

CELL :- Oil pump | CELL NAME:- Oil pump | MACHINE / STAGE :- Brother m/c | OPERATION :- Boring ,facing & Tapping

KAIZEN THEME :-To increase output Per hour.

IDEA :- Cycle time decrease

WIDELY/DEEPLY:-

COUNTERMEASURE:-A315 Oil pump two fixture run on Double pallet brother m/c due to which Loading & unloading time eliminated. Now cycle time 18 sec.

BENCHMARK	138 nos
TARGET	200 nos
KAIZEN START	03.10.2016
KAIZEN FINISH	12.10.2016

PROBLEM / PRESENT STATUS :-A315 Oil Pump only one fixture run on FRD M/C .Due to Which cycle time 26 sec (machining time + loading & unloading time) & output per hour – 138 nos.

ATER

TEAM MEMBERS :-
Amit , Harish , Pratap ,Ashok

- BENEFITS :-**
1. Output per hour increased.
 2. productivity increased
 3. Tooling cost reduced
 4. M/C cost reduced

BEFORE

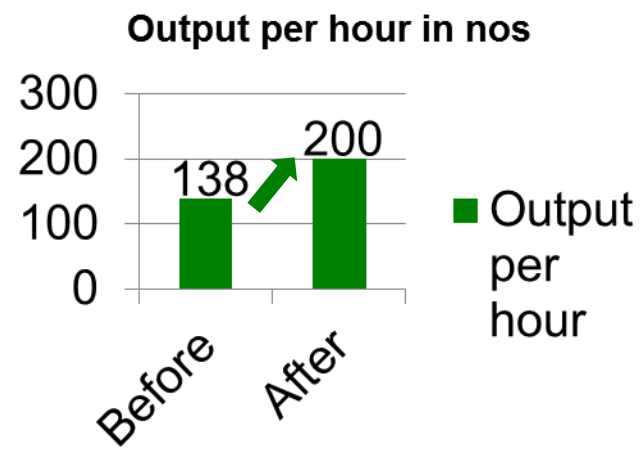
KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
WHY1 :-Output per hour 138 nos
ANS 2:- Cycle time 26 sec

RESULT :-

WHAT TO DO :- IR- reversible
HOW TO DO :- N/A
FREQUENCY :- one time activity.

ROOT CAUSE :-Cycle time 26 sec



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.

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

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1				