



P14

TPM CIRCLE NO :- 1	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :	LOSS NO. / STEP								
DEPT :- Q.A	RESULT AREA	P	Q	DEF:- A	C	D	S	M	

KAIZEN IDEA SHEET

CELL :-A361	CELL NAME:- Oil pump	MACHINE / STAGE :-VMC	OPERATION :-Drilling
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KAIZEN THEME : To avoid A361 Body Dia 6.5 mm hole Center distance shift by 0.2204 mm wrt dowel hole .

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS A361 Body Dia 6.5 mm hole Center distance shift by 0.2204 mm wrt dowel hole .

IDEA :- Operation sequence to be changed .

COUNTERMEASURE:- :- Drilling operation done in Ist set up 40 mm & II nd set up 20 mm.

BENCHMARK	12No.
TARGET	0 No.
KAIZEN START	11.07.2014
KAIZEN FINISH	11.07.2014

TEAM MEMBERS :-
Ganesh padwalkar
Umesh Pimple

BENEFITS :-

1. Prevent Re-occurrence of Customer Complaint.
2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO: Add Checkpoint action sustain check sheet
HOW TO DO: Checking during audit
FREQUENCY : once in week

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

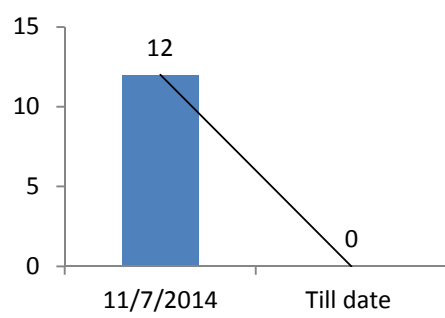
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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BEFORE

AFTER

WHY - WHY ANALYSIS :-
Why 1 – 12 Nos. A361 Body Dia 6.5 mm hole Center distance shift by 0.2204 mm wrt dowel hole .
Why 2 –Drill drift During operation .
Why 3 –As cast dia (6.6 to 5.4 length 54 mm)
Why 4 – Casting process concern draft angle 15 degree.

RESULT :-



ROOT CAUSE Casting process concern draft angle 15 degree.

REGISTRATION NO. & DATE: 11.07.2014

REGISTERED BY :- Ganesh

MANAGER'S SIGN :- Sunil kinkar