TPM CIRCLE NO :-		ACTIVITY	KK	QM	PM JH	I SHE	OT	DM	E&T					
ADVIK P14 TPM CIRCLE NO TPM CIRCLE NAME :		LOSS NO. / STEP		0			D			Kaizi	en iu	EA SHE	<u>'EI</u>	
CELL :-A177 CELL NAME:- A177 Assy.	MAC	RESULT AREA P Q DEF : MACHINE / STAGE :- A177 Assembly Line						ERATION :- Self Screw Stage						
KAIZEN THEME : To Prevent the defect probability of self tapping screw damage in	IDEA :- Robust design										•			
A177 oil pump body assy.	COUNTERMEASURE:- Core pin design modified from 3.6+0.1 to 3.5+0.1 to increased the interference and Avoid the probability of self tapping damage. And update drg also.							BENCHMARK0 No.TARGET0 No.						
WIDELY/DEEPLY:-								KAIZEN START 22.07.14						
PROBLEM / PRESENT STATUS :- probability of self tapping screw damage in A177 oil pump body								KAIZEN FINISH 22.07.14						
assy.								TEAM MEMBERS :- Raja-R&D						
								Data Pandrey						
								BENEFITS :-						
							X.	1. Avoid the customer complaint						
							KAIZEN SUSTENANCE							
BEFORE	AFTER							WHAT TO DO: Update the drg HOW TO DO: -To check every batch						
WHY - WHY ANALYSIS :-	RESULT :-							REQUENCY : Every core pin						
Why 1 : Probability of self tapping screw								changing time						
damage in A177 oil pump body screw									5 5					
tightening stage.														
Why 2 : Less interference between screw &														
tapping hole. Why 3 : Weak Design	robability of	ility of No Probability of												
Wily 5. Weak Design	Self Tapping Damage Self Tapping Damage							COST INCURRED FOR MAKING KAIZEN						
ROOT CAUSE :- Weak Design							M	MATERIAL COST LABOUR COST TOTAL COST IN RS IN RS IN RS						
		Before After						SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT						
REGISTRATION NO. & DATE : 115 & 22.07.14								SR. CELL TARGET RESPONSIBILITY STAT					ATUS	
REGISTERED BY :-Guru								Δ3	374	22 07 14	Naucos	Co	omp	
MANAGER'S SIGN :- Narayanan									815 (23.07.14	Naray	anan i	eted	