

# Cycle Time Reduction Kaizen – A361

PROD

<b>ADVIK</b> Plant-1, Chakan.	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	<b>KAIZEN IDEA SHEET</b>						
	TPM Circle Name:	Loss no.	✓														
	Dept.: Machine Shop.	Step															
	Result Area	P	Q-Def A / B / C		C	D	S	M									
Cell No.: A361	Cell Name: Gear Shifter	Process / Stage : VMC								Operation : Machining							
<b>Kaizen Theme:</b> To Reduce cycle time.		<b>Idea :</b> To combine all setups in one 4 th axis fixture.															
		<b>Counter Measure:</b> 4th axis fixture for a361 body machining.															
<b>Problem / Present Status:</b> 1. For A361 body machining 5 Different Set ups On 2 Different Machines required total 271 mins ct per component.		<b>Before : Cycle time = 271 sec/Component</b>				<b>Bench Mark</b>		6 OP. / DAY									
		<b>13 Component/hr.</b>				<b>Target</b>		3 OP. / DAY									
						<b>Kaizen Start</b>		02.05.2014									
						<b>Kaizen Finish</b>		05.05.2014									
		<b>Team Members With Sign :</b> 1) Ajit Deokar 2) Satish Kilbile 3) Umesh Pimpale															
		<b>Benefits:</b>															
		P		Productivity improved													
		Q															
		C															
		D		Loss at customer end reduced													
		S		—													
		M		—													
		<b>Kaizen Sustenance :</b>															
		<b>What to do :</b> A361 body machining run with 4th axis setup.															
		<b>How to do :</b> Maintain process as per PCP															
<b>Why Why Analysis :</b> Why 1:A361 body machining cycle time was 271 sec per job. Why 2. No of setup to complete on job is more.		<b>After :Cycle time = 170 sec/Component</b>															
		21 Component/hr. Loading unloading time reduced.															
<b>Root Cause :</b> No of setup to complete on job is more.		<b>Result : 3 operator saved for a361 machining.</b>															
		<p>The bar chart displays the cycle time per job before and after the kaizen. The 'Before' bar is at 271 seconds, and the 'After' bar is at 170 seconds. The y-axis ranges from 0 to 300 seconds.</p> <table border="1"> <thead> <tr> <th>Phase</th> <th>Cycle Time (sec)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>271</td> </tr> <tr> <td>After</td> <td>170</td> </tr> </tbody> </table>										Phase	Cycle Time (sec)	Before	271	After	170
Phase	Cycle Time (sec)																
Before	271																
After	170																
Registration no.& dt :5/05/2014		<b>Scope &amp; Plan for Horizontal Deployment</b>															
Submitted by : Umesh Pimple		Sr. no.		Model		Target Date		Responsibility		Status							
Manager's Sign :Surenra Kulkarni		—		—		—		—		—							