Kaizen sheet

PROD

ADVIK	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	KAIZEN IDEA SHEET
	TPM Circle Name:	Loss no.									
Plant-1 Chakan		Step									Kaizen No.:
	Dept.: Machine Shop	Result Area	P	Q-			C	D	S	M	
Cell No.: 01	Cell Name: A170 / A208 / A340body	Process / Stage : CNC-7									Operation : Machining

Kaizen Theme: To reduce setup change time in A170 / A208 / A267

Idea : To made provision in jaws to rest different profile jobs.

Counter Measure: Step boring done to rest A340 /A208 /A170 jobs in same setup.

Problem / Present Status:

1) For Every setup used different jaw set. To change jaw set required

Before : Plane boring Jaws

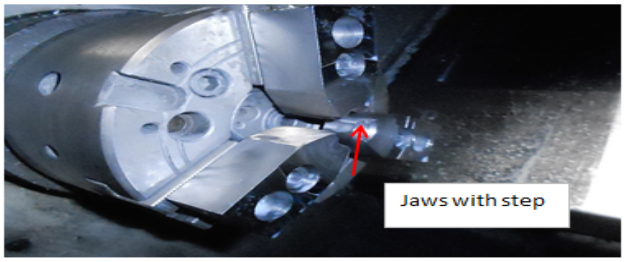
Bench Mark	127 MIN
Target	21.5 MIN
Kaizen Start	28-Apr-14
Kaizen Finish	30-Apr-14

Team Members With Sign :
1.Maruti sagar
2 Nana ugale
3. Vinod Jadhav

Why Analysis :

Why 1): For setup change required 71 mins per setup
Why 2):Every setup used different jaw set .
Why 3): No provision available in jaws to clamp different profile jobs

After : Jaws step boring done.



Benefits:

P	Productivity increased
Q	
C	
D	
S	
M	———

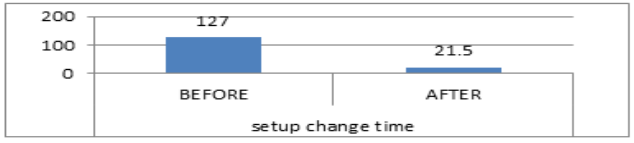
Kaizen Sustenance :

What to do : Fixed Jaws with step to be used for different setups.

How to do : Varify fixed stp jaws are used on machine. Point added in supervisoer check sheet.

Root cause- No provision available in jaws to clamp different profile jobs

Result :
1)Setup time reduce from 127 min to 21.5 min



Registration no.& dt : :02/05/14

Submitted by : Maruti Sagar

Manager's Sign : Surendra Kulkarni

Scope & Plan for Horizontal Deployment

Sr. no.	Model	Target Date	Responsibility	Status
1	_____	_____	_____	_____