

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

KAIZEN IDEA SHEET

F/IMS/05

CELL: A351 CELL NAME: Shot blasting MACHINE / STAGE: Mecshot OPERATION: Shot blasting

KAIZEN THEME: To reduce JH checking time for FLR unit pressure checking in shot blasting m/c.

WIDELY/DEEPLY:

PRESENT STATUS : During JH time taken to check FLR unit pressure is 50sec.



BEFORE

IDEA: Easy to access.

COUNTERMEASURE : Changed the location of FRL Unit from back side of machine to front side of the machine.



AFTER

BENCHMARK	50 Sec
TARGET	20 Sec
KAIZEN START	02.10.2016
KAIZEN FINISH	03.10.2016

TEAM MEMBERS:
 1. Mr. Basvalinga.
 2. Mr. Shanmugam.

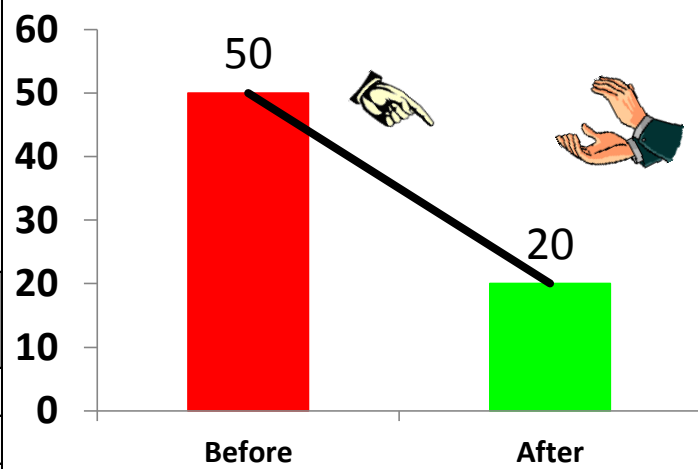
BENEFITS:
 1. Operator moral increased.
 2. JH time reduced

WHY - WHY ANALYSIS :-

- Why1:** During JH time taken to check FLR unit pressure is 35sec.
- Why2:** FRL unit at the backside of the machine.
- Why3:** Hard to access.

ROOT CAUSE : Hard to access.

RESULT:- Reduced JH time from 50 Sec to 20sec.



KAIZEN SUSTENANCE

WHAT TO DO :: Ir-reversible Kaizen
HOW TO DO : -----
FREQUENCY : One time action

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 50/--	-----	INR 50/--

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS
1	Rotary Washing	30.10.16	Mr. Pavan	On Going

REGISTRATION NO. & DATE: 1307, 05.10.16

REGISTERED BY: Mr. Gurubasappa

MANAGER'S SIGN: Mr. Chamraj B T