

CELL :-A247 CELL NAME:- CBS Assy. MACHINE / STAGE :- A247 Assembly Line OPERATION :- M5 Screw Tightening

KAIZEN THEME : To Prevent defect probability of Continuity Test miss in A247 CBS Assembly.

IDEA :- Poka Yoke

WIDELY/DEEPLY:-

COUNTERMEASURE:- Provided auto punch mark at M5 Screw Tightening stage to conform evidence mark of inspection on Bracket.

PROBLEM / PRESENT STATUS :- Probability of continuity Test – miss in A247 CBS Assembly Line at M5 Screw Tightening Stage.

No Auto Punch Mark for conformation of Inspection Activity



Auto Punch Mark for conformation of Inspection Activity

BENCHMARK	0 No.
TARGET	0 No.
KAIZEN START	01.05.2014
KAIZEN FINISH	24.05.2014

TEAM MEMBERS :-
 Dinesh Kumar
 Ratna Kumar

BENEFITS :-

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

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why1: Probability of Continuity Test Miss.
Ans.1: Poka

RESULT :-

Probability of Inspection Miss No Probability of Inspection Miss

WHAT TO DO: Monitoring of Auto Punch Mark quality on Bracket.
HOW TO DO: Visual Inspection w.r.t Master Sample.
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
24000/-	-----	24000/-

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 nd Cell	25.06.14	Shankar	In-Process

