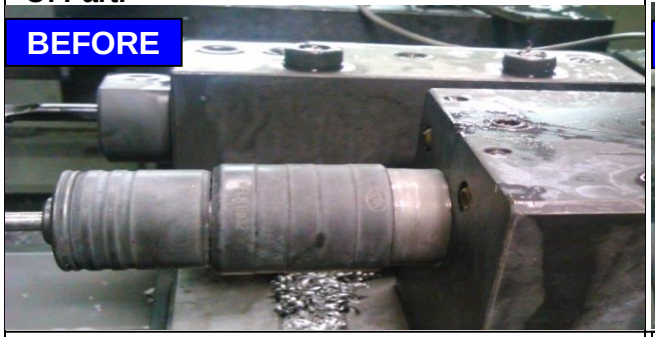
ADVIK	TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET
	TPM CIRCLE NAME :-	LOSS NO. / STEP		✓							KAIZEN NO:-
	DEPT :- Production.	RESULT AREA	P	Q	DEF :- A / B / C		C	D	S	M	

CELL :- Tensioner CELL NAME:- A-157 | MACHINE / STAGE :- Mazak (QUICK TURN 6G) | OPERATION :- Boring Tapping & Facing

KAIZEN THEME :-
To eliminate Thread defect Problem.

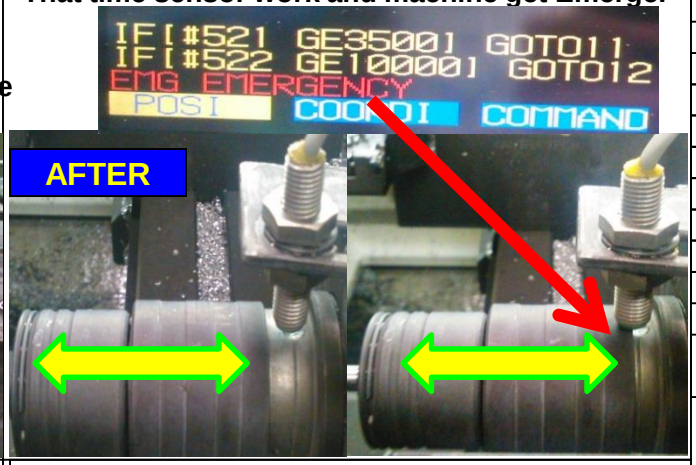
WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- In A-157 Tensioner Line some time getting half thread Component and operator can't Catch the piece Of Part.



IDEA :- Provide a Proximity sensor.

COUNTERMEASURE:- Proximity sensor attached On Tapping Holder if the holder jam in back side That time sensor work and machine get Emerge.



BENCHMARK	12 Nos
TARGET	0.0
KAIZEN START	23.04.2014
KAIZEN FINISH	02.05.2014

TEAM MEMBERS :- Production Team

BENEFITS :-

1. Thread defect customer Complain Zero.
2. Quality improve.
3. Moral improve.
4. POKA – YOKE Implement.

KAIZEN SUSTENANCE

WHAT TO DO :- To check proper working of sensor.

HOW TO DO :- As per JH / PM check sheet

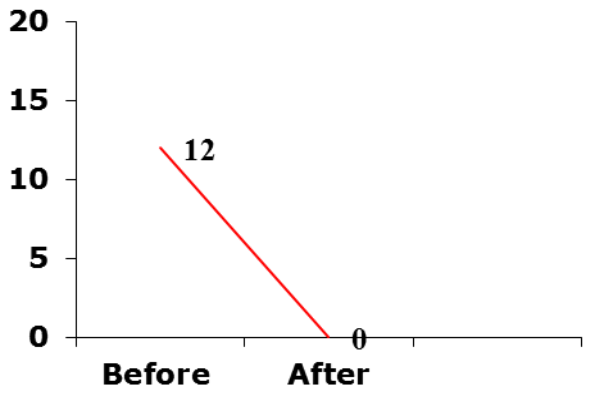
FREQUENCY :- At start of Shift

WHY - WHY ANALYSIS :-

WHY 1:- Thread missing problem.
ANS 1:- Due to uneven load on Tapping Holder, Holder jam in back side and Tool length getting short.
WHY 2:- Tool length getting short.
ANS 1:- Tapping holder is flexible & flexible Length is Uncontrolled.

ROOT CAUSE :-
Uncontrolled flexibility.

RESULT :- Customer Complaint.



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	All sell Tensioner Line.	10.04.14	Production & Maintenance	Comp.

REGISTRATION NO & DATE:

REGISTERED BY :-

MANAGER'S SIGN :-

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

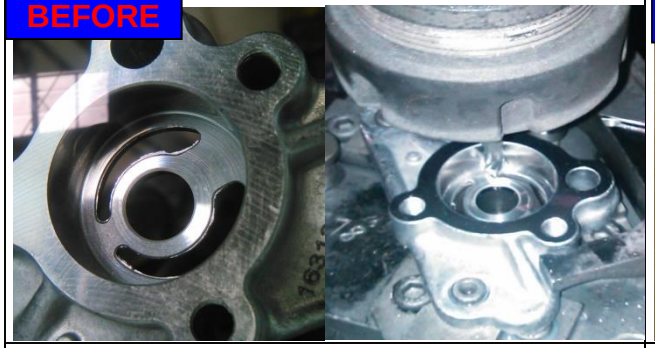
CELL :- oil Pump | CELL NAME:- A-316 | MACHINE / STAGE :- FANUC ROBOT DRILL | OPERATION :- Boring Tapping & Facing

KAIZEN THEME :-
To Reduce Cycle time.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :-
In A-316 Machine has required 4sec/ Comp to remove The burr from in late out late hole.

BEFORE



IDEA :- Provide Chamfer in casting Body.

COUNTERMEASURE:-
Provided Chamfer in In – Late Out-Late hole, Now We not using tool in Machine.

AFTER

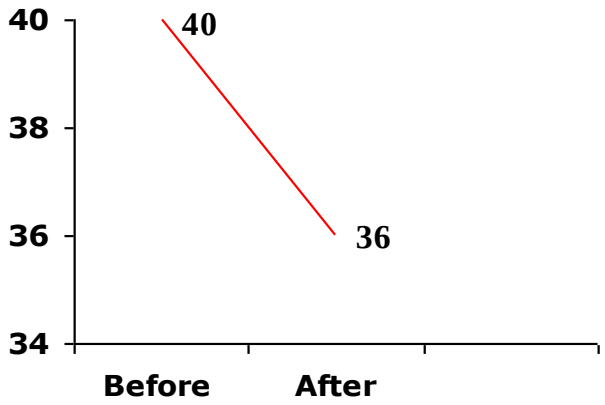
BENCHMARK	
TARGET	
KAIZEN START	23.03.2014
KAIZEN FINISH	12.04.2014

TEAM MEMBERS :- Production Team

BENEFITS :-
1. Output per hr increased 90 to 100 per hr..
2. Man power cost saving 0.6 lac per annum.
3. .
4.

WHY - WHY ANALYSIS :-
WHY 1:- Process time is more.
ANS 1:- Due to Burr Removing By Machine.
WHY 2:- Why Burr Coming.
ANS 2:- Due to chamfer not available.

RESULT :- Cycle Time Reduce.



KAIZEN SUSTENANCE

WHAT TO DO :- N/A.

HOW TO DO :- N/A

FREQUENCY :- N/A

ROOT CAUSE :-
Chamfer not available In Casting.

REGISTRATION NO&DATE:

REGISTERED BY :-

MANAGER'S SIGN :-

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1				