

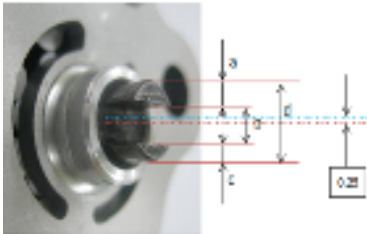
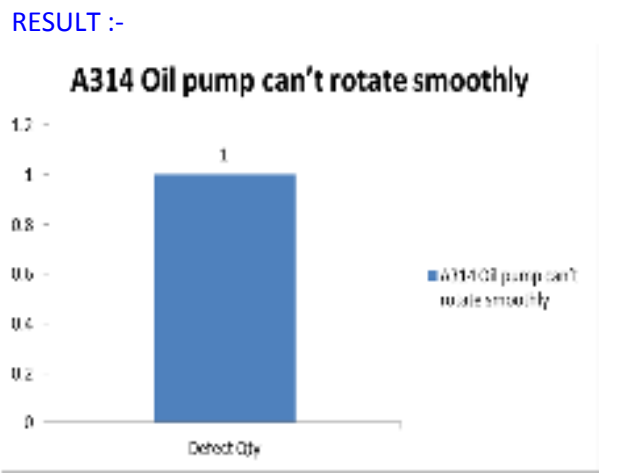


		TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET																				
		TPM CIRCLE NAME :	LOSS NO. / STEP										KAIZEN NO:-01																			
		DEPT :- IQA	RESULT AREA	P	Q	DEF:- A	C	D	S	M																						
CELL :-A314	CELL NAME:-Oil Pump Assembly	MACHINE / STAGE :Milling						OPERATION :-Slot Milling																								
KAIZEN THEME To prevent Occurrence of rotation jam Issue in A314 Oil Pump Assembly			IDEA :- Detection Type Pokayoke to be provided on D-Milling M/C .																													
WIDELY/DEEPLY:-			COUNTERMEASURE:-					BENCHMARK 01 No.																								
PROBLEM / PRESENT STATUS :- A314 Oil pump can't rotate smoothly /Jump after assembled in crankcase (A314 Shaft symmetry NG With respect to OD 6.8mm.)																																
 <table border="1" style="float: right; margin-top: 10px;"> <thead> <tr> <th>Part</th> <th>Standard</th> <th>Actual</th> <th>Judge</th> </tr> </thead> <tbody> <tr> <td>a</td> <td>1.6~1.8</td> <td>1.91</td> <td>NG</td> </tr> <tr> <td>b</td> <td>±0.102</td> <td>0.14</td> <td>OK</td> </tr> <tr> <td>c</td> <td>1.6~1.8</td> <td>1.46</td> <td>NG</td> </tr> <tr> <td>d</td> <td>0.05^{+0.02}_{-0.02}</td> <td>0.12</td> <td>OK</td> </tr> </tbody> </table>			Part	Standard	Actual	Judge	a	1.6~1.8	1.91	NG	b	±0.102	0.14	OK	c	1.6~1.8	1.46	NG	d	0.05 ^{+0.02} _{-0.02}	0.12	OK	BEFORE					AFTER				
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WHY - WHY ANALYSIS :- Why 1: A314 Oil pump can't rotate smoothly /Jump Why 2: Symmetry of U Milling wrt to OD NG (Spec 0.1 & actual 0.25mm Why 3- Lug wall thickness variation one side 1.91 & other side 1.46 (0.45mm) spec 1.6-1.8mm) Why 4- Setting rejection Mix-up & not detect in next process .			RESULT :- 																													
ROOT CAUSE: Setting rejection Mix-up & not detect in next process .			WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram HOW TO DO : Verify the action plan - FREQUENCY – As Per supplier Audit plan.																													
REGISTRATION NO &DATE::14.07.2014			COST INCURRED FOR MAKING KAIZEN																													
REGISTERED BY :- Parmeshwar Bansode			MATERIAL COST IN RS		LABOUR COST IN RS		TOTAL COST IN RS																									
MANAGER'S SIGN :- Sunil Kinkar			-----		-----		-----																									
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																																
Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS																												
1	-----	-----	-----	-----																												