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|--------------------------|-------------|----|----|----|----|----------|----|----|-----|-------------------|
| Dept. :- Assembly | Activity | KK | JH | QM | PM | SHE | OT | DM | E&T | Kaizen No. |
| | Result Area | P | Q | C | D | S | M | | | |
| | Defect Type | | | | | Loss No. | | | | |

| | | | | | | | |
|-----------------|--|------------------|-----------|-----------------|----------|----------------------|-----------|
| Cell No. | | Cell Name | A380/A381 | Machine: | Assembly | Process Stage | Assembly. |
|-----------------|--|------------------|-----------|-----------------|----------|----------------------|-----------|

Kaizen Theme: To eliminate setup change loss. **Kaizen Idea:** To install new line in available re-sources..

Problem / Present Status : Difficult to achieve target of A370, A380, A381 on single line due to plan increased.

Before



Counter Measure : Use the old table, old toggle press, old fixture plate after correction for clearance machine & line.

After



| | |
|----------------------|------------|
| Bench Mark | 40 Mint. |
| Target | 0 |
| Kaizen Start | 02.05.2014 |
| Kaizen Finish | 13.05.14 |

Team Members:- Bhavesh Pednekar, Babasaheb Mhaske, Ramesh Thanvi.

Benefits : 1. Setup change loss eliminated.
2) Line capacity increased.

Why-Why Analysis:-

Why:- Plan is increased..

Why:-Time required to setup change daily..

Why:-New clearance machine of A380 is not installed.

Why:-No space & table available for clearance machine & line.

Root Cause: No table & space available for line.

Results :

- 1). New standby line available in available re-sources & achieve Target as daily requirement.
- 2).Setup loss eliminated.
- 3) Line capacity increased.

Kaizen Sustenance :

What to do :Use line for A380/A381 product time

Scope and Plan for HD

| Sr. No | Model | T/ date | Res. | Status |
|--------|-------|---------|------|--------|
|--------|-------|---------|------|--------|

NA

Registration No. & Date :
Registered by :Sandeep Patil
Manager's Sign :Anil Shende