
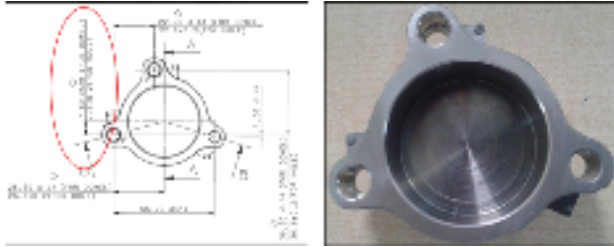
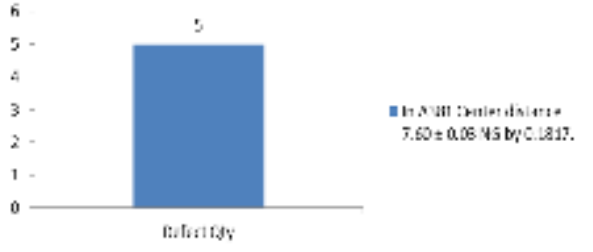


										KAIZEN IDEA SHEET					
TPM CIRCLE NO :-		ACTIVITY		KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN NO:-01			
TPM CIRCLE NAME :-		LOSS NO. / STEP													
DEPT :- M/c Shop QA		RESULT AREA		P	Q	DEF:- A	C		D	S	M				
CELL :-A381	CELL NAME:-Oil Pump Assembly	MACHINE / STAGE :Reaming					OPERATION :-Reaming								
KAIZEN THEME To prevent occurrence of Incorrect center distance in A381 Body m/cing				IDEA :- Grub screw locking slot length to be increase											
WIDELY/DEEPLY:-				COUNTERMEASURE:- <ol style="list-style-type: none"> 1.Grub screw locking slot length increase. 2. 100% inspection for rotor bore depth on clearance machine. 3. CMM Done after grub screw locking slot length increase & found ok. 				BENCHMARK 05 No.		TARGET 0 No.		KAIZEN START 26.07.2014		KAIZEN FINISH 30.07.2014	
PROBLEM / PRESENT STATUS :- Center distance 7.60 ± 0.03 NG by 0.1817.								TEAM MEMBERS :- Sachin Sonawane, Sunil Kinkar							
								BENEFITS :- <ol style="list-style-type: none"> 1)No production loss 2) No Supplier Rejection 3)No customer complaint 							
WHY - WHY ANALYSIS :- Why 1: Center distance 7.60 ± 0.03 NG by 0.1817. Why 2: Job not locating properly Why 3 –Spring loaded locating pin in fixture remain unreleased than required stroke Why 4 –Grub screw locking slot length less in fixture				RESULT :- <p style="text-align: center;">In A381 Center distance 7.60 ± 0.03 NG by 0.1817.</p> 											
ROOT CAUSE:- Grub screw locking slot length less in fixture				WHAT TO DO :- Check point Added In Supplier action plan sustenance sheet & change process flow diagram HOW TO DO : Verify the action plan - FREQUENCY – As Per supplier Audit plan.											
REGISTRATION NO &DATE::26.07.2014				COST INCURRED FOR MAKING KAIZEN											
REGISTERED BY :-Sachin Sonawane				MATERIAL COST IN RS		LABOUR COST IN RS		TOTAL COST IN RS							
MANAGER'S SIGN :- Sunil Kinkar				-----		-----		-----							
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT															
Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS											
1	-----	-----	-----	-----											