

CELL :- A 315, CELL NAME:- Oil Pump MACHINE / STAGE :- Free Rotation OPERATION :- Free Rotation

**KAIZEN THEME :-** Common Clamp For Oil Pump A 387, A315 ,

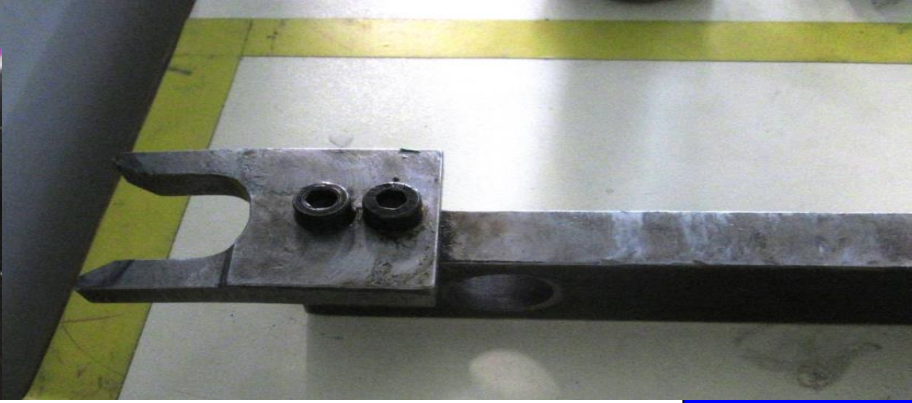
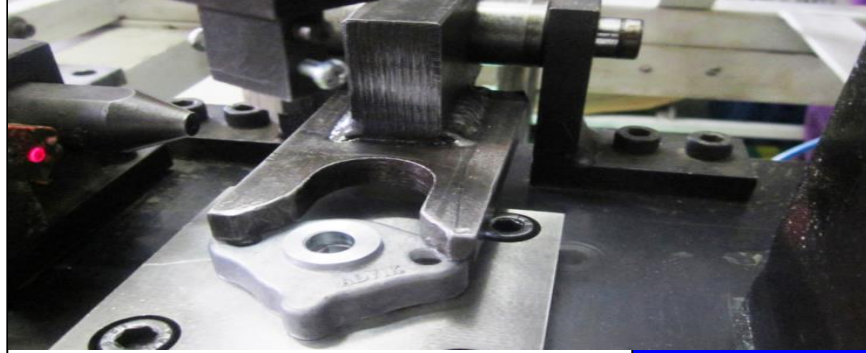
**IDEA :-** Save setting time . Of line Change .

**WIDELY/DEEPLY:-**

**COUNTERMEASURE :-** Common Clamp for Oil Pump A315,A387,

**PROBLEM / PRESENT STATUS :-** To Reduce Line Change Cycle Time.

|                      |          |
|----------------------|----------|
| <b>BENCHMARK</b>     | 0.       |
| <b>TARGET</b>        | 0        |
| <b>KAIZEN START</b>  | 10.05.14 |
| <b>KAIZEN FINISH</b> | 19.05.14 |



**BEFORE**

**AFTER**

**TEAM MEMBERS :-**

Ramesh joshi,

**BENEFITS :-**

- 1) Save setting Time.

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

**WHY 1:-** Clamp Change Time Min. 1Hr.,  
**ANS 1:-** Same M/c for Free Rotation, Oil Pump A387,A315

**RESULT :-** Clamp change time Reduce 40 Min. to 5 Min.

**WHAT TO DO :-** Provide Common Clamp.

**ROOT CAUSE :-**

**FREQUENCY:-**

**REGISTRATION NO&DATE:**

**COST INCURRED FOR MAKING KAIZEN**

**REGISTERED BY :-**

| MATERIAL COST RS. | LABOUR COST RS. | TOTAL COST RS. |
|-------------------|-----------------|----------------|
| -----             | -----           | -----          |

**MANAGER'S SIGN :-**

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

| SR. NO. | CELL | TARGET   | RESPONSIBILITY | STATUS  |
|---------|------|----------|----------------|---------|
| 1       | A177 | 19.04.14 | Ramesh joshi   | Process |