TPM CIRCLE NO:-2 KK PM SHE OT E&T **ACTIVITY** QM JH DM KAIZEN IDEA SHEET ADVIK P14 **TPM CIRCLE NAME: Joshile** LOSS NO. / STEP **DEPT**:- Manufacturing Engg. **RESULT AREA** P Q C D S DEF :- A **CELL NAME:- Oil Pump Line** MACHINE / STAGE :- VMC (Brother) / Machining **OPERATION**:- Operation No. 10 **CELL:-A337 KAIZEN THEME:** To Prevent the Rejection & **IDEA:** Component Locating Pin To Be Modify Taper To Straight. potential Customer Complaint of Rotor Face **BENCHMARK** 10% taper & free rotation jam. **COUNTERMEASURE**:- Component Locating Pin **TARGET** 0% Modified & Body Rotor Face Taper Found 6-8 WIDELY/DEEPLY:-**KAIZEN START** 10.09.15 Microns & Now No Issue In Assembly Clearance **KAIZEN FINISH** 12.09.15 PROBLEM / PRESENT STATUS :- A337 Oil Pump Checking Stage. **Body Rejection In Assembly Clearance Checking TEAM MEMBERS:-**Stage Due To Body Rotor Face Taper up To 30 N.S.Pujari ,Shanthkumar microns & Customer Complaint May Happen For **BENEFITS:-**Rotation Jam & We Are Presently using Spring **Loaded Taper Locating Pin For Component** 1. Prevent Rejection. Straight Locating Pin Locating. Taper Locating Pin 2. Avoid In Customer Complaints. **KAIZEN SUSTENANCE** WHAT TO DO: Irreversible Kaizen **BEFORE AFTER** HOW TO DO:-----**RESULT:-**WHY - WHY ANALYSIS :-**Rejection Detail In % FREQUENCY: 1 Time activity** Why1:- A337 Oil Pump Body Rejection In **Assembly Clearance Checking Stage** 20% Why 2:- Body Rotor Hole Face Taper Up to 30 10% 10% Microns. 0% Why 3:- Improper Resting Of Component. 0% Why 4:- Spring Loaded Taper Locating Pin. **COST INCURRED FOR MAKING KAIZEN Before After** MATERIAL COST | LABOUR COST **TOTAL COST ROOT CAUSE: - Spring Loaded Taper Locating** IN RS IN RS **IN RS** Pin. INR 1100/-INR 1100/-**Improvement** By Luck No **SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT** Done Customer Customer **REGISTRATION NO. & DATE: 836 & 25.09.15** SR. **Complaints** TARGET | RESPONSIBILITY | STATUS CELL

REGISTERED BY:- Mr. Shanthakumar

MANAGER'S SIGN :- N.S.Pujari

Complaints 0

NO.

1.