



TPM CIRCLE NO :- 3	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Orion	LOSS NO. / STEP								
DEPT :- Assembly Shop	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

# KAIZEN IDEA SHEET

CELL :-A177      CELL NAME:- Oil Pump Assy.      MACHINE / STAGE :- A177 Oil Pump Assembly Line      OPERATION :- Plate Fitment & Flushing

**KAIZEN THEME :** To Increase Output/Man in A177 Oil Pump Assembly Line.

**IDEA :-** Bottleneck Stage Time < 15 Sec.

**WIDELY/DEEPLY:-**

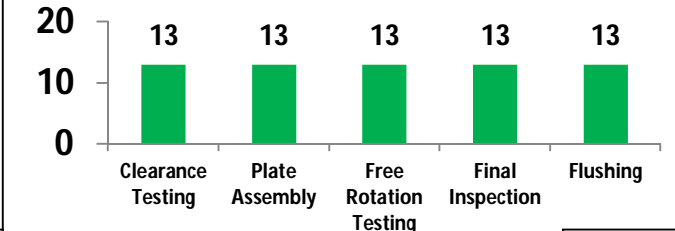
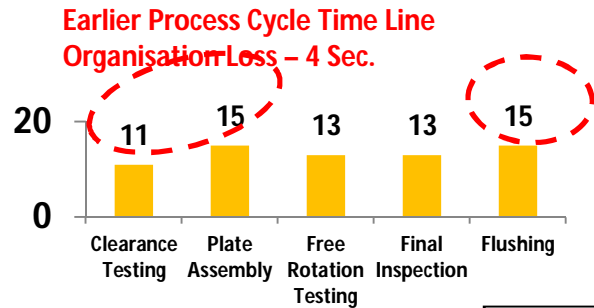
**COUNTERMEASURE:-** Changed the Plate Assembly Stage activities by distributing Plate putting on Body at Clearance Stage and Reduced the Cycle Time of Flushing Stage by 2 Sec. to reduced Bottleneck stage time up-to 13 Sec.

<b>BENCHMARK</b>	392 Nos.
<b>TARGET</b>	492 Nos.
<b>KAIZEN START</b>	22.05.2014
<b>KAIZEN FINISH</b>	24.05.2014

**PROBLEM / PRESENT STATUS :-** Present Output/Man is 392 Nos.

Revised Process Cycle Time  
Line Organisation Loss – 0 Sec.

**TEAM MEMBERS :-**  
Pramod Kumar



**BENEFITS :-**

- Productivity increased from 1764 Nos. /Shift to 2035 Nos./Shift.
- Save 9 Mandays cost /Month.

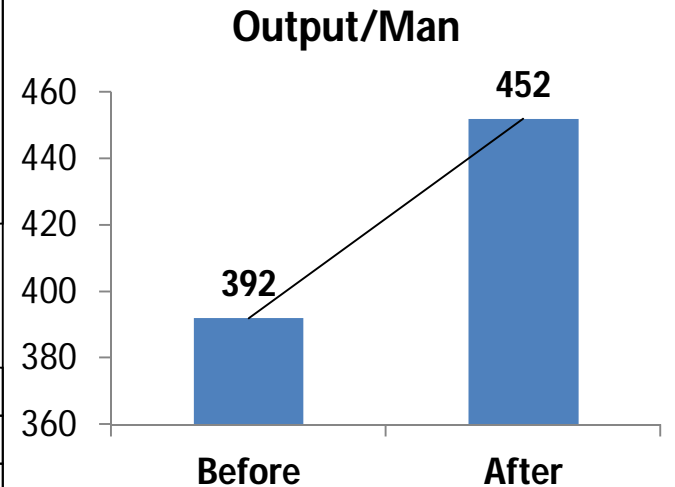
## KAIZEN SUSTENANCE

**WHY - WHY ANALYSIS :-**  
**Why1:** Output/Man is 392Nos.  
**Ans.1:** Bottleneck Stage Time is 15 Sec.

**RESULT :-**

**WHAT TO DO:** Irreversible Kaizen.  
**HOW TO DO:**-----  
**FREQUENCY :**-----

**ROOT CAUSE :-** Bottleneck Cycle Time is 15 Sec.



COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**REGISTRATION NO. & DATE:** 42 & 24.05.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** Ravi Gouda

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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