



P14

TPM CIRCLE NO :- 3

TPM CIRCLE NAME : Orion

DEPT :- Assembly Shop

ACTIVITY

LOSS NO. / STEP

RESULT AREA

KK

QM

PM

JH

SHE

OT

DM

E&T

P

Q

DEF :- A

C

D

S

M

# KAIZEN IDEA SHEET

CELL :-A374

CELL NAME:- Oil Pump Assy.

MACHINE / STAGE :- A374 Oil Pump Assembly Line

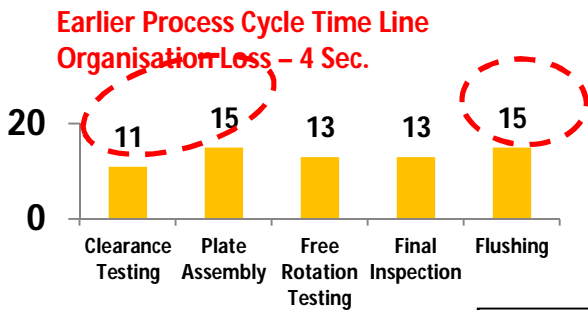
OPERATION :- Plate Fitment & Flushing

**KAIZEN THEME :** To Increase Output/Man in A374 Oil Pump Assembly Line.

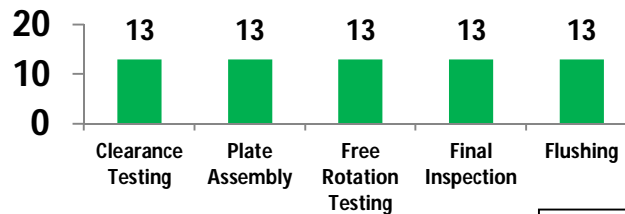
**IDEA :-** Bottleneck Stage Time < 15 Sec.

WIDELY/DEEPLY:-

**PROBLEM / PRESENT STATUS :-** Present Output/Man is 392 Nos.



**COUNTERMEASURE:-** Changed the  
 1. Plate Assembly Stage activities by distributing Gear Sub-Assy. putting on Body at Clearance Stage  
 2. Reduced the Cycle Time of Flushing Stage by 2 Sec. to reduced Bottleneck stage time up to 13 Sec. Revised Process Cycle Time Line Organisation Loss – 0 Sec.



<b>BENCHMARK</b>	392 Nos.
<b>TARGET</b>	452 Nos.
<b>KAIZEN START</b>	16.06.2014
<b>KAIZEN FINISH</b>	18.06.2014

**TEAM MEMBERS :-**  
Pramod Kumar

**BENEFITS :-**

1. Productivity increased from 1764 Nos. /Shift to 2035 Nos./Shift.
2. Save 14 Mandays cost /Month.

## KAIZEN SUSTENANCE

**WHAT TO DO:** Irreversible Kaizen.

**HOW TO DO:**-----

**FREQUENCY :**-----

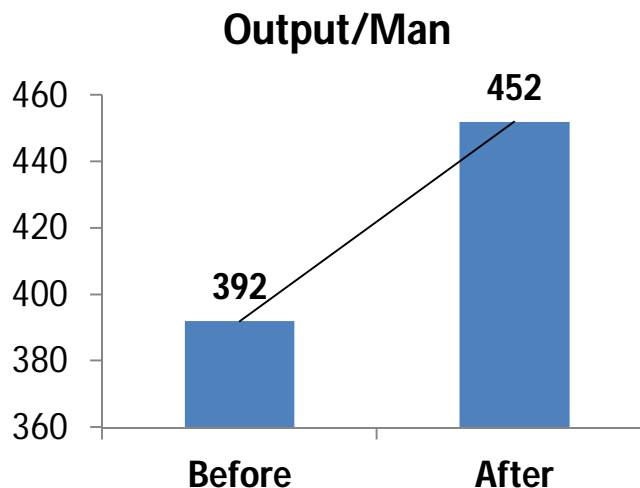
**WHY - WHY ANALYSIS :-**

**Why1:** Output/Man is 392Nos.

**Ans.1:** Bottleneck Stage Time is 15 Sec.

**ROOT CAUSE :-** Bottleneck Cycle Time is 15 Sec.

**RESULT :-**



## 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	RESPONSIBILITY	STATUS
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**REGISTRATION NO. & DATE:** 89 &18.06.14

**REGISTERED BY :-** Guru Basappa

**MANAGER'S SIGN :-** Ravi Gouda