A DUITZ	TPM CIRCLE NO :- 3		CTIVITY	KK	QM	PM JH	SHE	OT	DM	E&T	1/117					
A DV K P14	TPM CIRCLE NAME : Orion		OSS NO. / STEP								KAIZEN II.		DEA SHEE			
12 111	DEPT :- Machine shop		SULT AREA	<u> P</u>	Q	DEF :- A	С	D	S	М						
CELL : A351 CEL	NAME:- Drum Change	MACHIN	E / STAGE :- VM	C Macr	ine			OPE	RATIO	<u>ON :-</u>	Drilling	Tapping	,,Profile	e Milli		
KAIZEN THEME : To reduce energy		IDEA : P	IDEA : Poka Yoke													
consumption for ope	rating all VMC											_				
Machines in Drum Changes Soft Cell.		countermeasure:- Provided Timer & interface the PLC for auto cut off of Hydraulic Power Pack Motor when no production is there							BENCHMARK			1675 Units 1600 Units				
WIDELY/DEEPLY:-									TARGET 1600 U KAIZEN START 15.09.2							
									KAIZEN START							
PROBLEM / PRESENT STATUS :- Presently Monthly Average Energy Consumption for		on M/c. with delay time of 5 Minutes.							KAIZEN FINISH 16.09.2014							
		011 1417 0.	on with delay time of 5 windtes.							TEAM MEMBERS :-						
operating all 3 VMC N		Sivasankar														
										BENEFITS :-						
B.f. a Law Drove		Motor Running average –							Monthly Saving of 75 Units							
Motor Runr	IV									J						
17 Hours/	Working Day		16 Hours/	Wor	kin	n Dav										
17 Hours	Working Day		10 110013/	vvoi	KILI	g Day										
									KAIZEN SUSTENANCE							
									NAIZEIN SUSTEINAINCE							
	BEFORE					Г	AFTER	→ V	VHAT	TOI	00: Irr	eversibl	e Kaiz	en.		
		_					AI ILI	<u>`</u>	HOW	TO D	O:					
WHY - WHY ANALYSIS	RESULT	RESULT :-							FREQUENCY :							
Why1: 3 Nos. VMC N	I/c. Monthly Energy															
consumption is 1675 Units.			Energy consumption													
Why2: Hydraulic Power Pack running			units/month													
continuously even wh	nen not required.		units	71110	11(11											
Why3: Poka	·	1700 -	1475													
•			1675						OOT 1			00.844	/INIO 1			
		1/50							COST INCURRED FOR MAKING KAIZE							
ROOT CAUSE: Poka		1650 -						MA	MATERIAL COST LABO							
			1600						IN RS IN RS IN R							
		1600 -	_	100					Rs. 6000 Rs. 600					6000		
		555						SC	OPE &	PLAN	N FOR HORIZONT		AL DEPLOYME			
REGISTRATION NO. &	DATE : 216 & 16.09.14							SR		:II	TARGET	RESPONS	SIRII ITV	STAT		
REGISTERED BY :- Gur	ıı Rasanna	1550 -		I				₁ NC).					J.A.		
MANAGER'S SIGN :- S	-	Before			After			-								
RARRIACED/C CICNI. C	ivasankar								1							