

# Cycle Time Reduction Kaizen – A285

PROD

<b>ADVIK</b>	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	<b>KAIZEN IDEA SHEET</b>						
	TPM Circle Name:	Loss no.	✓														
Plant-1, Chakan.	Dept.: Machine Shop.	Step									<b>Kaizen No.:</b>						
Cell No.: A285	Cell Name: Oil Pump	Result Area	P	Q-Def A / B / C			C	D	S	M							
		Process / Stage : FRD-2							Operation : Machining								
<b>Kaizen Theme:</b> To Improve Productivity.		<b>Idea :</b> To implemented higher capacity cylinder by modify fixture.															
		Counter Measure: Fixture Cylinder to be Modified as High Clamping Capacity.															
<b>Problem / Present Status:</b> 1. A285 body Cycle Time 37sec/Job.		<b>Before :</b> Cutting Parameter Low. Cycle time = 37 sec/Component 97 Component/hr.					<b>Bench Mark</b>		37 sec								
							<b>Target</b>		30 sec								
							<b>Kaizen Start</b>		19.05.2014								
							<b>Kaizen Finish</b>		20.05.2014								
		Team Members With Sign : 1)Ajay Bhor, 2)Ajit deokar 3) Satish Kilbile															
		<b>Benefits:</b>															
		P	Productivity improved														
		Q															
		C															
		D	Loss at customer end reduced														
		S	---														
		M	---														
<b>Why Why Analysis :</b>  Why 1:A285 body Low Cutting Parameter Used. Why 2.Clamping Force less. Why 3.Low Capacity Cylinder Used. Why 4:Low Cutting Parameter used due to low Fixture Cylinder Capacity.		<b>After :</b> Cutting Parameter Used at Higher side Cycle time = 30 sec/Component 120 Component/hr.					<b>Benefits:</b>										
		<b>What to do :</b> 1. Not to change in Program. 2. Inspection as per frequency.															
		<b>How to do :</b> 1. Program lock by edit key.															
<b>Root Cause :</b> Low Cutting Parameter used due to low Fixture Cylinder Capacity.		<b>Result :</b> Cycle Time Reduced By 7 sec/ Component. Out put Increased 175 no's /Shift					<b>Scope &amp; Plan for Horizontal Deployment</b>										
		<table border="1"> <caption>Cycle Time Comparison</caption> <thead> <tr> <th>Phase</th> <th>Cycle Time (sec)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>37</td> </tr> <tr> <td>After</td> <td>30</td> </tr> </tbody> </table>					Phase	Cycle Time (sec)	Before	37	After	30	Sr. no.	Model	Target Date	Responsibility	Status
Phase	Cycle Time (sec)																
Before	37																
After	30																
Registration no.& dt :20/05/2014							-	-	-	-	-						
Submitted by : Umesh Pimple																	
Manager's Sign :Suresndra Kulkarni																	