

CELL :- A285 **CELL NAME:-** Oil Pump Assly **MACHINE / STAGE :-** Free rotation stage **OPERATION :-** Free rotation

KAIZEN THEME : To reduce the total insp. time.

IDEA :-Modify the process for arresting the inspection dimension.

Problem present status :- Inspection time is more due to gauging.

COUNTERMEASURE:-
1)Dimensions of shaft symmetry, Shaft O/D,5.2 milling width is controlled in free rotation gauge (Cycle time will reduced from 34.7sec. To 27.7 sec.)

BENCHMARK	34.7 sec.
TARGET	27.7 sec.
KAIZEN START	26.03.2016
KAIZEN FINISH	28.04.2016

TEAM MEMBERS : P.Bansode, Nitin sutar
Mohan Kate

BENEFITS :-
1) Output after inspection will be improve from 841 nos to 1040 nos.

KAIZEN SUSTENANCE

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

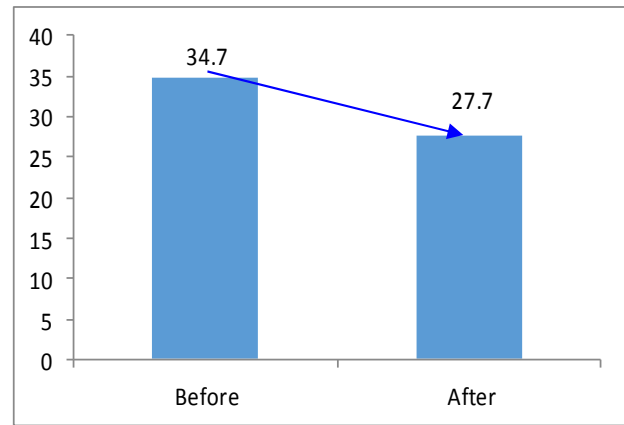
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
01	A373		Nitin Sutar	In process



WHY - WHY ANALYSIS :-
Why1 :-Inspection time is more (Insp. time 34.7 sec)
Why2:-Dimensions are checked 100% at final inspection stage.
Why3 :-Child part dimension are not controlled in assembly process.

RESULT :-



ROOT CAUSE : Child part dimension are not controlled in assembly process.

REGISTRATION NO. & DATE : 26.3.2016

REGISTERED BY :- Mohan kate

MANAGER'S SIGN :- Sunil Kinkar