

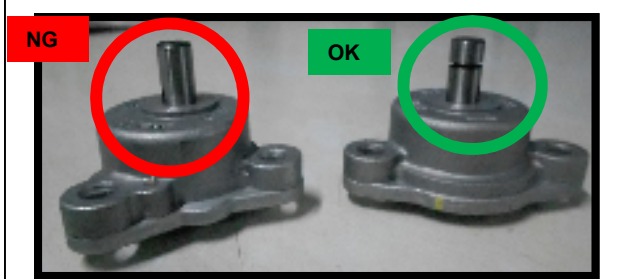
TPM CIRCLE NO :-	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :	LOSS NO. / STEP								
DEPT :- Q.A	RESULT AREA	P	Q	DEF:- B	C	D	S	M	

**CELL :-** A420    **CELL NAME:-** Oil Pump Assy.    **MACHINE / STAGE :-** Oil Pump Assembly Line    **OPERATION :-** Shaft Assembly Stage

**KAIZEN THEME :** To Prevent re-occurrence of wrong position of Shaft assembly in A420 oil pump Assembly

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-** During assembly wrong position of Shaft assembly in A420 Oil Pump.



**BEFORE**

**IDEA :-** Pokayoke

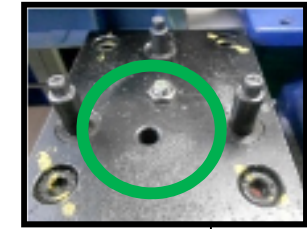
**COUNTERMEASURE:-**

Prevention type Pokayoka provided on assembly stage : Sensor provide at bottom side of Fixture to arrest wrong position shaft assembly.

**Before**

No provision in fixture to arrest wrong position shaft assembly

**After**



**AFTER**

<b>BENCHMARK</b>	42 Nos.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	22.12.2015
<b>KAIZEN FINISH</b>	18.01.2015

**TEAM MEMBERS :-**  
 Parmeshwar Bansode  
 Yuvraj Desai  
**BENEFITS :-**

1. Prevent Re-occurrence of In-house Complaint.
2. Reduce COPQ.

**KAIZEN SUSTENANCE**

**WHAT TO DO:** Check pokayoke.

**HOW TO DO:** Checkpoint added in pokayoke sustenance check sheet.

**FREQUENCY :** Daily Start of Shift

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
900	200	1100

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
	A336	02.01.15	Sandip	Completed

**WHY - WHY ANALYSIS :-**

- Why 1:** Shaft position wrong during assy
- Why 2:** Existing process allow to pass such type of defects
- Why 3:** No provision to arrest wrong position of shaft during assy.
- Why 4:** Poka.

**ROOT CAUSE :-** Poka

**REGISTRATION NO. & DATE:** 22/12/2014

**REGISTERED BY :-** Parmeshwar Bansode

**MANAGER'S SIGN :-** Sunil Kinkar

**RESULT :-**

