
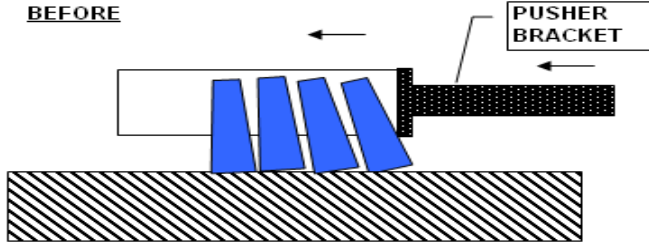
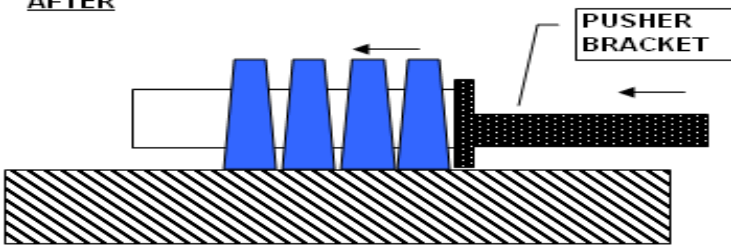
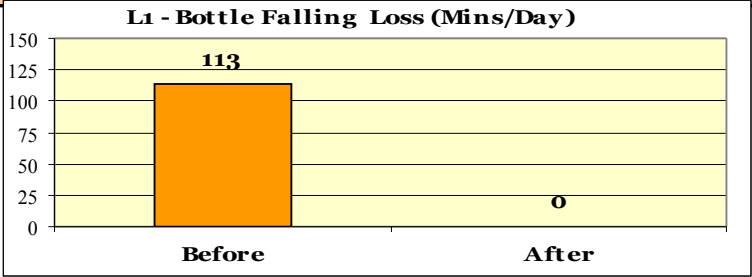


14th KAIZEN CONFERENCE		KAIZEN IDEA SHEET		Activity	KK	JH	QM	PM	SHE	OTPM	DM	ET													
		Operator Level Kaizen		Loss No./Step																					
				Result Area		P	Q	C	D	S	M														
Plant:	GOA	Dept.:	Filling	Machine:	L1			Marico Limited, Goa																	
Kaizen Theme:		Idea:		Kaizen No.		K09 - 145		Benchmark:		113 mins		Target:		0 mins											
Reduction in minor stoppage loss due to bottle falling at L1 pusher of autocollator machine.		Create the push on the bottle closer to its base so that its stability is maintained.		Kaizen start:		12/15/2009		Kaizen finish:		12/30/2009															
Problem / Present Status: (in words)		Countermeasure: (in words)		Team members:		Amod Deasi Rajesh Fernandes Anand Sinari																			
Due to a buisness need pack changeover has been taken on the machine from a bigger SKU to a smaller SKU , The smaller SKU bottles are falling at the pusher assembly during the pushing operation, at the packing stage of the bottles.Resulting in Line stoppage of 113 min / Day		Reduce the height of the pusher so that the point of contact is closer to the base; thus preventing bottle toppling or failing																							
Illustration: (with sketch)		Illustration: (with sketch)		Benefits:		<ol style="list-style-type: none"> 1. Bottle falling reduction 2. Reduced stoppages 3. Increase in Productivity 																			
																									
Analysis: (why - why)		Results:		Scope for HD		<table border="1"> <tr> <td>Sr. no.</td> <td>K09 - 145</td> </tr> <tr> <td>M/c.no.</td> <td>L2 and L3</td> </tr> <tr> <td>Target Date</td> <td>1/15/2010</td> </tr> <tr> <td>FPR</td> <td>Rajesh F</td> </tr> <tr> <td>Status</td> <td>Done</td> </tr> </table>										Sr. no.	K09 - 145	M/c.no.	L2 and L3	Target Date	1/15/2010	FPR	Rajesh F	Status	Done
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M/c.no.	L2 and L3																								
Target Date	1/15/2010																								
FPR	Rajesh F																								
Status	Done																								
Why 1	Bottles falling at pusher																								
Why 2	Pushing action																								
Why 3	Point of contact at a distance from the base of the bottles																								