

TPM CIRCLE NO :- 04	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME: GEAR SHIFTER	LOSS NO. / STEP								
DEPT :- ASSEMBLY SHOP	RESULT AREA	P	Q	A		C	D	S	M

CELL :- A338	CELL NAME:- Gear shifter	MACHINE / STAGE :- ASSEMBLY	OPERATION :- Riveting
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KAIZEN THEME : To eliminate in-house rejection

IDEA :- Pokayoke

WIDELY/DEEPLY:-

COUNTERMEASURE:- Gide Pin to be provided on fixture (pokayoke pin to avoid the tilting of bracket & wrong locating of bracket.)

PROBLEM / PRESENT STATUS :- A 338 bracket damage at the time of riveting operation



BENCHMARK	9
TARGET	0
KAIZEN START	04.02.2015
KAIZEN FINISH	20.02.2015

TEAM MEMBERS :- Shushma. G ,chandhrakant , Gufran

BENEFITS :-

1.Reduce in house Rejection

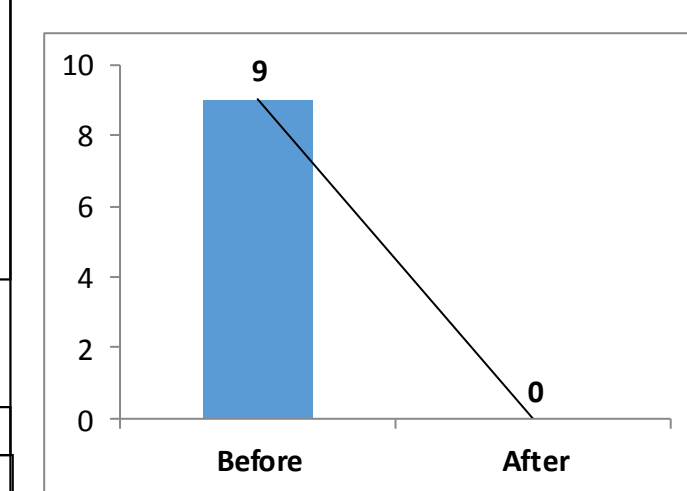
KAIZEN SUSTENANCE

WHAT TO DO: Pokayoke point added in pokayoke sustenance check sheet.
HOW TO DO: Verification by locating bracket on fixture.
FREQUENCY : Daily start of the shift.

WHY - WHY ANALYSIS :- :-

Why1: A 338 bracket damage
Why2: bracket locating not properly on fixture
Why3: no provision on fixture to lock the bracket.
Why4: No pokayoke.

RESULT :-



ROOT CAUSE :- No pokayoke

MATERIAL COST	LABOUR COST	TOTAL COST
IN RS	IN RS	IN RS
500	-----	500

REGISTRATION NO. & DATE: 4.02.2015
REGISTERED BY :- Sushma
MANAGER'S SIGN :- Sunil Kinkar

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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