

CELL :- A 247 BKT	CELL NAME:- BKT	MACHINE / STAGE :- Drilling	OPERATION : Drilling
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**KAIZEN THEME –To avoid** A247 Bracket 8.1 Hole Oversize Spec 8.1±0.2 & actual 8.35mm ( No Go PPG Qualify )

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS -A247**  
Bracket 8.1 Hole Oversize Spec 8.1±0.2 & actual 8.35mm ( No Go PPG Qualify



Difficult to tightening, During regular production ( operator fatigue )

**IDEA :-** Pokayoke to be implemented ( Toggle clamping to be provide ).

**COUNTERMEASURE:-** 1) Toggle clamping clamping to be provide. 2) 100 % checking started for 8.1 Inside dia .



Toggle Clamping to be provided to avoid operator mistake

<b>BENCHMARK</b>	45 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	21.11.2014
<b>TARGET DATE</b>	18.12.2014
<b>KAIZEN FINISH</b>	

**TEAM MEMBERS :-**  
Ganesh Padwalkar ,vijay walunj,sutar  
Nana Ugle

- BENEFITS :-**
1. Prevent Re-occurrence of Customer Complaint.
  2. Reduce COPQ.

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

**Why 1** – A247 Bracket 8.1 Hole Oversize. (Spec 8.1 0± 0.2 ,Actual 8.35).

**Why 2** – Part vibrate during Drilling operation .

**Why 3** – Part not clamp properly by operator .

**Why 4** – During clamping in regular process operator hands touch to fixture edge ( Operator fatigue )

**ROOT CAUSE-** – During clamping in regular process operator hands touch to fixture edge ( Operator fatigue )

**REGISTRATION NO. & DATE:- 21.11.2014**

**REGISTERED BY :- Ganesh Padwalkar**

**MANAGER’S SIGN :- Sunil kinkar**

**RESULT :-**

Currently not using Drilling machine for BKT .

**WHAT TO DO :-** NA  
**HOW TO DO:-** NA  
**FREQUENCY :-** NA

COST INCURRED FOR MAKING KAIZEN		
<b>MATERIAL COST IN RS</b>	<b>LABOUR COST IN RS</b>	<b>TOTAL COST IN RS</b>
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
---	Not Applicable .			