A DUITZ	TPM CIRCLE NO		ACTIVITY		KK	QM	PM J	H SHE	ОТ	DM	E&T	1/117					
() 	TPM CIRCLE NAME : Orion			LOSS NO.		_		<u> </u>					KAIZ	EN IV	EA SI		
DEPT :- Assembly				RESULT AREA Chine / Stage :- A31!		Р	Q	DEF:-A	C	D	S	М					
CELL :-A315 CELL	NAME:- Oil Pum	ip Assy.	MACHI	NE / STAG	E :- A31	o Oil Pu	ımp <i>F</i>	Assembl	y Line	OPE	RAII	<u>ON :-</u>	Plate Fit	tment &	Flushin	ıg	
KAIZEN THEME: To In A315 Oil Pump Assem	-	/Man in	IDEA :	Bottlen	eck Stag	e Time	e < 1!	5 Sec.									
			COUNTERMEASURE:- Changed the Plate								BENCHMARK			490 Nos.			
WIDELY/DEEPLY:-			Assembly Stage activities by distributing Plate								TARGET 565 Nos.						
			putting on Body at Clearance Stage and Reduced								KAIZEN START				10.04.2014		
PROBLEM / PRESENT STATUS :- Present Output/Man is 445 Nos. Earlier Process Cycle Time Line Organisation Loss – 4 Sec.			the Cycle Time of Flushing Stage by 2 Sec. to							u <u>K</u>	KAIZEN FINISH 12.04.2014						
			1 2							-	TEAM MEMBERS :-						
			reduced Bottleneck stage time up-to 13 Sec.								Pramod Kumar						
			Revised Process Cycle Time							<u> </u>	Traniou Ramai						
			Line Organisation Loss – 0 Sec.								BENEFITS :-						
20 11 15	13 13	15	20 -	13	13	13		13	13	1	1. Productivity increased from 1764 Nos. /Shift to 2035 Nos./Shift.						
\ <u>-</u>			10 -							١,							
0										4	2. Save 20 Mandays cost /Month.						
Clearance Plate		Flushing	0 -	Claaranaa	Diete	Fuer	-	Final	Fluobina	٦							
Testing Assembly	Rotation Inspection Testing		Clearance Testing	Plate Assembly	Free Rotation Testing		Final spection	Flushing		KAIZEN SUSTENANCE							
										WHAT TO DO: Irreversible Kaizen.							
		BEFORE							AFTE	N					IE Naizi	en.	
WHY - WHY ANALYSIS :-			RESULT :-								HOW TO DO:FREQUENCY:						
Why1: Output/Man is	s 490 Nos.										KEQ	DEING	1				
Ans.1: Bottleneck Sta		ec.			Outp	ut/N	lan										
			580 - 565 - 560 - 540														
			540 -							C	OST I	NCU	RRED F	OR MAI	KING K	AIZE	
ROOT CAUSE :- Bottle	anack Cycla Tim	o ic 15	520 -	-						MA	TERIA	L COS	T LABOU	JR COST	TOTAL	COST	
	neck cycle film	6 12 13	500 -	490							IN RS			IN RS IN		N RS	
Sec.																	
		480 -							OPF &	E & PLAN FOR HORIZONTAL DEPLOYMEN							
REGISTRATION NO. &	DATE: 09 & 12.	04.14	460	-						SR	· CE			RESPONS			
REGISTERED BY :- Gur	u Basappa		440 -		_	I				¬ NC) "	_					
MANAGER'S SIGN :- Ravi Gouda			Before				Afte		-								