

## Setup-Adjustment Time Reduction Kaizen

P14

TPM CIRCLE NO:	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME:	LOSS NO. / STEP								
DEPT: Production	RESULT AREA	P	Q	DEF:-A	C	D	S	M	
CELL: DGS CELL	CELL NAME: A479	MACHINE / STAGE: OD Turning				OPERATION: Turning			

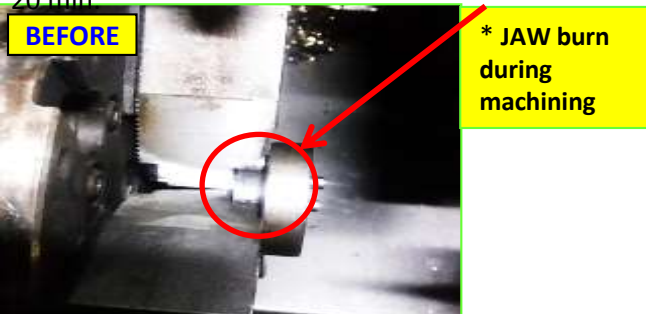
### KAIZEN IDEA SHEET

F/IMS/05

**KAIZEN THEME :** To reduced setup adjustment time.

**WIDELY/DEEPLY:**

**PRESENT STATUS :-** in A479 DGS line OP20 Jaw burning problem is getting during machining in every shift and its adjustment time taken approx. 20 min



**IDEA:** Clamping Fix to be modified.

**COUNTERMEASURE :** Provide a manual stopper on clamping diameter. fixture so that cutting load reduced from JAW (Clamp)



<b>BENCHMARK</b>	40min
<b>TARGET</b>	0 min
<b>KAIZEN START</b>	1-092017
<b>KAIZEN FINISH</b>	1-09-2017

**TEAM MEMBERS:**  
Manas Dey + Anirudh + Purushottam

- BENEFITS:**
1. Improve productivity
  2. Rejection reduced.
  3. Moral improved.

**KAIZEN SUSTENANCE**

**WHAT TO DO :** Added in Fix design

**HOW TO DO :** N/A

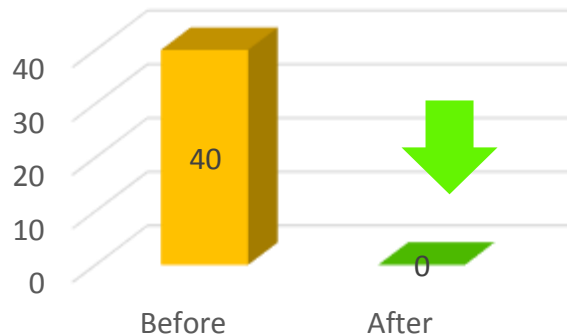
**FREQUENCY :** One time activity.

**WHY - WHY ANALYSIS :-**

- Why1:** Jaw burning problem is getting during machining.
- Why2:** More cutting load on clamping Jaw.
- Why3:** Less clamping area.
- Why4:** Week design

**ROOT CAUSE:-** Week design

**RESULT:-** Adjustment time reduced per day.



COST INCURRED FOR MAKING KAIZEN		
<b>MATERIAL COST</b>	<b>LABOUR COST</b>	<b>TOTAL COST</b>
<b>IN RS</b>	<b>IN RS</b>	<b>IN RS</b>
INR 50/-	-----	INR 50/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
Sr. NO.	CELL	TARGET	RESP.	STATUS
1				

**REGISTRATION NO. & DATE:** 1852 & 22.09.17

**REGISTERED BY:** Mr. Manas.

**MANAGER'S SIGN:** Mr. Chamaraj