

TPM CIRCLE NO :- 3	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Orion	LOSS NO. / STEP								
DEPT :- Assembly Shop	RESULT AREA	P	Q	DEF:- A		C	D	S	M

CELL :-A128	CELL NAME:- Tensioner Assy.	MACHINE / STAGE :- A128 Assembly Line	OPERATION :- Grouping & Cap Crimping
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**KAIZEN THEME :** To Increase Output/Man in A128 Tensioner Assembly Line.

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-** Present Output/Man is 445 Nos.

**Grouping & Cap Fitment (Bottleneck) Stage–**  
 Nut + Screw + Spacer + Washer = Sub-Assy.1  
 Sub-Assy.1 + Retainer + Cap = Sub-Assy.2  
 Sub-Assy.2 is Output of Grouping Stage.

BEFORE

**IDEA :-** Bottleneck Stage Time < 11 Sec.

**COUNTERMEASURE:-** Changed the Grouping Stage (Bottleneck) activities in more better economical way and reduced the Cycle Time up-to 10.28 Sec.

**Grouping & Cap Fitment (Bottleneck) Stage –**  
 Nut + Retainer + Cap Crimping = Sub-Assy.1  
 Sub-Assy.1 + Screw + Spacer + Washer = Sub-Assy.2

AFTER

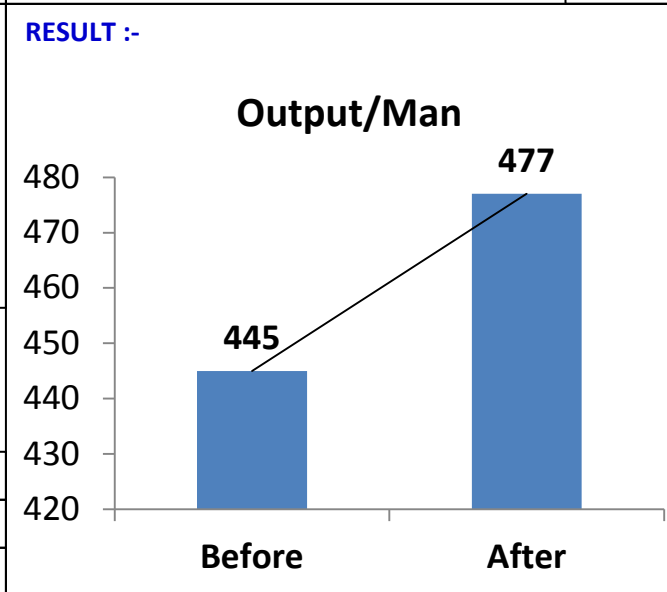
**WHY - WHY ANALYSIS :-**  
**Why1:** Output/Man is 445 Nos.  
**Ans.1:** Bottleneck Stage Time is 11 Sec.

**ROOT CAUSE :-** Bottleneck Cycle Time is 11 Sec.

**REGISTRATION NO. & DATE:** 16.05.14

**REGISTERED BY :-** Guru Basappa

**MANAGER'S SIGN :-** Ravi Gouda



<b>BENCHMARK</b>	445 Nos.
<b>TARGET</b>	477 Nos.
<b>KAIZEN START</b>	16.05.2014
<b>KAIZEN FINISH</b>	21.05.2014

**TEAM MEMBERS :-**  
 Pramod Kumar

- BENEFITS :-**
1. Productivity increased from 2405 Nos. /Shift to 2574 Nos./Shift.
  2. Save 13 Mandays cost /Month.

**KAIZEN SUSTENANCE**

**WHAT TO DO:** Irreversible Kaizen.  
**HOW TO DO:**-----  
**FREQUENCY :**-----

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	A157 Cell	25.05.14	Pramod	Comp.