

TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTP M	DM	E & T	KAIZEN IDEA SHEET
TPM CIRCLE NAME :		LOSS NO./STEP									
<b>Plant : P14</b>	DEPT :	Production	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M

CELL :	A657	CELL NAME :	OIL PUMP BODY	M/C STAGE:	BROTHER-7	OPERATION:	Facing, Reaming drilling
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KAIZEN THEME : KAIZEN IDEA :

Rejection percentage reduction on A657 line	Reamer design has to remodify and the same should be updated in process control plan	BENCHMARK:	3.00 %
		TARGET:	0.07%
		KAIZEN START:	20.11.18
		TARGET DATE:	29.11.18

PROBLEM PRESENT STATUS : COUNTERMEASURE:

Dowel pin hole load NG due to Dia 2.97 mm NOGO answering	Reamer design changed in diameter from 2.97 to 2.964 and drill changed from 2.5 to 2.7...	KAIZEN FINISH:	29.11.18
		TEAM MEMBERS:	
		<u>Mr.Manas</u>	<u>Mr.Satish</u>
		BENEFITS:-	Rejections percentage is reduced

WHY-WHY ANALYSIS:

- Why1:-** Dowel pin load NG during assembly
- Why2:-** Dowel pin hole diameter 2.97mm Plug gauge NOGO answering
- Why3:-** Dia2.97 Reamer used for dowel hole Reaming



KAIZEN SUSTAINANCE

WHAT TO DO:  
HOW TO DO: ----  
FREQUENCY:

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

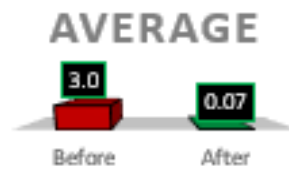
SR. NO	CELL/ PRODUCT	TDC	RESP.	STATUS
1	A657	30.12.18	Prod	Pending

ROOT CAUSE

Plug gauge NOGO size is 2.97mm and Dia 2.97mm reamer used for dowel reaming

RESULTS:

Rejection (Load NG) percentage is reduced from, 3.0% to 0.07.....



HD SCOPE INFORMATION IN OTHER PLANT

SR.NO.	PLANT	WHEN	WHOM	STATUS