



5th /6th KAIZEN CONFERENCE

KAIZEN IDEA - SHEET

Activity	KK	JH	QM	PM	SHE	OTPM	DM	ET
Loss No./ Step	10							
Result Area	P	Q	C	D	S	M		

Endurance Systems (I) Pvt. Ltd,
E-92, MIDC, Waluj, Aurangabad

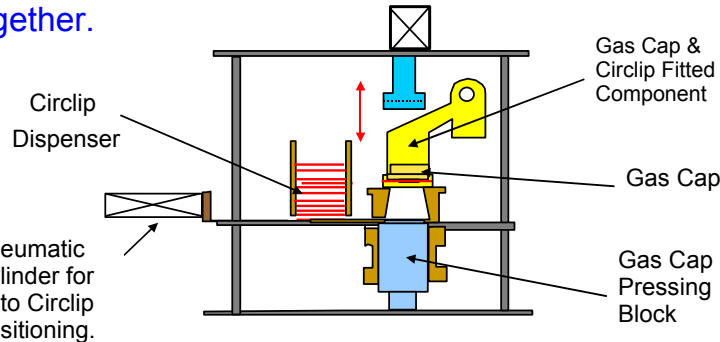
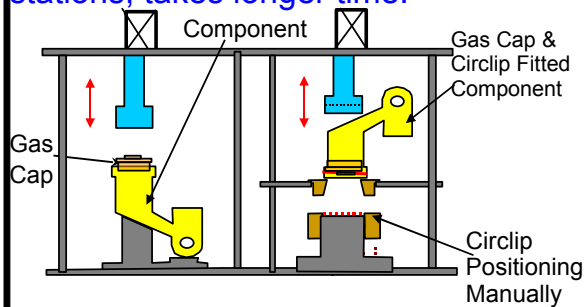
Plant :E-92, MIDC, Waluj, Aurangabad Machine : Gas Cap and Circlip Inserting machine

Kaizen Theme : To eliminate operator motion loss involved in Gas Cap Pressing and Circlip insertion

Idea : Same Work station with auto circlip positioning.

Problem/present status : Operator has to press the Gas Cap and insertion of Circlip in 2 separate stations, takes longer time.

Countermeasure: A Circlip dispenser provided, with a pneumatic cylinder to position circlip after Gas Cap pressing. Now both operations are done together.



1. Gas Cap Pressing

2. Circlip Insertion

Gas Cap Pressing and Circlip Insertion together

Bench mark	05 Sec.
Target	0 Sec.
Kaizen start	13.02.05
Kaizen Finish	15.03.05

Team members

Mr. Atul Khoche
Mr. Sachin Jadhav

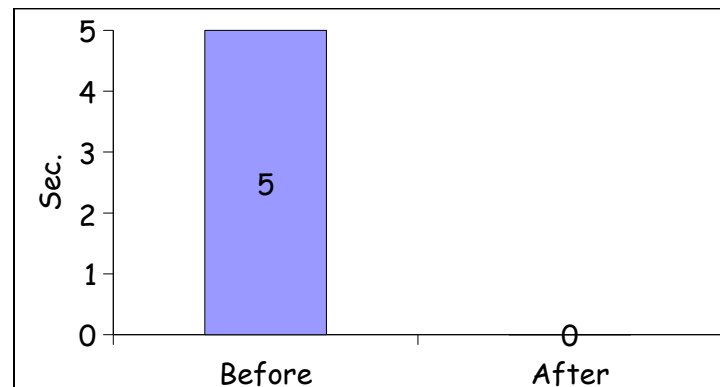
Benefits:

1. Production increased from 1440 to 1920 nos. per shift as Cycle Time reduced from 20 Sec. to 15 Sec.
2. Elimination of Circlip Damage.
3. Reduction in Cost of compressed air by Rs 720 /- per day
4. Employee morale improved
5. Floor Space saved.

Analysis :

Operator motion loss
 ↓ Why
 After Gas Cap Pressing operator has to reload component on circlip insertion fixture and position the circlip manually
 ↓ Why
 Separate work station for both operation

Results : Operator Motion Loss Per Cycle



Scope & plan for Horizontal Deployment

S no	M/c No.	Target dat	Responsibility	Status
NA	NA	NA	NA	NA

