

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

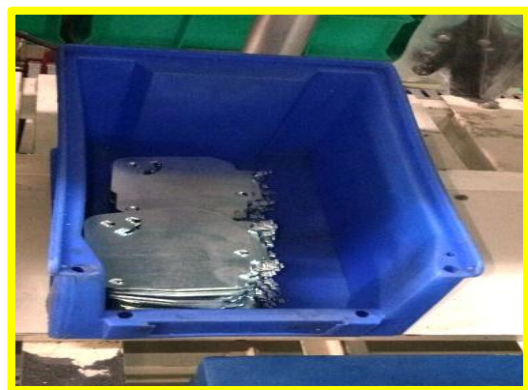
F/IMS/05

CELL: A490 Line 1 **CELL NAME:** CBS Assembly **MACHINE / STAGE:** Child Part Assembly. **OPERATION:** Plate fitment.

KAIZEN THEME: To improve ergonomics activity in CBS assembly @ Child Part Assembly stage

WIDELY/DEEPLY:

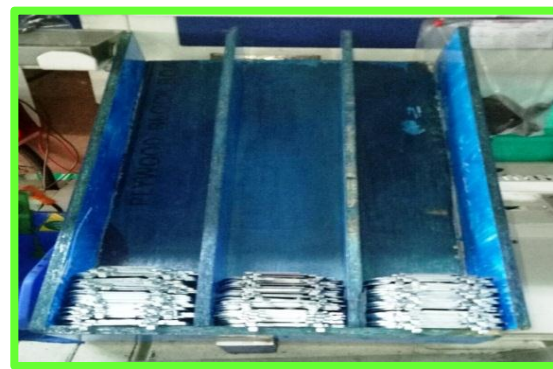
PRESENT STATUS: Approx. 18 times in a shift Operator brings plate to child part assembly stage from input rack.



BEFORE

IDEA: Plate holding tray capacity to be more.

COUNTERMEASURE : Changed Plate holding tray to wooden box where its capacity is 3 times more than plastic tray.



AFTER

BENCHMARK	18 times
TARGET	6 times
KAIZEN START	15.12.16
KAIZEN FINISH	16.12.16

TEAM MEMBERS:
Mr. Girish
Mr. Sridhar

- BENEFITS:**
- ergonomics activity improved.
 - Operator moral increased.

KAIZEN SUSTENANCE

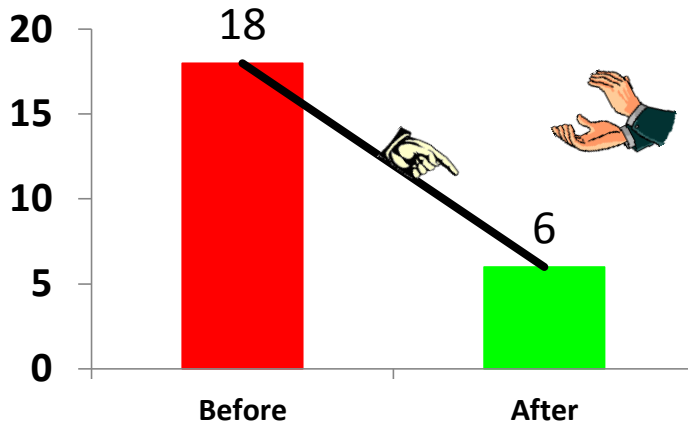
WHAT TO DO : Plates to be kept in wooden stand provided for it..
HOW TO DO : Manually.
FREQUENCY : Top up after it is empty.

WHY - WHY ANALYSIS :-

- Why1:** Approx. 18 times in a shift Operator brings plate to child part assembly stage from input rack.
Why2: Plate holding tray capacity is small.

ROOT CAUSE:-Plate holding tray capacity is small.

RESULT:- Motion time reduced from 18 times to 6 times



REGISTRATION NO. & DATE: #1402, 18 .12.16

REGISTERED BY: Mr. Guru Bassappa

MANAGER'S SIGN: Mr. Chamaraj

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 150/-	-----	INR 150/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS
1	CBS Line 2	15.1.17	Mr. Girish	In Process