

Plant : P14

TPM CIRCLE NO :- 1		ACTIVITY		KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET
		TPM CIRCLE NAME :		LOSS NO./STEP								
DEPT : Production		RESULT AREA		C	Q	P	P, C	S	M, D	P, C	M	

CELL : A337	CELL NAME : OIL PUMP BODY	M/C STAGE: FRD-02	OPERATION: Face Milling Drilling Reaming, Tapping
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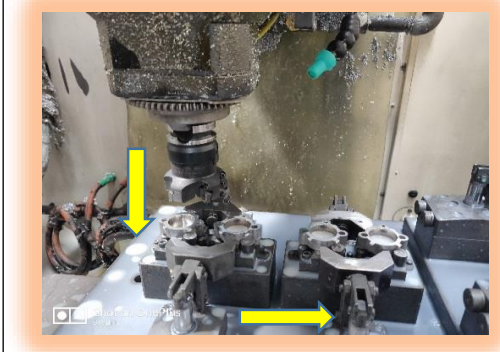
KAIZEN THEME : To reduce cycle time	KAIZEN IDEA : CNC Programming need to be revised frequently	BENCHMARK: 1 min 23 sec
		TARGET: 1 min 16 sec
		KAIZEN START: 30.09.18

PROBLEM PRESENT STATUS : Cycle time is more by 1 min 23 sec	COUNTERMEASURE: Cycle time reduced by reducing X-axis movement from 230 mm to 170mm and X-axis movement given in opposite direction..Y-axis movement reduced from 60 mm to 0 mm..	TARGET DATE: 31.09.18
		KAIZEN FINISH: 31.09.18

TEAM MEMBERS:	
Mr. Satish	
BENEFITS:-	
Cycle time is reduced from 1min 23 sec to 1min 16sec	

WHY-WHY ANALYSIS:	BEFORE	AFTER	KAIZEN SUSTAINANCE
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Why1:- Cycle time is more by 1 min 23 sec
Why2:- Machining time more on facing operation.
Why3:- Face cutter X axis movement upto 230mm from first part to 4th part & Y axis movement 55mm from reference position to first part
Why4:- Programme has not written properly in machine



ROOT CAUSE	RESULTS:	1	A337	30.09.18	Prod	Close
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Programme not written properly and not revised

Cycle time is reduced from 1min 23 sec to 1min 16sec

REGISTRATION NO.:	P14/KK/2018/29
DATE:	22.10.2018
REGISTERED BY:	Mr. Omprakash
MANAGER SIGN:	Mr. Manas Kumar Dey

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL/ PRODUCT	TDC	RESP.	STATUS
1	A337	30.09.18	Prod	Close
HD SCOPE INFORMATION IN OTHER PLANT				
SR.NO.	PLANT	WHEN	WHOM	STATUS