

CELL :- Oil pump | CELL NAME:- Oil pump | MACHINE / STAGE :- FRD-2ND. | OPERATION :- Boring ,facing

KAIZEN THEME :-To reduce setup Change time

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :-Separate Fixture for A315 & A449 Oil pump & due To production plan more of A315 oil pump we Have change the A449 oil pump fixture & A315 Oil pump fixture setting on m/c . Setup change time - 180 min.

BEFORE

IDEA :-Combined fixture for A449 & 315 oil pump.

COUNTERMEASURE:-A315 & A449 oil pump Body both same only C.D is deferent & A315 Body easily clamp on A449 fixture so we have Change the work coordinate sequence 1 to 12 For A449 & 13 to 24 for A315 & A315 run on A449 fixture Due to which setup Change time reduced.

AFTER

BENCHMARK	180 min.
TARGET	20 min.
KAIZEN START	05.10.2016
KAIZEN FINISH	12.10.2016

TEAM MEMBERS :-
Harish ,Pratap , Ami ,Ashok

- BENEFITS :-**
1. Setup change time reduced
 2. Productivity increased
 3. Moral increased

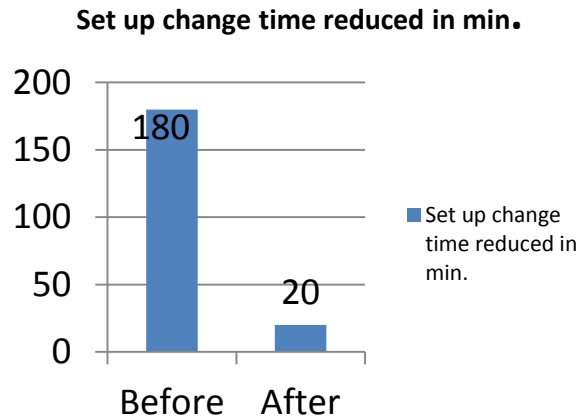
KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-

- WHY 1:-** Setup change time - 180 min.
ANS 1:- Separate fixture for A449 & A315
ANS 2:- Combined fixture not available for A449 & 315 oil pump.

ROOT CAUSE :-
Combined fixture not available

RESULT :-



WHAT TO DO :- IR- reversible

HOW TO DO :- N/A

FREQUENCY :- one time activity.

COST INCURRED FOR MAKING KAIZEN

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

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1				

REGISTRATION NO&DATE:

REGISTERED BY :-

MANAGER'S SIGN :-