

TPM CIRCLE NO: 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME: Joshile	LOSS NO. / STEP								
DEPT: Manufacturing Engineering	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

KAIZEN IDEA SHEET

F/IMS/05

CELL: A177 **CELL NAME:** Oil Pump Assy. **MACHINE / STAGE:** Flushing/Assembly **OPERATION:** Free Rotation & Flushing

KAIZEN THEME: To reduce RM cost of Jigs Fixture in A177 Oil Pump Assy. @ Free Rotation & Flushing Stage

WIDELY/DEEPLY:	IDEA: To be separate Bottom wear out & top fixed pin
PRESENT STATUS : Present Rotation Part 2 A177 FL 0108l cost is INR 310/- Piece .	COUNTERMEASURE : Made separate Piece of bottom wear out & top fixed pin & now after life over we are replacing bottom part & cost of Top pin is INR 150/-
<p>Discription : ROTATION PART 2 A177 FL 0108l</p> <p>Approx. Qty. Required/Year : 40 Nos</p> <p>Cost Per Piece : INR 310/-</p> <p>Average FS Jigs/Fix/ RM Cost/M : INR 12400/-</p>	<p>Discription : ROTATION PART 2 A177 FL 0108l</p> <p>Approx. Qty. Required/Year : 40 Nos</p> <p>Cost Per Piece : INR 150/-</p> <p>Average FS Jigs/Fix/ RM Cost/M : INR 6000/-</p>
BEFORE	AFTER
BENCHMARK	INR 12400/-
TARGET	INR 6000/-
KAIZEN START	10.11.17
KAIZEN FINISH	30.11.17
TEAM MEMBERS: N.S.Pujari & Mr. Mallikarjun	
BENEFITS: 1) Cost Saving per annum 6400/-	

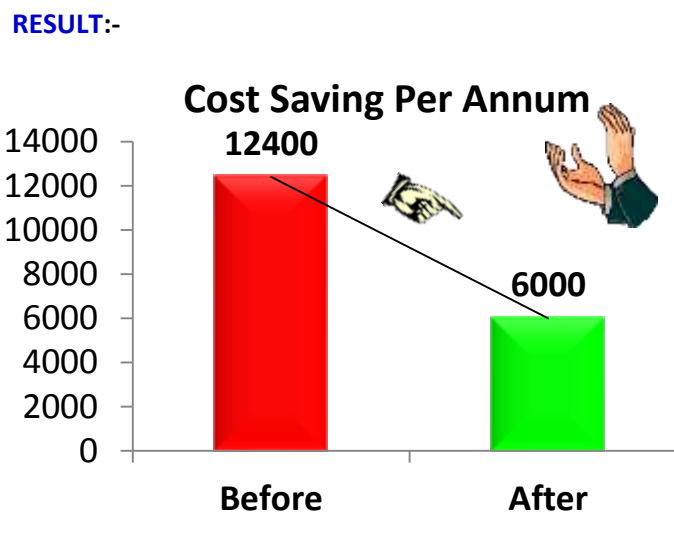
WHY - WHY ANALYSIS :-
Why1: Present Rotation Part 2 A177 FL 0108l cost is INR 310/- Piece .
Why2: Bottom Wear Out Part & Top Fixed Part In One Piece

ROOT CAUSE:- Bottom Wear Out Part & Top Fixed Part In One Piece

REGISTRATION NO. & DATE: 1932 & 30.11.17

REGISTERED BY: Mr. Manas KP

MANAGER'S SIGN: Mr. N.S.Pujari



KAIZEN SUSTENANCE				
WHAT TO DO : Fixture spare part to be update in line with revision & need to replace top pin only after life over				
HOW TO DO : - Manual				
FREQUENCY : On-Going Activity				
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 P14 , Kaizen share to CME for HD Implementation @ other plants				

