

CELL :-A337	CELL NAME:- Oil Pump Line	MACHINE / STAGE :- VMC (Brother)/ Machining	OPERATION :- Operation No. 10
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KAIZEN THEME : To Prevent the Rejection & potential Customer Complaint of Rotor Face taper & free rotation jam.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- A337 Oil Pump Body Rejection In Assembly Clearance Checking Stage Due To Body Rotor Face Taper up To 30 microns & Customer Complaint May Happen For Rotation Jam & We Are Presently using Spring Loaded Taper Locating Pin For Component Locating. **Taper Locating Pin**



BEFORE

WHY - WHY ANALYSIS :-
Why1:- A337 Oil Pump Body Rejection In Assembly Clearance Checking Stage
Why 2:- Body Rotor Hole Face Taper Up to 30 Microns.
Why 3:- Improper Resting Of Component.
Why 4:- Spring Loaded Taper Locating Pin.

ROOT CAUSE :- Spring Loaded Taper Locating Pin.

REGISTRATION NO. & DATE: 836 & 25.09.15

REGISTERED BY :- Mr.Shanthakumar

MANAGER'S SIGN :- N.S.Pujari

IDEA :- Component Locating Pin To Be Modify Taper To Straight.

COUNTERMEASURE:- Component Locating Pin Modified & Body Rotor Face Taper Found 6-8 Microns & Now No Issue In Assembly Clearance Checking Stage.

TEAM MEMBERS :-
N.S.Pujari ,Shanthkumar

BENEFITS :-

BENCHMARK	10%
TARGET	0%
KAIZEN START	10.09.15
KAIZEN FINISH	12.09.15

1. Prevent Rejection.
2. Avoid In Customer Complaints.

KAIZEN SUSTENANCE

WHAT TO DO: Irreversible Kaizen
HOW TO DO:-----
FREQUENCY : 1 Time activity

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 1100/-	-----	INR 1100/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO	CELL	TARGET	RESPONSIBILITY	STATUS
1.	-----	-----	-----	-----.

