

K1

TPM CIRCLE NO: 2
 TPM CIRCLE NAME: Green
 DEPT: Assembly Shop

ACTIVITY
 LOSS NO. / STEP
 RESULT AREA

KK	QM	PM	JH	SHE	OT	DM	E&T
P	Q	DEF:- A	C	D	S	M	

KAIZEN IDEA SHEET

F/IMS/05

CELL: A490 CELL NAME: CBS Assembly MACHINE / STAGE: Cable fitment OPERATION: Cable fitment

KAIZEN THEME: : To Reduce the Cycle time In A490 CBS Assembly Cell

WIDELY/DEEPLY:

PRESENT STATUS : CBS Bottleneck Station (Cable fitment) 14 Sec/Comp.

IDEA: To Reduce the Distance.

COUNTERMEASURE :- To Provided Belt type Conveyer in between Hex-Nut Assembly and Cable Fitment Station.

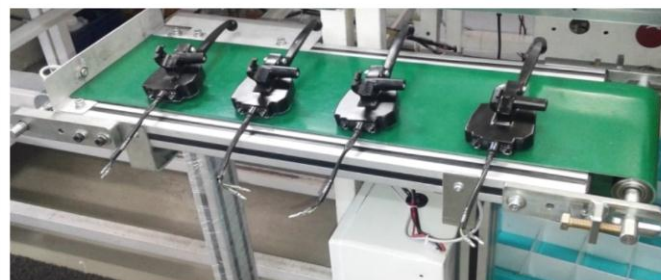
BENCHMARK	C.T 14 Sec
TARGET	C.T 13 Sec
KAIZEN START	08.09.2016
KAIZEN FINISH	28.11.2016

TEAM MEMBERS:
Dinesh, Pramod

BENEFITS:
1) Increase the Productivity



BEFORE



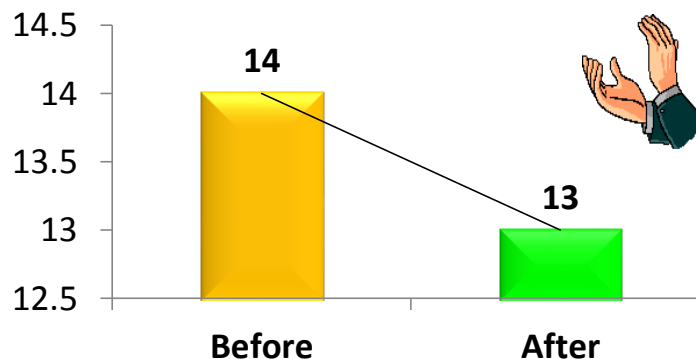
AFTER

WHY - WHY ANALYSIS :-

- Why1:** Bottleneck Cycle time is 14 Sec/Comp.
- Why2:** Operator Movement time more
- Why3 :** Distance between two station is 3 meter.

RESULT:-

Cycle Time/Comp. in Sec



ROOT CAUSE:- Distance between two station is 3 meter.

REGISTRATION NO. & DATE: #1405, 10.10.2016

REGISTERED BY: Mr. Guru Bassappa

KAIZEN SUSTENANCE

WHAT TO DO : Check the Conveyer Working condition
HOW TO DO : manually
FREQUENCY : Start of the Shift.

COST INCURRED FOR MAKING KAIZEN

62000/-	-----	62000/-
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS
	CBS I-2	W4-Jan-17	Pramod.	In-Process