

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

KAIZEN IDEA SHEET

F/IMS/05

CELL: A627 CELL NAME: Tensioner MACHINE / STAGE: CUB LM OPERATION: Facing Grooving & Tapping

KAIZEN THEME : To reduce JH time through Cockpit concept.

WIDELY/DEEPLY:

PRESENT STATUS: Present CLIRT inspection time is 460 sec.



BEFORE

IDEA: M/c should be in JH step 5 Condition.

COUNTERMEASURE : Changed m/c condition at initial stage only from JH step 3 to JH step 5 , by cockpit concept.



AFTER

BENCHMARK	460 sec
TARGET	390 sec
KAIZEN START	02.08.17
KAIZEN FINISH	18.09.17

TEAM MEMBERS:
Mr. N.S.Pujari
Mr. Praveen Jannu, Mr. Manas Day

- BENEFITS:**
- JH inspection time reduced.
 - M/c is in JH step 5 Condition.

KAIZEN SUSTENANCE

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

WHY - WHY ANALYSIS :-

- Why1:** Present CLIRT inspection time is 460 sec.
- Why2:** Operator has to move for all sides of the m/c for JH point inspection
- Why3:** M/c is in JH step 3 condition.

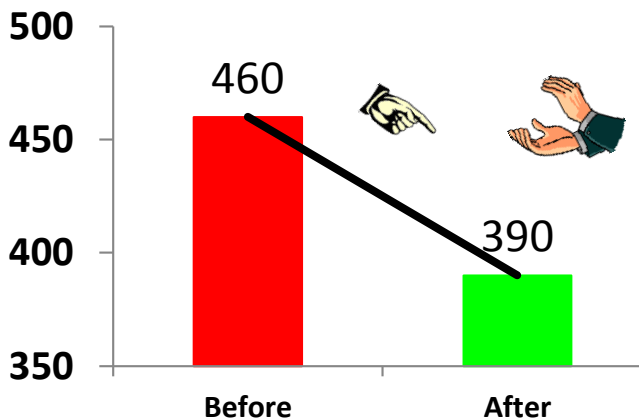
ROOT CAUSE:- M/c is in JH step 3 condition .

REGISTRATION NO. & DATE: 1896 & 21.10 .17

REGISTERED BY: Mr. Ponnappa

MANAGER'S SIGN: Mr. Chamaraj

RESULT:- CLIRT inspection time reduced from 460 Sec to 390 sec.



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 80000/-	-----	INR 80000/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS
1	All CNC VMC	31.12.17	Mr. Dinesh & Team	In Process