

|             |                         |                                |   |
|-------------|-------------------------|--------------------------------|---|
| CELL : A351 | CELL NAME:- Drum Change | MACHINE / STAGE :- VMC Machine | OPERATION :- Drilling,Tapping,Profile Milling |
|-------------|-------------------------|--------------------------------|---|

**KAIZEN THEME :** To reduce energy consumption for operating all VMC Machines in Drum Changes Soft Cell.

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-** Presently Monthly Average Energy Consumption for operating all 3 VMC M/c. is 1675 Units.

**Motor Running average – 17 Hours/Working Day**

**IDEA :** Poka Yoke

**COUNTERMEASURE:-** Provided Timer & interface the PLC for auto cut off of Hydraulic Power Pack Motor when no production is there on M/c. with delay time of 5 Minutes.

**Motor Running average – 16 Hours/Working Day**

|                      |            |
|----------------------|------------|
| <b>BENCHMARK</b>     | 1675 Units |
| <b>TARGET</b>        | 1600 Units |
| <b>KAIZEN START</b>  | 15.09.2014 |
| <b>KAIZEN FINISH</b> | 16.09.2014 |

**TEAM MEMBERS :-**  
Sivasankar

**BENEFITS :-**  
Monthly Saving of 75 Units

**KAIZEN SUSTENANCE**

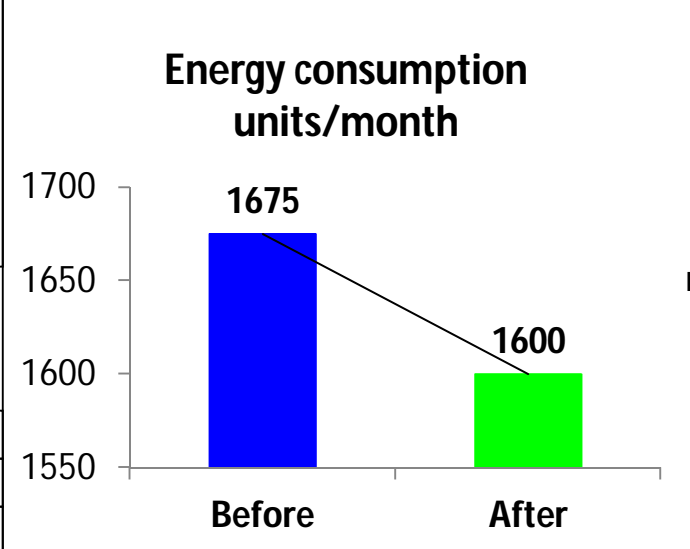
**WHAT TO DO:** Irreversible Kaizen.  
**HOW TO DO:**-----  
**FREQUENCY :**-----

**WHY - WHY ANALYSIS :-**  
**Why1:** 3 Nos. VMC M/c. Monthly Energy consumption is 1675 Units.  
**Why2:** Hydraulic Power Pack running continuously even when not required.  
**Why3:** Poka

**ROOT CAUSE :** Poka

**REGISTRATION NO. & DATE :** 216 & 16.09.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** Sivasankar

**RESULT :-**



| COST INCURRED FOR MAKING KAIZEN |                      |                     |
|---------------------------------|----------------------|---------------------|
| MATERIAL COST<br>IN RS          | LABOUR COST<br>IN RS | TOTAL COST<br>IN RS |
| Rs. 6000                        | -----                | Rs.6000             |

| SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT |      |        |                |        |
|--|------|--------|----------------|--------|
| SR. NO.                                | CELL | TARGET | RESPONSIBILITY | STATUS |
| ---                                    | ---- | -----  | -----          | -----  |