


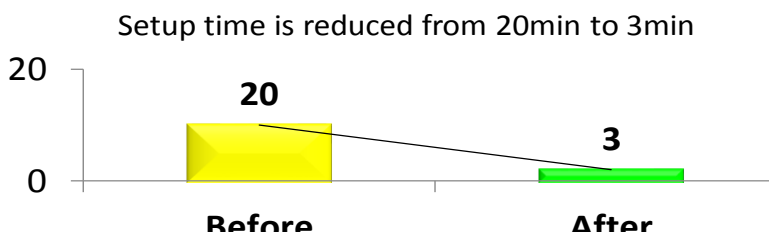


AD  IK		TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET	
		TPM CIRCLE NAME :		LOSS NO./STEP										
Plant : P14		DEPT :	Production	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M		
CELL :	A665/A627	CELL NAME :	TENSIONER		M/C STAGE:	ACE COLT CUB			OPERATION:	Facing, Tapping Grooving				
KAIZEN THEME :		KAIZEN IDEA :												
To reduce setup time in A665/A627 Line		Jaws design has be changed to use two parts at a time without Change the jaws						BENCHMARK:	20 min					
								TARGET:	3min					
								KAIZEN START:	05.10.18					
								TARGET DATE:	09.10.18					
PROBLEM PRESENT STATUS :	Setup time is more by 20min		COUNTERMEASURE:	Made a curve on face of the jaws for A627 part						KAIZEN FINISH:	08.10.18			
								TEAM MEMBERS:						
								Mr.Anirudh		Mr. Satish				
								BENEFITS:-						
								Cycle time is reduced from 1min 23 sec to 1min 16sec						
WHY-WHY ANALYSIS:			BEFORE					AFTER						
Why1:- Setup time is more by 20min														
Why2:- Jaws need to change during setup.														
Why3:- Found clamping mark on part after machining														
Why4:- Part to part design is different														
ROOT CAUSE	Jaws design was not made for both part		RESULTS:	<p>Setup time is reduced from 20min to 3min</p> 										
REGISTRATION NO.:	P14/KK/2018/38													
DATE:	15.11.2018													
REGISTERED BY:	Mr. Omprakash Barik													
MANAGER SIGN:	Mr. Manas Kumar Dey													
KAIZEN SUSTAINANCE														
WHAT TO DO: It reversible Kaizen..														
HOW TO DO: -----														
FREQUENCY: One time activity														
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT														
SR. NO	CELL/ PRODUCT	TDC	RESP.	STATUS										
1	A337	30.09.18	Prod	Close										
HD SCOPE INFORMATION IN OTHER PLANT														
SR.NO.	PLANT	WHEN	WHOM	STATUS										