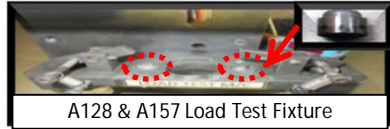


CELL :- Load Testing | CELL NAME :- Tensioner Assy. | MACHINE / STAGE :- Load Testing/ Inspection | OPERATION :- ---

KAIZEN THEME : To Reduce the Set-up Change Over Time of A128 & A467 Tensioner load Testing at Inspection Stage.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS: Set-up Changeover Time is 45 Minutes for changeover of Load Testing Fixture from Model A128 to Model A467 or vice-versa.



BEFORE

IDEA :- 2-Model – 2 Load Testing Fixture-1 Load Testing Machine.

COUNTERMEASURE:- Modification done in Existing Load Testing Fixture, know Set-up Change over by Orientation Pin Change, to reduce the set-up change over time.



AFTER

BENCHMARK	45 Minutes
TARGET	1 Minute
KAIZEN START	22.05.2016
KAIZEN FINISH	22.05.2016

TEAM MEMBERS :-

N.S.Pujari.

Ambarish

BENEFITS :-

1. Reduce Set-up Change Over Time 45 Min to 1 Min.
2. Save New Fixture Procurement Cost INR 8000/-
3. User Friendly.

KAIZEN SUSTENANCE

WHAT TO DO:- Ir-reversible Kaizen (One Time Action)

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	RESPONSIBILITY	STATUS
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WHY - WHY ANALYSIS :-

Why1: Set-up Changeover Time is 45 Minutes for changeover of Load Testing Fixture from Model A128 to Model A467

Why2: 2-Model – 2 Load Testing Fixture-1 Load Testing Machine.

ROOT CAUSE :- 2-Model – 2 Load Testing Fixture-1 Load Testing Machine.

REGISTRATION NO. & DATE : #1151, 31.05.16

REGISTERED BY :- N.S Pujari

MANAGER'S SIGN :- N.S.Pujari

RESULT :-

Reduced Set-Up Change over time

