

TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :	LOSS NO. / STEP								
DEPT :-	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

**CELL :-** A431      **CELL NAME:-** Assy      **MACHINE / STAGE :-** Riveting m/c -3      **OPERATION :-** Riveting

**KAIZEN THEME :-** To prevent defect & accident

**IDEA :-** Change the logic.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Replaced the single solenoid valve by double acting solenoid & modified the PLC ckt logic, so that after power failure sliding & clamping cylinders remain in its working position & starts from same interrupted position after the power recovery.

<b>BENCHMARK</b>	0 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	5.10.2015
<b>KAIZEN FINISH</b>	5.10.2015

**PROBLEM / PRESENT STATUS :-**  
During power failure time all cylinders retracting simultaneously, so sliding unit hitting to riveting head & tool.

**TEAM MEMBERS :-**  
Mr.Dinesha.M  
Mr.Pawan



**BEFORE**



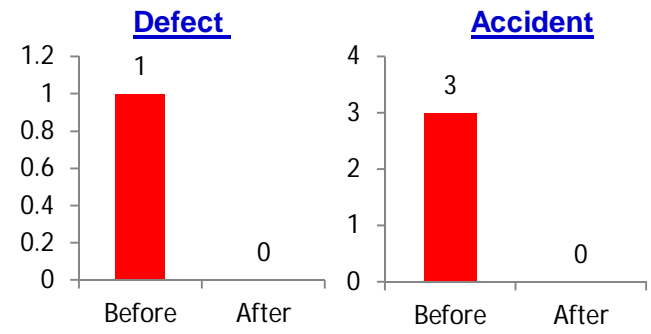
**AFTER**

**BENEFITS :-**  
1.M/C accident avoided  
2.Operation miss eliminated  
3.Customer complaint eliminated

**KAIZEN SUSTENANCE**

**Why1:-**Defect & m/c accident  
**Why2:-**No control of retracting stroke.  
**Why3:-**Single solenoid valve used

**RESULT:-**



**WHAT TO DO.**  
**HOW TO DO:**  
**FREQUENCY:-**One time action

**COST INCURRED**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
8850		8850

**ROOT CAUSE :-**Power failure

**HORIZONTAL DEPLOYMENT**

**REGISTRATION NO. & DATE:** 857 & 05.10.15  
**REGISTERED BY :-** Mr.Dinesha.M  
**MANAGER'S SIGN :-** Mr.Sivasankar.G

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS

CELL :- Utility	CELL NAME:- Main panel board	M/C STAGE :- Main panel board	OPERATION :- Utility
-----------------	------------------------------	-------------------------------	----------------------

<b>KAIZEN THEME :-</b> To prevent power failure defect	<b>IDEA :-</b> Alarm system to be provide for KEB power recovering
--	--

<b>WIDELY/DEEPLY:-</b>	<b>COUNTERMEASURE:-</b> Alarm provided so that when KEB power comes alarm will start before the change over from DG for 1 minute so that operator can stop the m/c to avoid rejection & other breakdowns, also provided indicator whether KEB or DG running with green & red respectively.	<table border="1" style="width:100%; border-collapse: collapse;"> <tr><td><b>BENCHMARK</b></td><td>0 No.</td></tr> <tr><td><b>TARGET</b></td><td>0 No.</td></tr> <tr><td><b>KAIZEN START</b></td><td>22.10.2015</td></tr> <tr><td><b>KAIZEN FINISH</b></td><td>23.10.2015</td></tr> </table>	<b>BENCHMARK</b>	0 No.	<b>TARGET</b>	0 No.	<b>KAIZEN START</b>	22.10.2015	<b>KAIZEN FINISH</b>	23.10.2015
<b>BENCHMARK</b>	0 No.									
<b>TARGET</b>	0 No.									
<b>KAIZEN START</b>	22.10.2015									
<b>KAIZEN FINISH</b>	23.10.2015									

<b>PROBLEM / PRESENT STATUS :-</b> Job rejection happening while power failure at both time KEB power fail & recovery.		<table border="1" style="width:100%; border-collapse: collapse;"> <tr><td colspan="2"><b>TEAM MEMBERS :-</b></td></tr> <tr><td colspan="2">Mr.Dinesha.M</td></tr> <tr><td colspan="2">Mr.Ganesh</td></tr> <tr><td colspan="2"><b>BENEFITS :-</b></td></tr> <tr><td colspan="2">1.Rejection quantity reduction</td></tr> <tr><td colspan="2">2.Power failure alarms reduced</td></tr> </table>	<b>TEAM MEMBERS :-</b>		Mr.Dinesha.M		Mr.Ganesh		<b>BENEFITS :-</b>		1.Rejection quantity reduction		2.Power failure alarms reduced	
<b>TEAM MEMBERS :-</b>														
Mr.Dinesha.M														
Mr.Ganesh														
<b>BENEFITS :-</b>														
1.Rejection quantity reduction														
2.Power failure alarms reduced														



<b>Why1 :-</b> Defect more	<b>RESULT:-</b> Defect reduced 30% to 10%	<b>WHAT TO DO.</b> To be check the working condition																
<b>Why2 :-</b> Cycle interruption	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="text-align: center;">35%</td> <td style="text-align: center;">30%</td> <td style="text-align: center;">25%</td> <td style="text-align: center;">20%</td> <td style="text-align: center;">15%</td> <td style="text-align: center;">10%</td> <td style="text-align: center;">5%</td> <td style="text-align: center;">0%</td> </tr> <tr> <td style="text-align: center;">Before</td> <td style="text-align: center;">After</td> <td colspan="6"></td> </tr> </table>	35%	30%	25%	20%	15%	10%	5%	0%	Before	After							<b>HOW TO DO:</b> Audible
35%		30%	25%	20%	15%	10%	5%	0%										
Before	After																	
<b>Why3 :-</b> Un expected power change over		<b>FREQUENCY</b> Daily																

<b>ROOT CAUSE :-</b>	<b>COST INCURRED</b>	
	<b>MATERIAL COST</b> IN RS	<b>LABOUR COST</b> IN RS
	1500	1500
	<b>HORIZONTAL DEPLOYMENT</b>	

<b>REGISTRATION NO. &amp; DATE :</b> 885 & 23.10.15		
<b>REGISTERED BY :-</b> Mr.Dinesha.M		
<b>MANAGER'S SIGN :-</b> Mr.Sivasankar.G		

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS