

CELL :- A177 **CELL NAME:-Oil pump assy.** **MACHINE / STAGE:- Free Rotation** **OPERATION :- 30**

KAIZEN THEME :- To prevent the defect Probability of A177 Oil pump Assy fitment problem at customer end.

IDEA :-Single plate Assy .

WIDELY/DEEPLY:-

COUNTERMEASURE:- Decreases the Air nozzle height by 2.0mm from exiting height 54 mm at free Rotation Process

PROBLEM / PRESENT STATUS :-Probability of A177 Oil pump 2 Plate Assy at plate Assy station.

BENCHMARK	00 No.
TARGET	0 No.
KAIZEN START	26.06.15
KAIZEN FINISH	27.06.15



TEAM MEMBERS :-

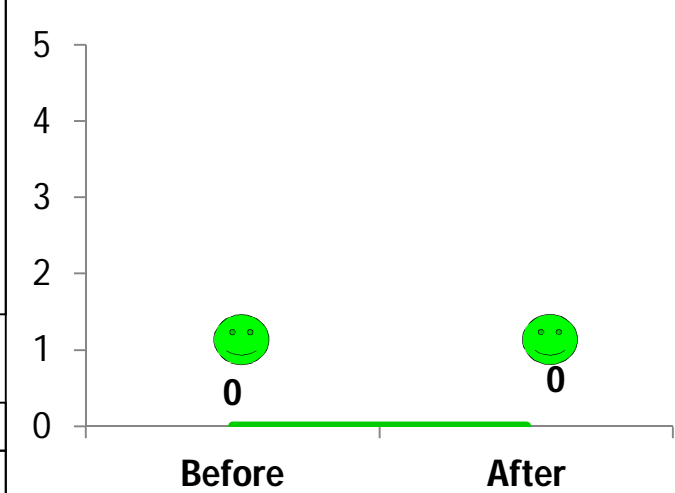
Mr. Pramod , Mr Sharath
Mr.Dsharath

BENEFITS :-

- 1) Prevent the in-house rejection as well PPM.
- 2) Prevent the customer complaints.

WHY - WHY ANALYSIS :-
Why 1 - Probability of A177 Oil pump Assy fitment problem at customer end.
Why 2 - A177 Oil Pump Assy not fitted in crank case at engine Assy .
Why 3 - Oil Pump Assy Height more .
Why 4 - Wrong Assy (2 plate Assy).

RESULT :-



KAIZEN SUSTENANCE

WHAT TO DO : Added in Poka-Yoke sheet . Master samples (NG & OK) provided in line & daily cross check.

HOW TO DO : Cross check with Master Samples.

FREQUENCY : - Shift starting.

ROOT CAUSE :-Wrong Assy(2 plate Assy).

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
00	00	00

REGISTRATION NO. & DATE: 726 & 27.06.2015

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Guru

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A374	25.07.15	Sharath	Open

MANAGER'S SIGN :- Mr. Vijay Kumar