

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

CELL :-A312 | CELL NAME:- A312 oil pump. | MACHINE / STAGE :- Flushing machine | OPERATION :- Flushing

KAIZEN THEME : To eliminate problem of ok job showing less L.P.M. at flushing m/c

WIDELY/DEEPLY:-

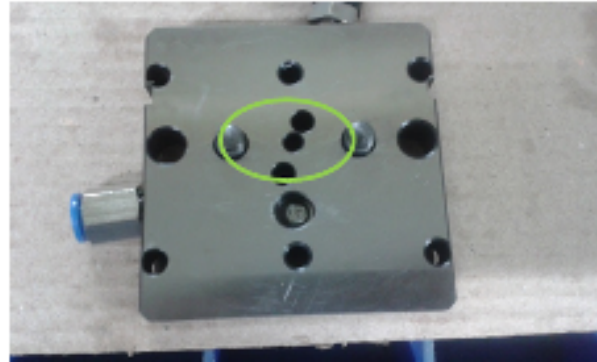
PROBLEM / PRESENT STATUS :- Ok job showing less L.P.M.



BEFORE

IDEA :- Flushing machine fixture to be modified.

Countermeasure :- Flushing fixture modified by reducing kidney slot area to avoid leakage.



AFTER

WHY - WHY ANALYSIS :-

Why 1 – L.P.M. not showing (Less LPM)

Why 2 – Oil not pass through flow meter.

Why 3 – Oil gets leakage through fixture

Why 4 – Kidney slot of fixture design excess size.

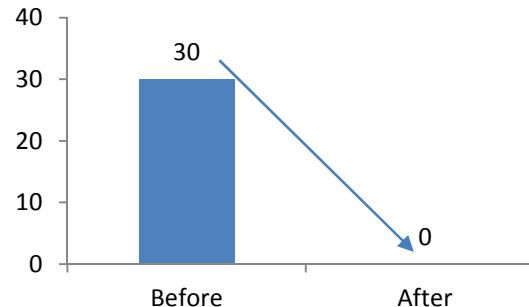
ROOT CAUSE :- Kidney slot of fixture wear out.

REGISTRATION NO. & DATE: 05.10.14

REGISTERED BY :- Parmeshwar B

MANAGER'S SIGN :- sunil kinkar

RESULT :-



BENCHMARK	30 No.
TARGET	0 No.
KAIZEN START	05.10.2014
KAIZEN FINISH	26.10.2014

TEAM MEMBERS :-

Samadhan Visave.

Nitin Sutar.

BENEFITS :-

1. Avoid the rejection.
2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO: -----

HOW TO DO: - Verify pokayoke at the start with master sample.

FREQUENCY : Daily.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
600	-----	600

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
01	A312 cell no 2	4.11.14	Samadhan	Completed