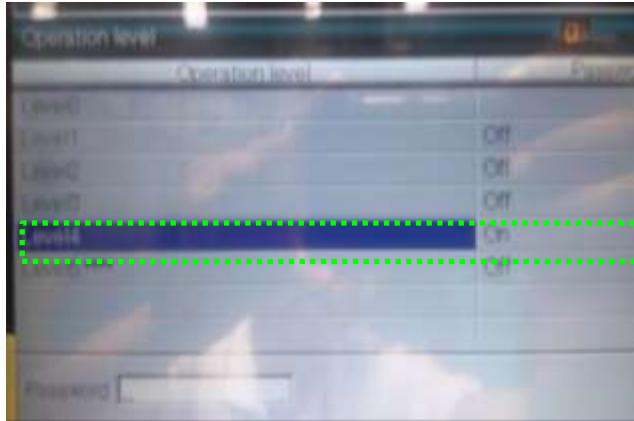
REGISTRATION NO. & DATE: 1609 & 29.04.2017
REGISTERED BY: Mr. Nigamananda
MANAGER'S SIGN: Mr. N.S.Pujari



Operator
 Line Engineer & Maintenance
 Password Interlock



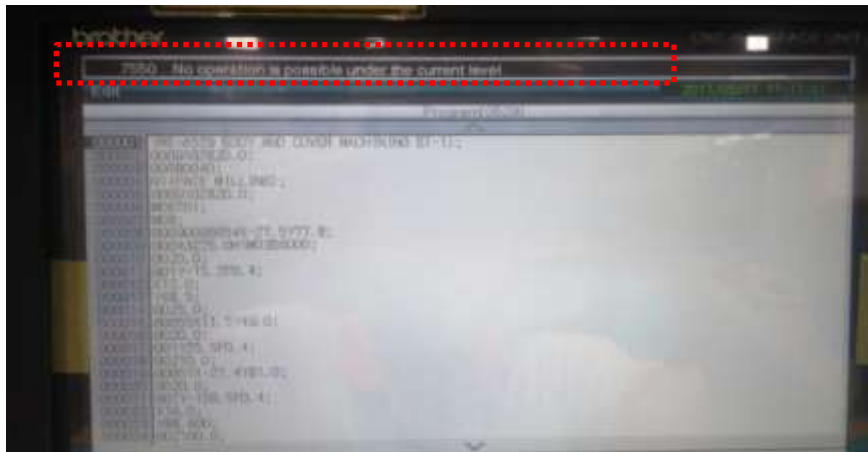
If Level 4 In On Mode Operator Cant Edit Any Function Screw Like Shown Examples & Alarm like No Operation Is Possible Under The Current Level.



Operator



Work Piece Co-Ordinate



Part Program



Tool Offset, Limit Band of Tool Geometry/Wear Offset & Life

Maintenance notice 2017/05/11 11:17:54

No.	Type (unit)	Message	Function	Current value	Target value	Notice	Status
1	Spindle speed (x1000revs)	GREASING XYZ AXIS	Valid	207	207	Notified	Tgt val over
2	None						
3	None						
4	None						
5	None						
6	None						
7	None						
8	None						

Type

0:None 5:4th-axis spd 10:No. of tool changes 15:Side door closed 20:P1 mov. amnt
 1:Spindle spd 6:5th-axis spd 11:Magazine turn pitches 16:Inner door closed 21:P2 mov. amnt
 2:X-axis travel dist 7:6th-axis spd 12:Coolant ON period 17:Servo control ON frequency 22:P3 mov. amnt
 3:Y-axis travel dist 8:7th-axis spd 13:Coolant ON frequency 18:Power ON frequency 23:P4 mov. amnt
 4:Z-axis travel dist 9:8th-axis spd 14:Outer/front door closed 19:Power ON period



7530.001 Maintenance (GREASING XYZ AXIS)

Maintenance notice 2017/05/11 11:17:54

No.	Type (unit)	Message	Function	Current value	Target value	Notice	Status
1	Spindle speed (x1000revs)	GREASING XYZ AXIS	Valid	207	207	Notified	Tgt val over
2	None						
3	None						
4	None						
5	None						
6	None						
7	None						
8	None						

Type