

<b>ADVIK</b> P14	TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	<b>KAIZEN IDEA SHEET</b>										
	TPM CIRCLE NAME : Joshile	LOSS NO. / STEP																			
	DEPT :- Manufacturing Engg.	RESULT AREA	P	Q	DEF :- A	C	D	S	M												
CELL :- Rotor GRD	CELL NAME:- Rotor Grinding	MACHINE / STAGE :- Vibro Machine					OPERATION :- Vibro Deburring														
<b>KAIZEN THEME :</b> To Save the new Vibro Machine Purchase Capital Cost during installation of In-house Rotor Grinding set-up.		<b>IDEA :-</b> Separator Jali of Machine should have min. 40% of working area of machine Vibro Barrel size.																			
<b>WIDELY/DEEPLY:-</b>		<b>COUNTERMEASURE:-</b> 1. Increased the Jali area from existing 15% to 40% as per std. requirement. 2. Provided Gravity shooter for auto handling of cleaning media.					<b>BENCHMARK</b>		4.3 Lac INR												
<b>PROBLEM / PRESENT STATUS :-</b> Required new Vibro Maching which cost is 4.3 Lakh							<b>TARGET</b>		0.5 Lac INR												
<div style="background-color: red; color: white; padding: 5px; text-align: center; border-radius: 10px;">Manual Unloading of Rotors</div> <div style="background-color: red; color: white; padding: 5px; text-align: center; border-radius: 10px;">Manual loading of cleaning media in Vibro Machine after process completion</div>		<div style="background-color: green; color: black; padding: 5px; text-align: center; border-radius: 10px;">Auto unloading of rotors</div> <div style="background-color: green; color: black; padding: 5px; text-align: center; border-radius: 10px;">Auto loading of cleaning media in Vibro Machine after process completion</div>		<b>KAIZEN START</b>		27.02.2015															
				<b>KAIZEN FINISH</b>		30.03.2015															
							<b>TEAM MEMBERS :-</b>														
							Appasab Magadum, Pujari														
							<b>BENEFITS :-</b>														
							1. Save 4.30/- Lakh														
							<b>KAIZEN SUSTENANCE</b>														
BEFORE		AFTER					<b>WHAT TO DO:</b> Ir-reversible Kaizen														
<b>WHY - WHY ANALYSIS :-</b>		<b>RESULT :-</b>					<b>HOW TO DO: --</b>														
<b>Why1-</b> P1 Machine is not suitable for Rotor Vibro Cleaning.		<p style="text-align: center;"><b>Save New Machine Cost finally by use of existing machine with modification in design.</b></p> <table border="1" style="margin-top: 10px;"> <thead> <tr> <th>Phase</th> <th>Cost (Lakh)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>4.30</td> </tr> <tr> <td>After</td> <td>0.43</td> </tr> </tbody> </table>					Phase	Cost (Lakh)	Before	4.30	After	0.43	<b>FREQUENCY :</b> Need not monitoring								
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<b>Why2-</b> Ceramic media is also coming outside along-with components.		<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th colspan="3"><b>COST INCURRED FOR MAKING KAIZEN</b></th> </tr> <tr> <th>MATERIAL COST IN RS</th> <th>LABOUR COST IN RS</th> <th>TOTAL COST IN RS</th> </tr> </thead> <tbody> <tr> <td>0.43 Lakh</td> <td>-----</td> <td>0.43 Lakh</td> </tr> </tbody> </table>					<b>COST INCURRED FOR MAKING KAIZEN</b>			MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS	0.43 Lakh	-----	0.43 Lakh						
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<b>Why3-</b> very old model of Machine, Supplier has stop this model as market complaints of same reason that media is also coming outside along-with components.							<b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b>														
<b>Why4-</b> Separator Jali of Machine has less length.							<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th>SR. NO.</th> <th>CELL</th> <th>TARGET</th> <th>RESPONSIBILITY</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>-</td> <td>-</td> <td>--</td> <td>--</td> <td>--</td> </tr> </tbody> </table>					SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS	-	-	--	--	--
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<b>ROOT CAUSE :-</b> Separator Jali of Machine has less length																					
<b>REGISTRATION NO. &amp; DATE:</b> 685 & 30.04.15																					
<b>REGISTERED BY :-</b> Guru Basappa																					
<b>MANAGER'S SIGN :-</b> Ravigouda																					