

TPM CIRCLE NO :- 3	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Orion	LOSS NO. / STEP								
DEPT :- Q.A	RESULT AREA	P	Q	DEF :- A		C	D	S	M

CELL :-A247	CELL NAME:- CBS Assembly	MACHINE / STAGE :- A347 Assembly Line	OPERATION :- Flushing Stage
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KAIZEN THEME : To Prevent re-occurrence of Customer Complaint of Parking Lock Not working in CBS Assembly.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- 9 Nos. found at customer end without outer rotor assly.



IDEA :- Use transparent poly bags

COUNTERMEASURE:- Make transparent poly bags for visualize the job at packing time



AFTER

BENCHMARK	9 No.
TARGET	0 No.
KAIZEN START	17.06.2014
KAIZEN FINISH	17.06.2014

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 each tray of packing by QA inspector

FREQUENCY : 100 %

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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WHY - WHY ANALYSIS :-

Why1: Oil pump assembly not complete

Why 2: Outer rotor missing

Why 3:-While packing operator missed outer rotor

Why 4: Manual process and cannot able to detect

Why5: Polybag used for packing is not transparent

ROOT CAUSE :- Poly bag is not transparent.

REGISTRATION NO. & DATE: 17.06.14

REGISTERED BY :- Bhavesh Pednekar

MANAGER'S SIGN :- Anil Shende

RESULT :-

Under monitoring