

TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Innovation	LOSS NO. / STEP								
DEPT :- Q.A	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :-A374 CELL NAME:- Oil Pump Assembly MACHINE / STAGE :- A374 Oil Pump Assembly Line OPERATION :- Free Rotation Stage

KAIZEN THEME : To Prevent re-occurrence of Customer Complaint of Washer Miss in A374 Oil Pump Assy.

IDEA :- Poka Yoke

WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided Interfacing in-between Washer Pick up and Free Rotation Testing, Free Rotation Testing M/c. will not start until Washer not pick up for Assembly.

BENCHMARK	1 No.
TARGET	0 No.
KAIZEN START	22.11.2013
KAIZEN FINISH	30.12.2013

PROBLEM / PRESENT STATUS :- 1 No. A374 Oil Pump Assembly reported at customer end with Washer Miss on 22.11.13

TEAM MEMBERS :-
Sivashankar
Narayanan
BENEFITS :-



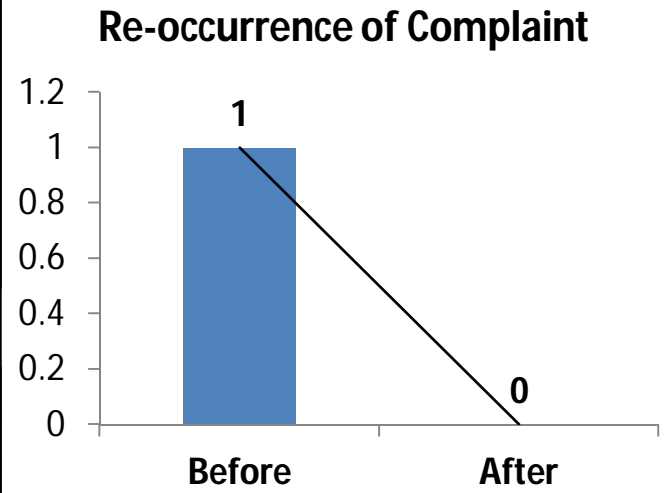
BEFORE

AFTER

- 1. Prevent Re-occurrence of Customer Complaint.
- 2. Reduce COPO.

WHY - WHY ANALYSIS :-
Why1: Washer Miss in A374 Oil Pump Assy.
Why 2: Washer assembly process skip by Assembly Operator.
Why1: Poka

RESULT :-



KAIZEN SUSTENANCE

WHAT TO DO: Add Checkpoint in Poka Yoke Monitoring Sheet. & JH Check-Sheet.
HOW TO DO: -----
FREQUENCY : Daily Start of Shift

ROOT CAUSE :- Poka

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 950/-	-----	INR 950/-

REGISTRATION NO. & DATE: 03 & 20.01.14
REGISTERED BY :- Guru Basappa
MANAGER'S SIGN :- Narayanan

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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