

CELL :- A247 CELL NAME:- CBS ASSY MACHINE / STAGE :- Riveting machine OPERATION :- RIVETING

KAIZEN THEME :- To Reduce the fixture PM time In A247 CBS line at riveting stage.

IDEA :- Auto provision to be provide for fixture cleaning.

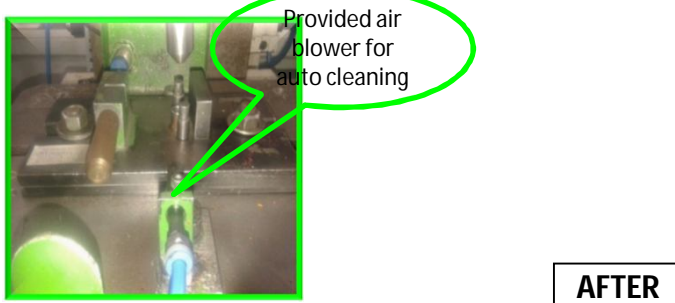
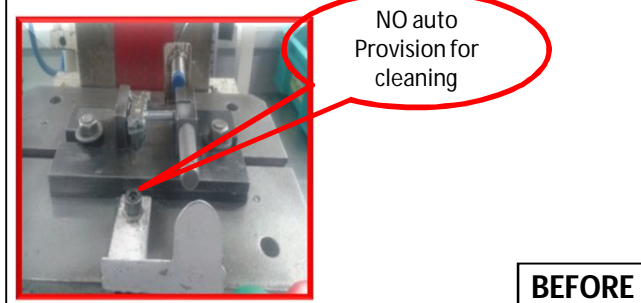
WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided air blower , after unload the component from fixture by logic system air blower work automatically & clean the fixture.

BENCHMARK	40
TARGET	15
KAIZEN START	15.12.15
KAIZEN FINISH	18.12.15

PROBLEM / PRESENT STATUS :- Takes more time for riveting fixture PM due to small chips accumulating in fixture & there is no any auto provision for fixture cleaning.

TEAM MEMBERS :- Shanth kumar.r
Mr.Mahesh.N



BEFORE

AFTER

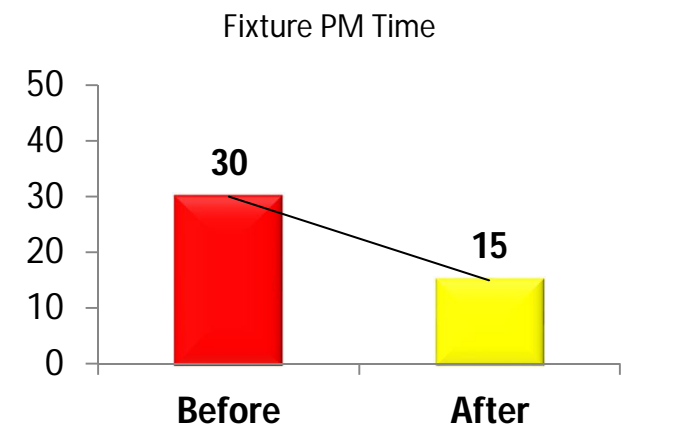
BENEFITS :- 1) Reduced Fixture time 40 min to 15 min. 2) Killed HTA area by action. 3) Work standardization . 4) Reduced Operator fatigue.

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why1 : Takes more time for riveting fixture PM.
Why2 : After completion of riveting operation small chips accumulating in fixture.
Why3 : No auto provision for fixture cleaning.

RESULT : Reduced fixture time.

WHAT TO DO : Check the presence of air blower & working condition.
HOW TO DO : Visually
FREQUENCY : Once in a day.



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
500	-----	500

ROOT CAUSE :- No auto provision for fixture cleaning.

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTRATION NO. & DATE : 953 & 23.12.15
REGISTERED BY :-
MANAGER'S SIGN :-

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS