

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: A467    CELL NAME: Tensioner Assy.    MACHINE / STAGE: Leak Testing/Assy.    OPERATION: Leak Testing

**KAIZEN THEME:** To Reduce the Jigs/Fixture R& M Cost of A467 Tensioner Assy.

**WIDELY/DEEPLY:**

**PRESENT STATUS :** Present Cost of Leak Testing Top seal is INR 750/- Piece

- 1) Top Seal Life : 4000 Nos
- 2) Average Prod./Month : 50000 Nos
- 3) Top Seal Cost Per Piece : INR 750/-
- 4) Top Seal Requirement Per Month(50000/4000) : 12.5 Nos
- 5) R&M Cost Per Month of top Seal : INR 9375/-
- 6) Make : Dr. Wiesner



**BEFORE**

**IDEA: Make to be replace Dr. Wiesner to Sai Rubber (Rubber Seal Manufacture)**

**COUNTERMEASURE :** Replaced the make from Dr. Wiesner to Sai Rubber & Now Leak Test top Seal Cost is INR 15/- piece

- 1) Top Seal Life : 4000 Nos
- 2) Average Prod./Month : 50000 Nos
- 3) Top Seal Cost Per Piece : INR 35/-
- 4) Top Seal Requirement Per Month(50000/4000) : 12.5 Nos
- 5) R&M Cost Per Month of top Seal : INR 438/-
- 6) Make : Sai Rubber



**AFTER**

<b>BENCHMARK</b>	INR 750/-
<b>TARGET</b>	INR 35/-
<b>KAIZEN START</b>	01.03.17
<b>KAIZEN FINISH</b>	04.03.17

**TEAM MEMBERS:**  
Mr. N.S.Pujari.  
Mr. Murali

**BENEFITS:**  
1) Cost Saving in INR 107250 /- Annum.

**WHY - WHY ANALYSIS :-**

- Why1:** Present Cost of Leak Testing Top seal is INR 750/- Piece
- Why2:** Purchasing from Dealer
- Why3:** No Direct contact with Seal Manufacture

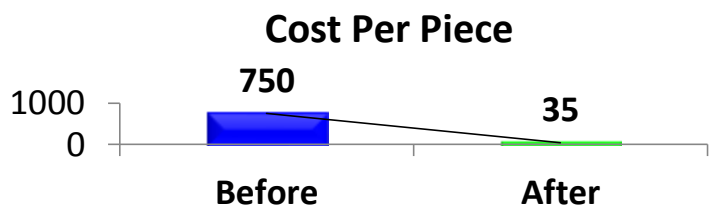
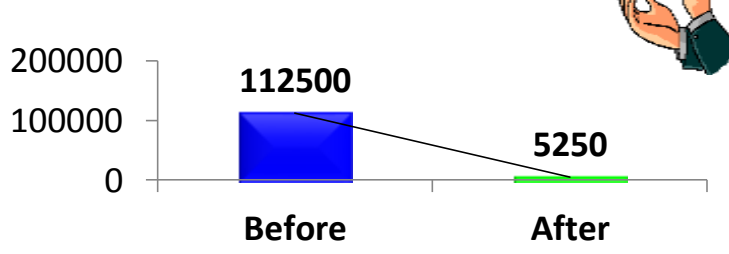
**ROOT CAUSE:-** No Direct contact with Seal Manufacture

**REGISTRATION NO. & DATE:** 1583 & 31.03.2017

**REGISTERED BY:** Mr. Nigamananda

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

**RESULT:- Leak Testing Top Seal Cost Per Annum in INR**



**KAIZEN SUSTENANCE**

**WHAT TO DO :** Irreversible 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	A467 Bottom Seal	30.03.17	N.S.Pujari	Completed