

TPM CIRCLE NO: 1	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME:	LOSS NO. / STEP								
DEPT:	RESULT AREA	P	Q	DEF:- A		C	D	S	M

# KAIZEN IDEA SHEET

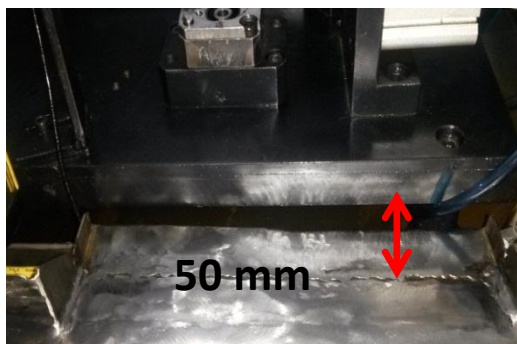
F/IMS/05

CELL: Assembly | CELL NAME: A478 | MACHINE / STAGE: Flushing & free rotation | OPERATION:- Testing

**KAIZEN THEME:-** MTTR to be reduce

**WIDELY/DEEPLY:**

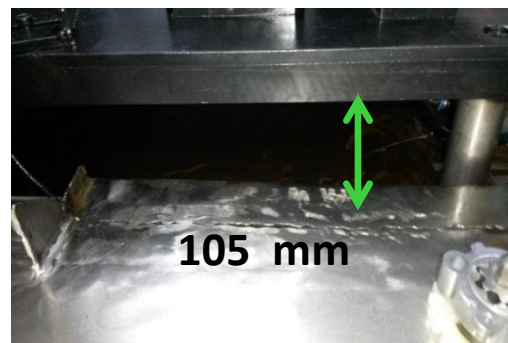
**PRESENT STATUS:-** Not accessing to put hand at the bottom of fixture.



**BEFORE**

**IDEA:-** Increase the clearance

**COUNTERMEASURE :-** Increased the bush height i.e. 50 mm to 105 mm



**AFTER**

<b>BENCHMARK</b>	60 sec
<b>TARGET</b>	10 sec
<b>KAIZEN START</b>	28.06.16
<b>KAIZEN FINISH</b>	28.06.16

**TEAM MEMBERS:**

Pawan  
Ganesh

**BENEFITS:**

1. MTTR reduced
2. Operator Fatigue reduced

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

**Why1:-** Hard to work at fixture bottom side

**Why2:-** Bush height is less i.e. 50 mm

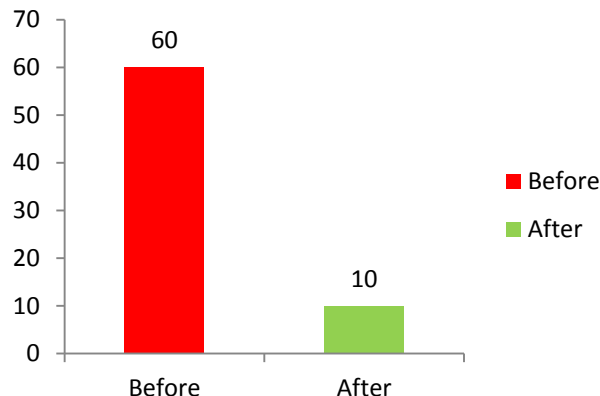
**ROOT CAUSE :-** Less clearence

**REGISTRATION NO. & DATE:** 1190 & 28.06.2016

**REGISTERED BY:** Dinesha.M

**MANAGER'S SIGN:**

**RESULT:-** reduced the time from 60 sec to 10 sec



**WHAT TO DO :-** Ir reversible 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	RESP.	STATUS
1	A177	25.07.16	Pawan	-----