

**CELL :-** A239      **CELL NAME:-** Oil Pump Assly      **MACHINE / STAGE :-** Flow testing machine      **OPERATION :-** Flow testing.

**KAIZEN THEME :** To eliminate the rejection of body O/D oversize at final insp.stage.

**Problem present status :-** Body OD Dia. 60.0-0.015/-0.045 found O/S at final inspection stage.



**IDEA :-** Fixture modification.

**COUNTERMEASURE:-**  
At flow testing stage body resting fixture ID to be maintained 59.990 as per outside dia. Of component.

<b>BENCHMARK</b>	47 no's
<b>TARGET</b>	0 no
<b>KAIZEN START</b>	22.03.2016
<b>KAIZEN FINISH</b>	29.04.2016

**TEAM MEMBERS :** Dhage Amit, Nitin Sutar, Mohan Kate.

**BENEFITS :-**

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

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

**Why1 :-** Body O/D oversize found at final insp. stage

**why2:-** .No arresting mechanism in process

**Why3 :-** .Body resting I/D of fixture is not as per the component OD.

**Why4 :-** Fixture design is weak.

**RESULT :-**

**WHAT TO DO:** Point added in fixture validation sheet.

**HOW TO DO:** By validation

**FREQUENCY –**Once/Day

**ROOT CAUSE :** Fixture design is weak.

Under Process

**REGISTRATION NO. & DATE :** 22.3.2016

**REGISTERED BY :-** Mohan kate

**MANAGER'S SIGN :-** Sunil Kinkar

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
01	A240		Nitin Sutar	Inproce ss.