

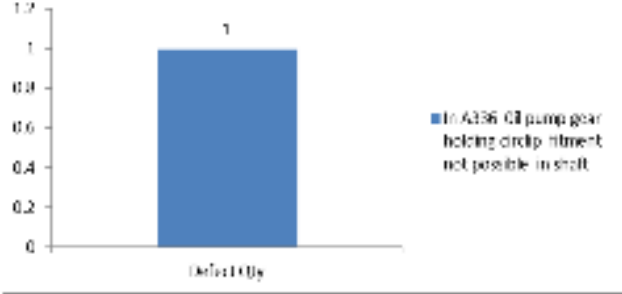


		TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	<b>KAIZEN IDEA SHEET</b> KAIZEN NO:-01
		TPM CIRCLE NAME :-	LOSS NO. / STEP	P	Q	DEF:- A	C	D	S	M		
		DEPT :- M/c Shop QA	RESULT AREA									
CELL :-A336	CELL NAME:-Oil Pump Assembly	MACHINE / STAGE :Drilling			OPERATION :-Drilling							
<b>KAIZEN THEME</b> To prevent occurrence of gear holding circlip fitment not possible in Oil pump shaft .		<b>IDEA :-</b> 1.During 2nd drilling operation groove area resting taken away by 5 mm from V block face.										
<b>WIDELY/DEEPLY:-</b>  <b>PROBLEM / PRESENT STATUS :-</b> In A336 Oil pump gear holding circlip fitment not possible in shaft .		<b>COUNTERMEASURE:-</b> 1.During 2nd drilling operation groove area resting taken away by 5 mm from V block face. 2. Shaft groove end will be kept hanging to avoid groove face damage. 3. Coolant pressure increased to avoid burr accumulation on V block. 4. 100% checking started by groove checking snap gauge at supplier end also.				<b>BENCHMARK</b> <b>TARGET</b> 0 No. <b>KAIZEN START</b> 27.07.2014 <b>KAIZEN FINISH</b> 02.08.2014			<b>TEAM MEMBERS :-</b> Mohan Kate, Sunil Kinkar			
					<b>BENEFITS :-</b> 1)No production loss 2) No Supplier Rejection 3)No customer complaint							
<b>WHY - WHY ANALYSIS :-</b> <b>Why 1:</b> Oil pump gear holding circlip fitment not possible in shaft. <b>Why 2:</b> Shaft damage on groove face area. <b>Why 3:</b> Existing shaft machining process allows to damage the part on groove. <b>Why 4:</b> Burr particles sticky inside of V block & after clamping next shaft its getting damage on groove area. <b>Why 5:</b> During 2nd drilling operation groove area rest near V block face.		<b>KAIZEN SUSTENANCE</b>  <b>WHAT TO DO :-</b> Check point Added In Supplier action plan sustenance sheet & change process flow diagram <b>HOW TO DO :</b> Verify the action plan - <b>FREQUENCY –</b> As Per supplier Audit plan.										
<b>ROOT CAUSE:</b> During 2nd drilling operation groove area rest near V block face.		<b>RESULT :-</b> 										
<b>REGISTRATION NO &amp; DATE::</b> 27.07.2014		<b>COST INCURRED FOR MAKING KAIZEN</b>										
<b>REGISTERED BY :</b> Sunil Kinkar		<b>MATERIAL COST IN RS</b>			<b>LABOUR COST IN RS</b>			<b>TOTAL COST IN RS</b>				
<b>MANAGER'S SIGN :-</b> Sunil Kinkar		-----			-----			-----				
<b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b>												
Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS								
1	-----	-----	-----	-----								