

CELL :-A328 CELL NAME:- Oil pump Assembly MACHINE / STAGE :- A328 Assembly Line OPERATION :- Assembly Stage

KAIZEN THEME : To Prevent re-occurrence of Customer Complaint of shaft length o/s (10.20mm)

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- 2 Nos. found at customer end without outer rotor assly.

No provision for arresting 10.20 mm o/s shaft

BEFORE

IDEA :-Add Poka Yoke

COUNTERMEASURE:- Sensor implemented for 10.20 mm o/s shaft and interlock with Gun.



AFTER

WHY - WHY ANALYSIS :-
Why1: Oil pump gets jam
Why 2: Shaft gets stuck while assembly
Why 3:-Shaft 10.20 mm dim. found 11.0 mm
Why 4: Milling done manually at supplier end
Why5: No pokayoke on assembly line

ROOT CAUSE :- No pokayoke .

REGISTRATION NO. & DATE: 15.07.14

REGISTERED BY :- Bhavesh Pednekar

MANAGER'S SIGN :- Anil Shende

RESULT :-

No rejection pass through process

BENCHMARK	2 No.
TARGET	0 No.
KAIZEN START	15.07.2014
KAIZEN FINISH	15.07.2014

TEAM MEMBERS :-
 Bhavesh Pednekar, Sandip Patil
 Sunil Kinkar Sir

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

KAIZEN SUSTENANCE

WHAT TO DO: Add Checkpoint in FGCP

HOW TO DO: Verify pokayoke at the start and hourly basis with master sample.

FREQUENCY : 100 %

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
01	A372	15/07/14	Maint.	C