

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

KAIZEN IDEA SHEET

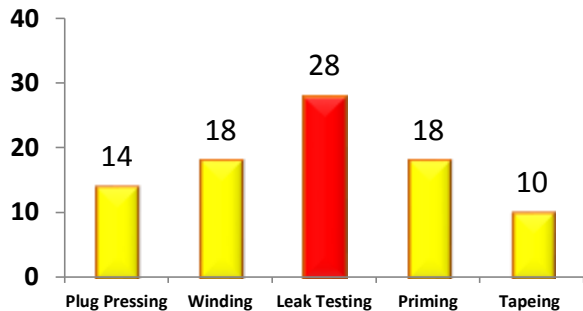
F/IMS/05

CELL: A467 CELL NAME: Tensioner MACHINE / STAGE: Assembly OPERATION: Leak testing

KAIZEN THEME: To reduce cycle time in A467 Tensioner assembly stage.

WIDELY/DEEPLY:

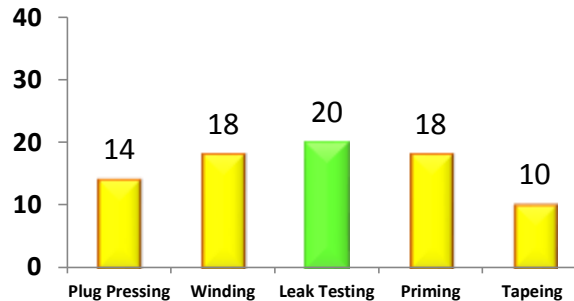
PRESENT STATUS: Current Cycle time @ assembly stage is 28 sec (Bottle neck station is Leak testing)



BEFORE

IDEA: To Reduce the bottleneck CT

COUNTERMEASURE:- Multi Activity Done



AFTER

BENCHMARK	28 sec
TARGET	20 sec.
KAIZEN START	10.02.2017
KAIZEN FINISH	10.03.2017

TEAM MEMBERS:

Mr. N.S.Pujari,
Mr. Pramod DR

BENEFITS:

1. Productivity increased.
2. Cycle time reduced.

KAIZEN SUSTENANCE

WHAT TO DO : Ir reversible Kaizen.

HOW TO DO : -----

FREQUENCY : One time action.

WHY - WHY ANALYSIS :-

Why1: Current Cycle time @ assembly stage is 28 sec (Bottle neck station is Leak testing)

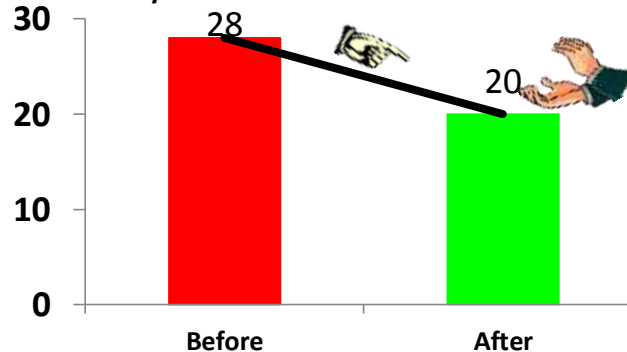
ROOT CAUSE:- Bottleneck CT is 28 Sec.

REGISTRATION NO. & DATE: 1578 & 10.03.17

REGISTERED BY: Mr. Guru Bassappa

MANAGER'S SIGN: Mr. Chamaraj

RESULT:- :- Cycle time reduced from 28 sec to 26 sec.



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	RESP.	STATUS
No Scope in P 14.				

A467 Tensioner Assy. Bottle neck (Leak Testing) Cycle Time Reduction Detail

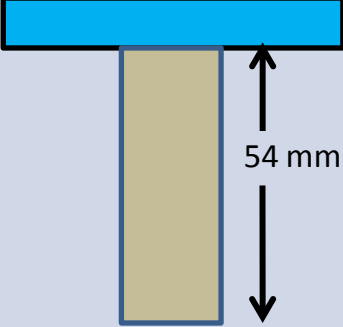
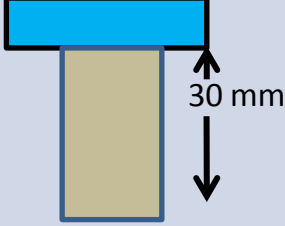
Sr. No	Process Detail	Time in sec		Remark
		Before	After	
1	Component Loading on Fix.	3	3	-
2	Air Filling	5	3	Time reduced based on Component volume & with reference to ATEQ service engineer feedback & trial
3	Air Stabilization	5	3	"
4	Leakage Testing	5	4	"
5	Air Dumping	1	0	We are filling 0.3 bar air for testing as per drawing , so there is no chance of componet get jum after de-clamp, trial taken with 0 Sec found ok..
6	Top Clamp Cylinder Movement (Up & Down)	4	2	Increase the Speed of Cylinder Movement by Control valve
7	Component Unloading From Fix.	3	3	-
8	Cycle start Push Button Operating	2	2	-
Cycle Time		28	20	

Process Validated by :

Signature	Name	Date
M.E :		
QA :		
Prod :		

Approved By:

Signature	Name	Date
Plant Head		

Activity Description	Before Condition	After condition
Time reduced based on Fixture volume reduction.		
Time reduced based on Sealing rubber ID Reduction.	