5th KAIZEN CONFERENCE

KAIZEN IDEA - SHEET

Activity	KK	JH	QM	PM	SHE	OTPM	DM	ET
Loss No./Step	11							
Result Area		P	Q	C	D	S	M	
		✓						

TITAN INDUSTRIES LTD
HOSUR

Plant : Watch division

Machine: Conveyor Assembly Line

Kaizen theme : To Reduce Cycle time in Watch Movement Assembly.

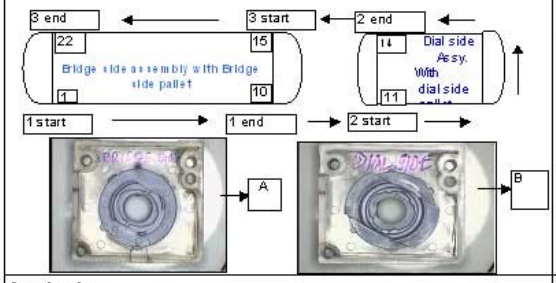
Idea : Provide relief in bridge side pallet

Problem/present status :

*Movement assembly carried out in 2 conveyor lines with 22 stations

*Activities at station #10 & #15 require 2 types of pallets.

1. Unload movement @ Stn 10 from pallet A, reverse & keep in B @ stn11
2. Unload movement @ Stn 14 from pallet B, reverse & keep in A @ stn15

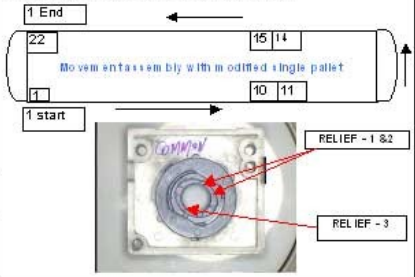


Countermeasure :

* Movement Assy in One conveyor line. Bridge side pallet was modified(relief was provided) to accommodate the movement on dial side.

* At Stn 11 & 15, Movement reversed & kept in same pallet.

* Operations reorgaised at stations 7 to 10.



Bench mark	7.58 Sec
Target	6.8 Sec
Kaizen start	Aug 2004
Kaizen Finish	Dec 2004

Team members :

M.Mari, P.Saravanan, P. Gayathri, G.C.Sashikala, Sivakumar(Maint)

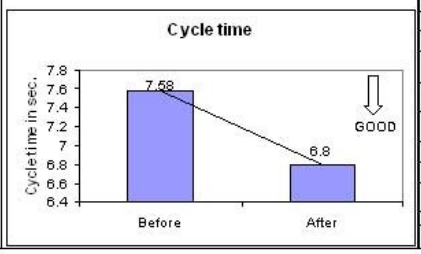
Benefits:

Cycle time reduction resulted 11 % production increase 105 K.

Analysis :

Cycle time more
↓ Why
Activities involving 2 types of pallets
↓ Why
Dial side operation cannnot be accomodated in bridge side pallet
↓ Why
Pallet profile for Dial & bridges sides are different
↓ Why
No relief for location in bridge side pallet

Results :



Scope & plan for Horizontal Deployment

Sl No.	M/C No.	Targert date	Responsibility	Status
Not applicable				