

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

KAIZEN IDEA SHEET

F/IMS/05

CELL: A157

CELL NAME: Tensioner

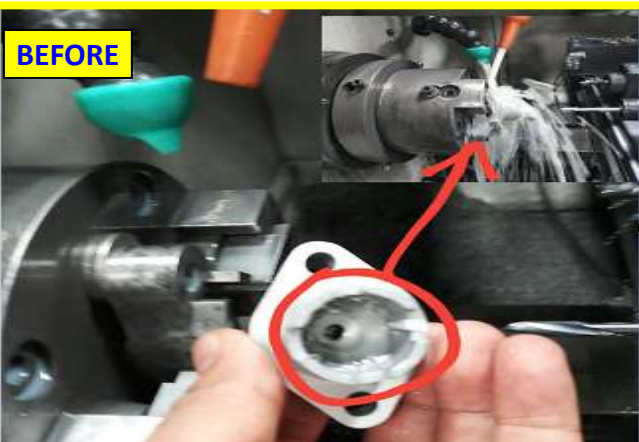
MACHINE / STAGE: ACE COLT 1

OPERATION: Facing , Tapping & ID Boring

KAIZEN THEME : To eliminate burr spillage at Tensioner machining stage.

WIDELY/DEEPLY:

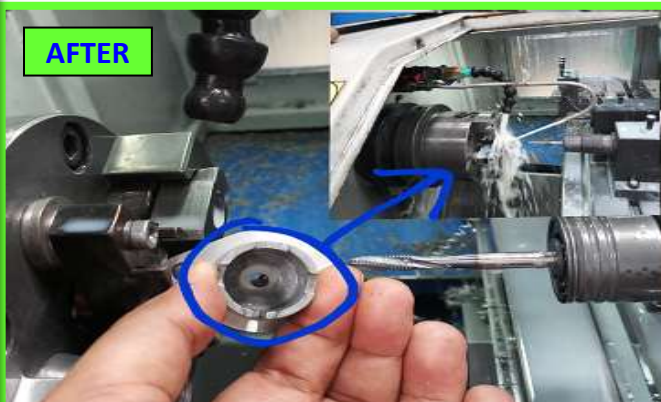
PRESENT STATUS: After machining burr spillage from air cleaning booth .



BEFORE

IDEA: Burr should get out from the ID after machining stage (Op 10).

COUNTERMEASURE : Changed coolant flow pipe design through which burr in ID will fall into m/c itself & no any burr spillage .



AFTER

BENCHMARK	-----
TARGET	-----
KAIZEN START	06.06.17
KAIZEN FINISH	07.06.17

TEAM MEMBERS:

Mr. Manas Dey ,
Mr. Sridhar, Miss. Mounika

BENEFITS:

1. Burr spillage eliminated.
2. Elimination Defect
3. User Friendly.

KAIZEN SUSTENANCE

WHAT TO DO : Coolant flow pipe direction should be facing to ID direction.

HOW TO DO : Manual Adjustment.

FREQUENCY : Start of the shift.

WHY - WHY ANALYSIS :-

Why1: After machining burr spillage from air cleaning booth .

Why2: Burr gets out from the body during air cleaning in booth.

Why3: Burr is not getting out from ID after machining stage (Op 10).

ROOT CAUSE:- Burr is not getting out from ID after machining stage (Op 10).

RESULT:-



Burr Spillage

No Burr spillage

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 50/-	-----	INR 50/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS
1	A128 Line 1 & 2	10.07.2017	Mr. Manas Dey	In Process

REGISTRATION NO. & DATE: 1708 & 22.06.17

REGISTERED BY: Mr. Shivram

MANAGER'S SIGN: Mr. Chamaraj