A DUII/ par	TPM CIRCLE NO :- 3		ACTIVITY			QM	PM J	H SHE	OT	DM	E&T	V	IZEN IDEASH		IFFT	
ADVIK P14	TPM CIRCLE NAME : Orion		LOSS NO.									i Naiz	ועו אב	EA 91		
	DEPT :- Assembly Shop		RESULT A		P	Q	DEF :- A	C	D	S	М					
CELL :-A374 CELI	NAME:- Oil Pump Assy.	MACH	NE / STAG	E :- A374	1 OII PU	ımp <i>I</i>	Assembl	y Line	OPE	RAII	<u> </u>	Plate Fi	tment &	Flushin	g	
KAIZEN THEME: To In	crease Output/Man in	IDEA:	 Bottlen 	eck Stag	e Time	e < 1!	5 Sec.									
A374 Oil Pump Assem	ıbly Line.															
l			COUNTERMEASURE:- Changed the								BENCHMARK			los.		
WIDELY/DEEPLY:-			1. Plate Assembly Stage activities by								TARGET 452 Nos. KAIZEN START 16.06.20					
			distributing Gear Sub-Assy. putting on Body													
PROBLEM / PRESENT STATUS :- Present			at Clearance Stage						K	KAIZEN FINISH 18.06.2014						
Output/Man is 392 Nos.		2. Reduced the Cycle Time of Flushing Stage by							, Т	TEAM MEMBERS :-						
ļ										Pramod Kumar						
Earlier Process Cycle Time Line		2 Sec. to reduced Bottleneck stage time up-														
Organisation Loss – 4 Sec.			to 13 Sec. Revised Process Cycle Time								BENEFITS :-					
	Line Organisation Loss – 0 Sec.								1. Productivity increased from 1764							
20 1 15	13 13 15	20 -	13	13	13		13	13					2035 No			
		10 -							2	Sa	ν <u>ο</u> 1/	Mand	ays cost	/Mont	h	
0										. Ju	IVC I	rivialia	ays cost	/ IVIOI10		
Clearance Plate	Free Final Flushing	0 -	Clearance	arance Plate	Free	,	Final	Flushing	` 	MAIZEN CHCTENIANOE						
Testing Assembly Rotation Inspection			Testing Assembly Rotation Inspection							KAIZEN SUSTENANCE						
	Testing	1			Testin	g		AFTE	_ v	VΗΔΊ	Γ ΤΟ Ι	∩O∙ Irr	eversibl	e Kaize	e n	
	BEFORE							AFTE	\					O Mail	J	
WHY - WHY ANALYSIS :-			RESULT :-							FREQUENCY :						
Why1: Output/Man i	s 392Nos.									KLQ	OLIVO					
Ans.1: Bottleneck Sta				Outp	ut/M	lan										
				o ap.												
			460 ¬ 452													
			1440													
			440 -													
	420								COST INCURRED FOR MAKING KAIZEN							
ROOT CAUSE :- Bottleneck Cycle Time is 15 Sec.		420 -							MA	MATERIAL COST LABOUR COST TOTAL COST					COST	
		400 - 392								IN RS IN RS IN RS					RS	
3 00.		400														
		380							SCO	OPE &	PLAN	FOR HC	RIZONTA	L DEPLO	ЭҮМЕ	
REGISTRATION NO. &	DATE: 89 &18.06.14]							SR				RESPONS			
		360			-				¬ NO		LL	IAKGEI	KESPUNS	DIBILI I	SIAIL	
REGISTERED BY :- Guru Basappa		Before After														
MANAGER'S SIGN :- Ravi Gouda			Deluie Allei													