													_			
AD▼IK		TPM CIRCLE NO :-	1	ACTIVITY	КК	QM	PM	JH	SHE	OTP M	DM	E&T		FALIDEA		
		TPM CIRCLE NAME :		LOSS NO./STEP								KAIZEN IDEA SHEET				
Plant : P14		DEPT :	Production	RESULT AREA	c	Q	Р	P, C	S	M, D	P, C	М				
CELL:	A657	CELL NAME: OIL PUMP BODY M/C STAGE: BROTHE				THER-	7		Facing, OPERATION: Reaming drilling			ing				
	KAIZEN THEME :		KAIZEN IDEA :													
Rejection percentage reduction on A657		Reamer design has to remodify and the same should be updated in								BENCHMARK: 3.00 %						
line		process control plan							TARGET:				).07%			
									KAIZEN START:				20.11.18			
PRO	BLEM PRESENT STATUS :	COUNTERMEASURE:							TARGET DATE:			29	29.11.18			
Dowel pin h	nole load NG due to Dia 2.97	Reamer design changed in diameter from 2.97 to 2.964 and drill							KAIZEN FINISH: 29.11.18							
mm NOGO		changed from 2.5 to 2.7							TEAM MEMBERS:							
	-								Mr.Manas				Mr.Satish			
									BENEFITS:-							
										Rejections percentage is reduced						
١	WHY-WHY ANALYSIS:	BEFORE AFTER							KAIZEN SUSTAINANCE							
Why1:- Dowel pin load NG during									WHAT TO DO:							
assembly		Rej (Nos)  150 20 87 21 33 77 99 61 59							HOW TO DO:							
	vel pin hole diameter 2.97mm								FREQUENCY:							
Plug gauge	NOGO answering								SCOPE & PLAN FOR HORIZONTAL							
M/bu/21 Dia	2.07 Beamer used for devial							_	DEPLOYMENT							
hole Reami	2.97 Reamer used for doweling	The stand of the s				,	SR. NO	CELL/		rDC	RESP.	STATUS				
ROOT CAUSE		RESULTS:					1 At	==7	20	12.18	Drad	Pending				
Plug gauge NOGO size is 2.97mm and		NESOEIS.							I A	337	DU.	12.16	riou	Penung		
Dia 2.97mm reamer used for dowel		Rejection (Load NG) percentage is reduced from, 3.0% to 0.07							$\vdash$					$\vdash$		
reaming		• • • • • • • • • • • • • • • • • • •						HD SCOPE INFORMATION IN OTHER								
	DA A NUVIDO DA CAS	AVERAGE							PLANT							
	N NO.: P14/KK/2018/45	3.0				SR.NO	. PLA	NT W	HEN !	MOHW	STATUS					
DATE:	05-12-2018 D.BV: Mr. Omorakash			0.07												
REGISTERE			Before							+	+					
MANAGER	SIGN: Mr. Manas Kumar Dey		poluit	. Prival							+			-		
AHPL/QMS/F	R/09/E, Rev. No.:03, Rev. Date:23.	01.2018														