AD 🔻 IK	TPM CIRCLE NO :-		ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E&T	KAIZEN IDEA Sheet	
	TPM CIR. NAME :		LOSS NO/STEP										
HD OF A545/A663 Plunger	DEPT :		RESULT AREA	C	Q	Р	Р, С	2	M, D	P, C	M	- BIILLI	
CELL : A696 oil pump	CELL NAME :	Oil pump.		MACHINE	STAGE:	Grinding M	achine			OPERATION:		Grinding	
KAIZEN THEME :	KAIZEN IDEA :												
To improve Productivity	Process time need to be	rocess time need to be reduced							BENCHMARK: 23sec				
								TARGET:		15sec			
								KAIZEN STA		06.10.2019			
PROBLEM PRESENT STATUS :	COUNTERMEASURE:							TARGET DA		13.10.2019			
A696 Shaft grinding capacity is 3206/day	Reduced the distance of non Grinding area by doing setup						KAIZEN FINISH: 13.10.2019						
								TEAM MEMBERS:					
								Rahul	ahul Murlli Mohan				
								BENEFITS:-					
								easy to operate , Quality improved, moral improved					
WHY-WHY ANALYSIS:	BEFORE AFTER						KAIZEN SUSTAINANCE						
Whyl:- A696 Shaft Grinding Capacity 3206/day							WHAT TO DO: Fix design need to be update						
Why2:- CT is more i.e 23sec/comp		Distance is	Distance				:= ==: ===:g=== == == == ==						
Why3:- Process time more	more between				reduced between								
·	part and						HOW TO DO:						
							FREQUENCY: One time activity						
ROOT CAUSE:-	RESULTS:						SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT						
Process time more	1. CT reduced by 4 sec	1. CT reduced by 4 sec 2. Capacity increased						SR.NO.	CELL/	TDC	RESP.	SUTATE	
							יחוויאוף.	PRODUCT	IDP	KEDP.	PINIO		
								1.	S 969A	10.10.19	Manas	Completed	
	30 23 4000 3740												
	25	19				37 10							
	20		35	500	3206	D		HD SCOPE INFORMATION IN OTHER PLANT SR.ND. PLANT WHEN WHOM STATUS					
REGISTRATION NO.:	10	10				3000				WHEN	WHOM	2UTAT2	
DATE:	5 0		25	500 —					Kaizen share to Corp				
REGISTERED BY:	Before	After			Before	Aftei	_						
MANGERS SIGN:													