

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

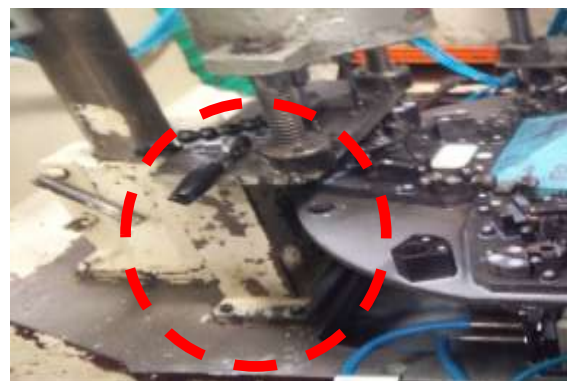
**KAIZEN IDEA SHEET**  
F/IMS/05

CELL:- A-247      CELL NAME:- A247 Lever SPM      MACHINE / STAGE:-      OPERATION:- Drilling & Tapping

**KAIZEN THEME:-** To eliminate Tool breakage

**WIDELY/DEEPLY:**

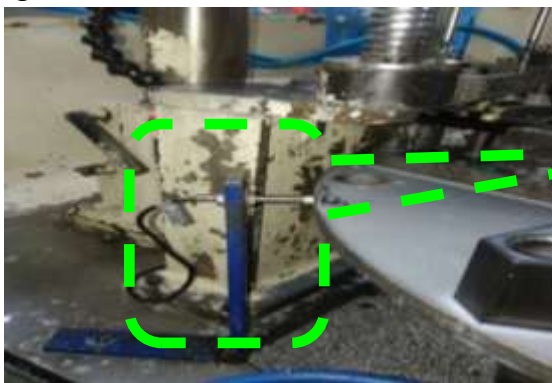
**PRESENT STATUS :-** Frequent tap & drill breakages incase of improper indexing.



**BEFORE**

**IDEA:-** Interlock

**COUNTERMEASURE:-** Provided a proximity sensor to get the table home condition feed back.



**AFTER**

<b>BENCHMARK</b>	6
<b>TARGET</b>	0
<b>KAIZEN START</b>	28.01.2017
<b>KAIZEN FINISH</b>	28.01.2017

**TEAM MEMBERS:-** Ganesh, Manjunath

- BENEFITS:-**
1. chance of accident eliminated
  2. Machine B/D Eliminated
  3. Safe & smooth working environment.
  4. Tool breakage eliminated while struck of table
  5. Quality improved

**WHY - WHY ANALYSIS :-**

- Why1:-** Drill & tap breakages
- Why2:-** Drill operation get starts before index Table homing
- Why3:-** No feed back for the table home condition

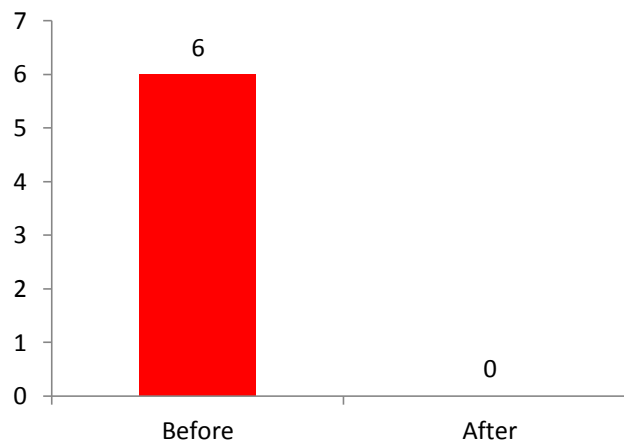
**ROOT CAUSE:-** no interlock

**REGISTRATION NO. & DATE:** 1458 & 28.01.2017

**REGISTERED BY:** Mr Nigama

**MANAGER'S SIGN:** Mr Dinesh

**RESULT:-** Tool breakage Eliminated



**KAIZEN SUSTENANCE**

**WHAT TO DO :-** Irreversible kaizen  
**HOW TO DO :** -----  
**FREQUENCY :** -----

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	-----	-----

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESP.	STATUS
	----	----	-----	-----