

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 :-A247 CELL NAME:- CBS Assy. MACHINE / STAGE :- A247 CBS Assembly Line OPERATION :- Plate Fitment Stage

KAIZEN THEME : To Increase Output/Man in A247 CBS Assembly Line.

IDEA :- Bottleneck Stage Time < 14.42 Sec.

WIDELY/DEEPLY:-

COUNTERMEASURE:- Changed the Pneumatic Gun holding method at Plate assembly stage from existing Slider Unit to Spring Balancer.

BENCHMARK	227 Nos.
TARGET	244 Nos.
KAIZEN START	16.06.2014
KAIZEN FINISH	19.06.2014

PROBLEM / PRESENT STATUS :- Present Output/Man is 227 Nos.

TEAM MEMBERS :-
Pramod Kumar



BEFORE

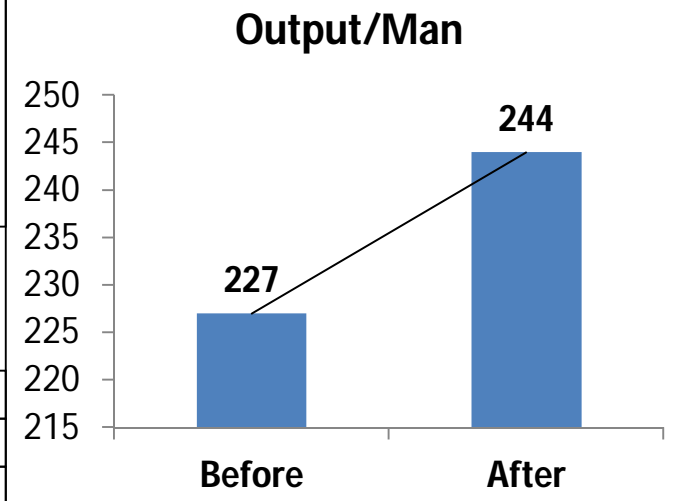
AFTER

- BENEFITS :-**
1. Productivity increased from 1835 Nos. /Shift to 1986 Nos./Shift.
 2. Save 21 Mandays cost /Month.

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why1: Output/Man is 227 Nos.
Ans.1: Bottleneck Stage Time is 14.42 Sec.

RESULT :-



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

ROOT CAUSE :- Bottleneck Cycle Time is 14.42 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: 96 &19.06.14

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Guru Basappa

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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MANAGER'S SIGN :- Ravi Gouda