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|---------------------------------|-----------------|----|----|--------|----|-----|----|----|-----|
| TPM CIRCLE NO: 2 | ACTIVITY | KK | QM | PM | JH | SHE | OT | DM | E&T |
| TPM CIRCLE NAME: Joshile | LOSS NO. / STEP | | | | | | | | |
| DEPT: Manufacturing Engineering | RESULT AREA | P | Q | DEF:-A | C | D | S | M | |

KAIZEN IDEA SHEET

F/IMS/05

CELL: A177 CELL NAME: Oil Pump Assy. MACHINE / STAGE: Flushing/Assembly OPERATION: Flushing

KAIZEN THEME: To reduce RM cost of Jigs Fixture in A177 Oil Pump Assy. Flushing Station

WIDELY/DEEPLY:

IDEA: Re use process to be started by removing wear out material of Flushing Shaft

PRESENT STATUS : Present Flushing Station Shaft Matting part cost is INR 930/- Piece.

COUNTERMEASURE : Started re-use of Life over shaft by rework in line with process (Rework Feasibility 2 times).

| | |
|----------------------|------------|
| BENCHMARK | INR 2790/- |
| TARGET | INR 1130/- |
| KAIZEN START | 01.08.17 |
| KAIZEN FINISH | 25.09.17 |

Discription : Flushing Shaft
 Tool Life : 15000 Nos
 Approx. Qty. Required/Month : 3 Nos
 Cost Per Piece : INR 930/-
 Average FS Jigs/Fix/ RM Cost/M : INR 2790/-



BEFORE

Discription : Flushing Shaft
 Tool Life : 45000 Nos
 Approx. Qty. Required/Month : 1 Nos
 Cost Per Piece : INR 930/-
 Rework Cost : INR 100/-
 Average FS Jigs/Fix/ RM Cost/M (100x2+930) : 1130/- INR /-

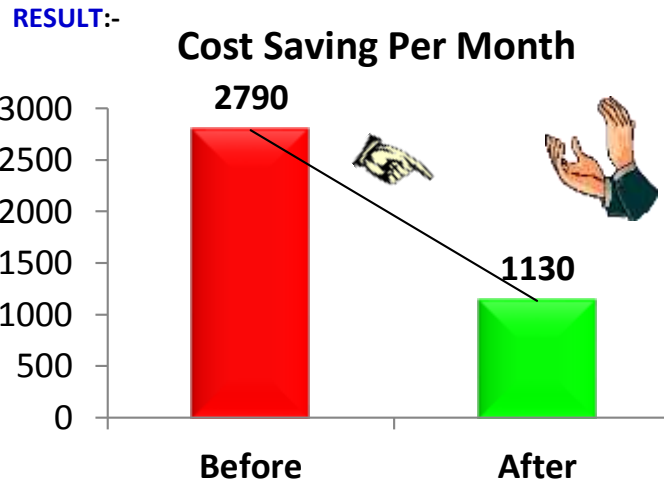


AFTER

TEAM MEMBERS:
 N.S.Pujari & Mr. Murali

- BENEFITS:**
- 1) Prevent May happen In house rejection
 - 2) Prevent May Happen Customer complaint

WHY - WHY ANALYSIS :-
Why1: Flushing Shaft Jig Fixture RM Cost is More
Why2: After Life over directly scrap to Flushing Shaft
Why3: No re-use process



KAIZEN SUSTENANCE

WHAT TO DO : Flushing Shaft Re-use process to be start
HOW TO DO : In Line With Shaft Life
FREQUENCY : On-Going Activity

ROOT CAUSE:- No re-use process

COST INCURRED FOR MAKING KAIZEN

| MATERIAL COST IN RS | LABOUR COST IN RS | TOTAL COST IN RS |
|---------------------|-------------------|------------------|
| ----- | ----- | ----- |

REGISTRATION NO. & DATE: 1862 & 31.08.2017
REGISTERED BY: Mr. Shivaramu.Mahadevu
MANAGER'S SIGN: Mr. N.S.Pujari

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

| SR. NO. | CELL | TARGET | RESP. | STATUS |
|---|------|--------|-------|--------|
| No Scope @P14 Case Study Shared to Other Plant for HD | | | | |