



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	

KAIZEN IDEA SHEET

CELL :-A315 CELL NAME:- Oil Pump Assy. MACHINE / STAGE :- A315 Oil Pump Assembly Line OPERATION :- Plate Fitment & Flushing

KAIZEN THEME : To Increase Output/Man in A315 Oil Pump Assembly Line.

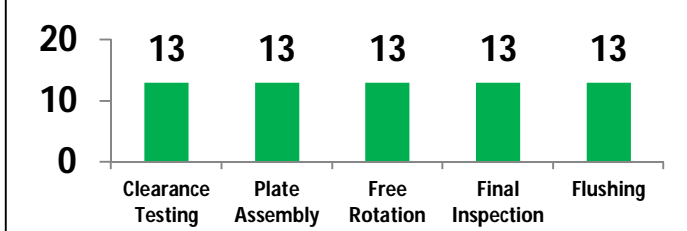
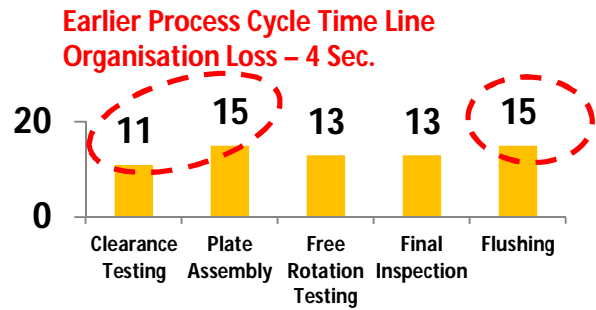
IDEA :- Bottleneck Stage Time < 15 Sec.

WIDELY/DEEPLY:-

COUNTERMEASURE:- Changed the Plate Assembly Stage activities by distributing Plate putting on Body at Clearance Stage and Reduced the Cycle Time of Flushing Stage by 2 Sec. to reduced Bottleneck stage time up-to 13 Sec.
 Revised Process Cycle Time
 Line Organisation Loss – 0 Sec.

BENCHMARK	490 Nos.
TARGET	565 Nos.
KAIZEN START	10.04.2014
KAIZEN FINISH	12.04.2014

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



TEAM MEMBERS :-
 Pramod Kumar

- BENEFITS :-**
1. Productivity increased from 1764 Nos. /Shift to 2035 Nos./Shift.
 2. Save 20 Mandays cost /Month.

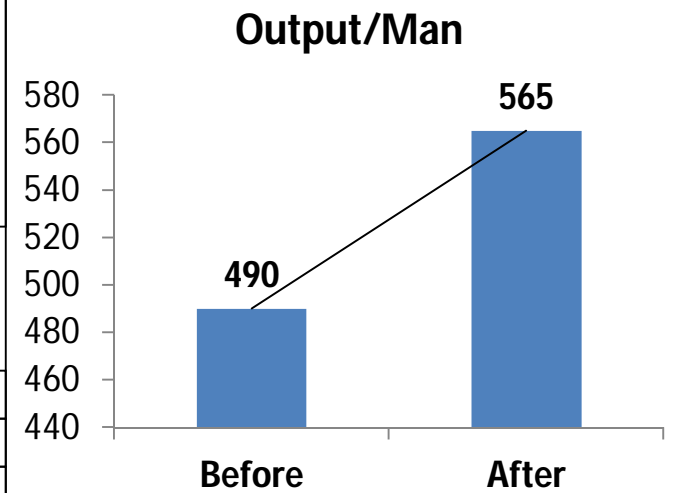
KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why1: Output/Man is 490 Nos.
Ans.1: Bottleneck Stage Time is 15 Sec.

RESULT :-

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

ROOT CAUSE :- Bottleneck Cycle Time is 15 Sec.



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE: 09 & 12.04.14
REGISTERED BY :- Guru Basappa
MANAGER'S SIGN :- Ravi Gouda

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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