I TE		_								г— - — г				
	TPM CIRCLE NO :-		ACTIVITY	KK	QM	PM J	1 SHE	ОТ	DM	E&T	KAIZEN IDEA SHEET			
	PM CIRCLE NAME :-	LOSS NO. / STE		П	0	DEE : A /F	/o C	_	-	KAIZEN NO				
	EPT :- Production ELL NAME:- Oil pump								D S M OPERATION:-Boring ,facing & Tapping					
CEEE: On pump	ELL NAME. On pump	IVIAC	SININE / STAGE	Bioti	iei iii	<i>i</i> C		UF	ENAI	10N	borning ,ia	acing o	x rapping	
KAIZEN THEME :-To increase output Per hour.		IDEA :- Cycle time decrease												
		COUNTERMEASURE:-A315 Oil pump two fixture							BENCHMARK 138 nos					
WIDELY/DEEPLY:-		run on Double pallet brother m/c due to which							TARGET 200 nos KAIZEN START 03.10.2016					
PROBLEM / PRESENT STATUS :-A315 Oil Pump only one fixture run on FRD M/C .Due to Which cycle time 26 sec (machining time + loading & unloading time) & output per hour - 138 nos.		Loading & unloading time eliminated. Now cycle time 18 sec.												
								<u> </u>	KAIZEN FINISH 12.10.2016					
		ATER							TEAM MEMBERS :-					
									Amit , Harish , Pratap ,Ashok					
									,,					
									BENEFITS :-					
									1. Output per hour increased.					
										2. productivity increased				
									3. Tooling cost reduced					
										4. M/C cost reduced				
										KAIZEN SUSTENANCE				
	BEFORE													
WHY - WHY ANALYSIS :- WHY1 :-Output per hour 138 nos			RESULT :-							WHAT TO DO :- IR- reversible				
ANS 2:- Cycle time 26 sec									HOW TO DO . N/A					
									HOW TO DO :- N/A					
			Output per hour in nos							FREQUENCY :- one time activity.				
			300											
	200 200							COST INCURRED FOR MAKING KAIZEN						
ROOT CAUSE :-Cv	Cycle time 26 sec	100				Output		t M	MATERIAL COST LABOURS.			соѕт	TOTAL COST RS.	
						ne	r						-	
		o per hour scope 8								& PLAN FOR HORIZONTAL DEPLOYMENT				
REGISTRATION NO&DATE	Before Atter hour						SF	SR. NO. CELL TARGET RESPONSIBILITY STATUS						
REGISTERED BY :-														
MANAGER'S SIGN :-			V						I					