	TPM CIRCLE NO :-		ACTIVITY	1	KK	QM	PM	JH	SHE	ОТ	DM	E&T	1/1/7			ICCT		
ADVIK P14	TPM CIRCLE NAME:		LOSS NO. / S										i Kall	en Id	EA Si	1661		
DEI 1:- Machine Shop											D   S   M   F/IMS/05							
CELL :- Rotor Grinding CELL NAME:- Rotor Grinding		·									OPERATION: - Rotors Vibro Machining							
KAIZEN THEME :- Reduce cleaning solution change over time in Vibro m/c.		IDEA :- Replace ball valve (stainless steel) to Ball va										aive (PVC).						
ondingo over time in vibio in/o.		COUNTERMEASURE:- Replaced ball valve								E	BENCHMARK -							
WIDELY/DEEPLY:-			(stainless steel) to Ball valve (PVC) & easy to								TARGET -							
			operate.								KAIZEN START 17.09.15 KAIZEN FINISH 19.09.15							
PROBLEM / PRESENT STATUS :- Casual takes			operate.									MAILEN FIINION 19.09.10						
more time to change over the cleaning												TEAM MEMBERS :- Mr. Ambarish &						
colution											Mr. Shivprasad							
BEFORE																		
											BENEFITS : Change over time reduced from 14 min to 10 min.							
											KAIZEN SUSTENANCE							
											NAME TO DO A Innoversible Keiner							
			AFTER								WHAT TO DO: Irreversible Kaizen HOW TO DO:							
WHY - WHY ANALYSIS	RESULT : Change over time reduced from 14 min									FREQUENCY : One time action.								
Why1: Casual takes more time to change			to 10 min.								TREGOLITOT . One time action.							
over the cleaning solution.																		
Why2: Difficult in ope Why3: Weak design.	erating outlet Ball valve.	15	5 ¬	14														
							4	^										
		1	`		10						COCT INCLIDED FOR MANUALC MAIZEN							
			10 -									COST INCURRED FOR MAKING KAIZEN						
ROOT CAUSE :- Old & Weak Design.										IVIA	MATERIAL COST LABOUR COST TOTAL COST IN RS IN RS							
		5 -									Rs 70		<del>  "</del>			700/-		
			3							SC.	SCOPE & PLAN FOR HORIZONTAL DEPLOYME							
<b>REGISTRATION NO. &amp; DATE: 826 &amp; 20.09.15.</b>		1											SR. CELL TARCET DESPONSIBILITY STATUS					
REGISTERED BY :- Mr. Praveen Jannu		(								NO	D.   "	LL	IARGEI	RESPUN	SIDILI1 Y	SIAIUS		
	MANAGER'S SIGN :- Mr.Ravigouda.H		Before			After												
With total o olole. Wil. Navigouda. I																		