

CELL :- A335 **CELL NAME:-** Oil Pump Assly **MACHINE / STAGE :-** Circlip Fitment **OPERATION :-** Pressing

KAIZEN THEME : To reduce rework due to gear shaft O/D oversize.

IDEA :- Provide Pokayoke.

Problem present status :- Circlip damage during dismantling due to Shaft OD O/S component found in final inspection.

COUNTERMEASURE:-
 1) Diameter of Circlip pressing tool should be change as similar to shaft dia. (6.00-0.004/-0.019)
 2) Inner Dia. of Circlip pressing tool.(6.58mm) to be modified (5.996)

BENCHMARK	61 no's
TARGET	0 no
KAIZEN START	27.03.2016
KAIZEN FINISH	21.04.2015

TEAM MEMBERS : Amit Dhage.Mohan Kate
Nitin sutar

- BENEFITS :-**
- 1) Avoid may happen customer complaint.
 - 2) In-house rework & rejection elimination.

KAIZEN SUSTENANCE

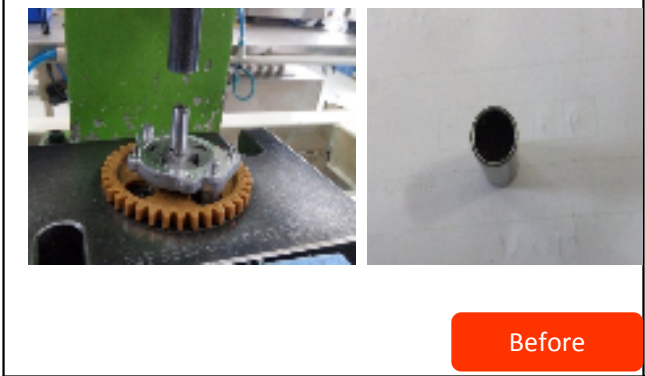
WHAT TO DO: Point is added in daily check sheet

HOW TO DO: Inspection

FREQUENCY –Daily

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
01	A238, A415	25.04 .2016	Nitin Sutar	Inprocess



RESULT :-

In Process

WHY - WHY ANALYSIS :-

Why1 :- Circlip damage during dismantling .
why2:- Assembly rework for gear shaft OD o/s
Why3 :- No arresting mechanism for shaft O/D in assembly process .
Why4 :-No Poka

ROOT CAUSE :No poka

REGISTRATION NO. & DATE : 27.03.2016

REGISTERED BY :- Mohan kate

MANAGER'S SIGN :- Sunil Kinkar