

C12, PUMP GP-WATER-Gp, PUMP GP-WATER -B, LEAKS WATER, (0R0705)

(Status Updated: 14Oct2021)

CPI Number: 494478
Status: Open , Active
6 Sigma Phase: Improve
Commercial Impact:
Initial Project Activation Date: 26Jul2021
Target Completion Date: 31Dec2021

Models:

(C10), (C12), (D7R II), (R1600G),

Symptom/Description:

Early hour failures on Reman Water Pumps for Loose/Spinning Impellers.

| CPI 494478 DAY 1 DEFECTS WATER PUMP LOOSE IMPELLERS | | | | | | | Team Leader: Constantino Espinoza Sponsor: Michael Boston | |
|---|---------------|-----------------|--------------------|--------------|--------------|--------------|--|--|
| | Launch | Define | Measure | Analyze | Improve | Control | Close | |
| Target | July 26, 2021 | August 09, 2021 | September 06, 2021 | Oct 06, 2021 | Nov 19, 2021 | Dec 19, 2021 | Dec 31, 2021 | |
| Completed | | Aug 09, 2021 | September 06, 2021 | Oct 14, 2021 | | | | |

Problem Statement...Business/Customer Impact:
 Early hour failures on Reman Water Pumps for Loose/Spinning Impellers. 0R0705
 Models affected: C10, C12, D7R II, R1600G

Root Causes:

- Oversized ID impeller after knurling process.
- CX tooling incorrect NO GO diameter
- Digiforce operating in manual mode

Broken Process TBD

ICA:

- Stop to fix. Use reman impeller with only one dot/mark.
- Hold Quality Stand Down with assy and impeller reclaim area.
- Sort inventory and check for previous knurling dot/mark.

Recent Activities:

- Stop to fix – PLC digiforce press operation
- Cost analysis reman vs new impeller

Next Steps:

- Inspect used impeller inventory – C.E
- Update Order Qty to 100% - Jamie K
- Update DWG to eliminate knurl operation – Derek W

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Part Number:

0R-0705 (PUMP GP-WATER -B) 10R-6223 (PUMP GP-WATER -B)

Dealer Status:

Checked the digiforce calibration, has been completed. Checked press impeller operation. Set to 100% new impeller, PLC digiforce evaluation

No Interim Repair Available

Root Cause:

- 1: Knurling process out of control, oversized bore impeller.
- 2: Incorrect gauge selection for upper limit.
- 3: Impeller press operation was working in manual mode instead of automatic, bypassing the digiforce.

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