

CELL :-A247      CELL NAME:- CBS Assy.      MACHINE / STAGE :- A247 Assembly Line      OPERATION :- Grouping Stage

**KAIZEN THEME :** To Prevent defect probability of Spring fitment miss in A247 CBS Assembly.

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-** Probability of Spring- miss in A247 CBS Assembly Line at Grouping Stage.

**IDEA :-** Poka Yoke

**COUNTERMEASURE:-** Provided interfacing in-between Spring pick up and Next stage ( ) Pneumatic Gun start up cycle, to prevent Poka.



BEFORE

AFTER

<b>BENCHMARK</b>	0 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	10.05.2014
<b>KAIZEN FINISH</b>	12.05.2014

**TEAM MEMBERS :-**  
 Dinesh Kumar  
 Pawan Kumar  
**BENEFITS :-**

1. Prevent Potential Customer Complaint.
2. Process Enhancement.

**KAIZEN SUSTENANCE**

**WHAT TO DO:** Validation of Interfacing activity.  
**HOW TO DO:** Visual Inspection .  
**FREQUENCY :** Daily start of Shift.

**WHY - WHY ANALYSIS :-**  
**Why1:** Probability of Spring Fitment Miss.  
**Ans.1:** Poka

**RESULT :-**

**ROOT CAUSE :-** Poka

Probability of Spring Miss      No Probability of Spring Miss

COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
3500/-	-----	3500/-

**REGISTRATION NO. & DATE:** 25.05.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** A.Shaivashankar



SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	2 <sup>nd</sup> Cell	30.05.14	Shankar	Comp.