

TPM CIRCLE NO:	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME:	LOSS NO. / STEP								
DEPT: Assembly Shop	RESULT AREA	P	Q	DEF:- A		C	D	S	M

KAIZEN IDEA SHEET

F/IMS/05

CELL: Washing **CELL NAME:** Washing Cell **MACHINE / STAGE:** Rotary Washing m/c **OPERATION:** Component Washing

KAIZEN THEME: To reduce component washing time of A315 Oil pump body.

WIDELY/DEEPLY:

PRESENT STATUS: Presently A315 Oil pump Body washing cycle time is 9sec/ comp.



BEFORE

IDEA: Component loading tray size to be modified to 3 rows with 120 pockets in each tray.

COUNTERMEASURE : Provided a metallic rack in the center of the tray where still 40 no's components can be loaded in each tray.



AFTER

BENCHMARK	CT 9 sec
TARGET	CT 6 sec
KAIZEN START	25.10.16
KAIZEN FINISH	30.10.16

TEAM MEMBERS:

Mr. Praveen Jannu , Mr. N.S. Pujari
Mr. Pavan , Miss Geeta

BENEFITS:

1) Increase out Put/hour from 400 No's to 600 Nos.

KAIZEN SUSTENANCE

WHAT TO DO : Ir reversible Kaizen.
HOW TO DO : -----
FREQUENCY : One time activity

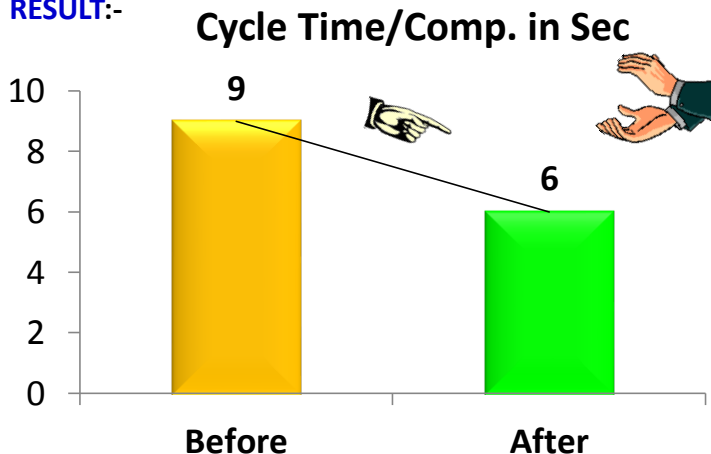
WHY - WHY ANALYSIS :-

Why1: Presently A315 Oil pump Body washing cycle time is 9sec/ comp.

Why2: Component loading tray size is 2 rows with 80 pockets in each tray.

ROOT CAUSE:- Component loading tray size is 2 rows with 80 pockets in each tray.

RESULT:-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 250/-	-----	INR 250/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESP.	STATUS

No scope in P 14

REGISTRATION NO. & DATE: 1304, 10.10.16

REGISTERED BY: Mr. Guru Bassappa

MANAGER'S SIGN: Mr. Chamaraj