TPM CIRCLE NO:-01 PM JH SHE OT DM E&T **ACTIVITY** KK QM KAIZEN IDEA SHEET ADVIK P15 **TPM CIRCLE NAME: Oil Pump** LOSS NO. / STEP **DEPT:** - ASSEMBLY SHOP **RESULT AREA** Q Α С D **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 diamension. **BENCHMARK** 34.7 sec. **COUNTERMEASURE:-TARGET** 27.7 sec. 1) Dimensions of shaft symmetry, Shaft O/D,5.2 milling Problem present status:-Inspection time is more **KAIZEN START** 26.03.2016 width is controlled in free rotation gauge (Cycle time due to gauging. **KAIZEN FINISH** 28.04.2016 will reduced from 34.7sec. To 27.7 sec.) **TEAM MEMBERS**: P.Bansode, Nitin sutar **Mohan Kate BENEFITS:-**1) Output after inspection will be improve from 841 nos to 1040 nos. **KAIZEN SUSTENANCE** Before After WHAT TO DO: NA **RESULT:-WHY - WHY ANALYSIS :-HOW TO DO: NA** Why1:-Inspection time is more (Insp. time 34.7) sec) 40 FREQUENCY -NA 34.7 Why2:-Dimensions are checked 100% at final 35 27.7 inspection stage. 30 Why3:-Child part dimension are not controlled in 25 assembly process. 20 **ROOT CAUSE**: Child part dimension are not 15 controlled in assembly process. 10 **REGISTRATION NO. & DATE:** 26.3.2016 5 SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT 0 **REGISTERED BY:** Mohan kate TARGET RESPONSIBILITYSTATUS CELL NO. Before After MANAGER'S SIGN :- Sunil Kinkar 01 A373 Nitin Sutar Inprocess

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