

TPM CIRCLE NO :- 1	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :	LOSS NO. / STEP								
DEPT :-	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :- Assembly **CELL NAME:-**A247-2 **MACHINE / STAGE :-** Screw tightening **OPERATION :-**

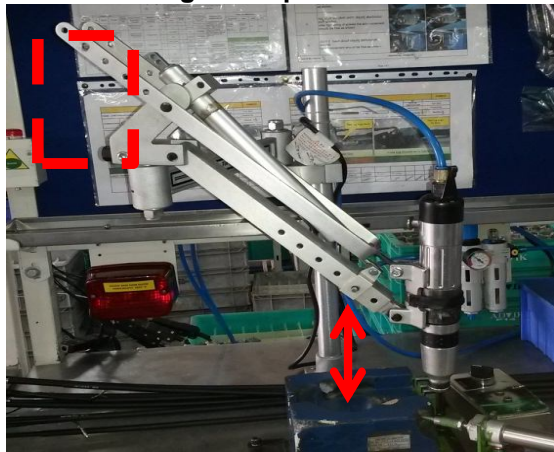
KAIZEN THEME :-Operator fatigue to be reduce

IDEA :- Provision of spring for return stroke

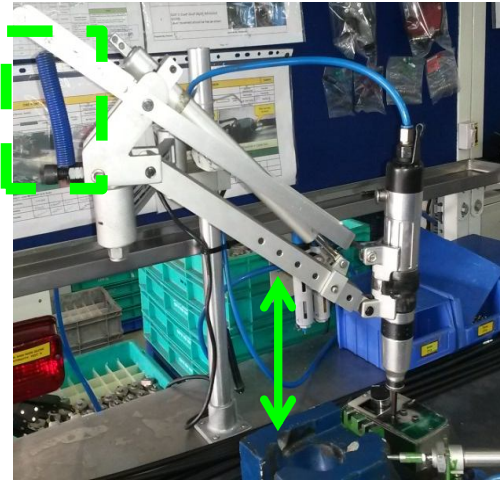
WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided a tension spring, so that after work completion rocker arm moves upward automatically due to the impact of spring tension.

PROBLEM / PRESENT STATUS :- Rocker arm not lifting up after the work completion, so creates fatigue to operator



BEFORE



AFTER

BENCHMARK	0 No.
TARGET	0 No.
KAIZEN START	30.6.15
KAIZEN FINISH	30.6.15

TEAM MEMBERS :-
Pavan kumar

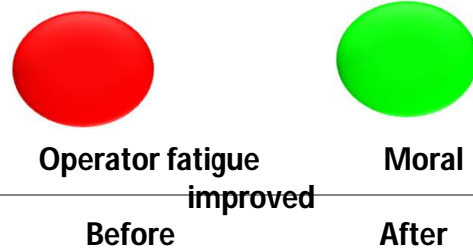
BENEFITS :-
1.Operator fatigue eliminated
2.Productivity will be increased

KAIZEN SUSTENANCE

WHAT TO DO. Spares to maintain
HOW TO DO : ---
FREQUENCY :---

Why1:-Provided a spring
Why2:-screw driver not retracting after the torquing.
Why3:-cylinder tension not sufficient

RESULT :-



ROOT CAUSE :- Less capacity of cylinder.

COST INCURRED

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
50		50

REGISTRATION NO. & DATE: # 735, 30.06.15
REGISTERED BY :- Dinesha.M
MANAGER'S SIGN :-

HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS