

TPM CIRCLE NO :-02	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME :-Innovation	LOSS NO. / STEP								
DEPT :-QA	RESULT AREA	P	Q	DEF :- A	C		D	S	M

CELL :- . CELL NAME:- All model MACHINE / STAGE:- Spark m/c. OPERATION:- 5 hole drill operation.

**KAIZEN THEME :-** To Reduce the Possibility of In-house Rejection & Stoppage of By-Pass Operation.

**IDEA :-** Strong Design.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE :-** Provided a key-lock system is at the Poke-Yoke. So that it cannot be operated by mistake.

<b>BENCHMARK</b>	03 Nos
<b>TARGET</b>	Zero
<b>KAIZEN START</b>	02.9.16
<b>KAIZEN FINISH</b>	12.9.16

**PROBLEM / PRESENT STATUS:-**

Air Pressure Poka-yoke provided at the spark m/c for the stoppage of wrong Butting of component on the locating pin can be manually operated( By-Pass).

**TEAM MEMBERS :-**

Sandeep Parihar

**BENIFITS :-**

- 1) In-house Rejection reduce.
- 2) Poke- yoke 100% self inspection
- 3) Operator moral increase.



**BEFORE**

**AFTER**

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

**WHY 1:-** 5-hole Dia O/S , Depth O/S Rejection found .

**WHY 2:-** Wrong Component butting on the locating pin.

**WHY 3:-** Poka-yoke is provided but wrong observation gained by the Operator.

**WHY 4:-** Poka-yoke can be manually operated.

**RESULT :-**

1. Reduce In-House Rejection.
2. Poke-yoke inside Poke-yoke(Mistake proofing)
3. Poke- yoke 100% self inspection.

**WHAT TO DO :-** Provide key lock system

**HOW TO DO :-**Check points add in Sustenance check sheet

**FREQUENCY :-** Daily

**ROOT CAUSE :-** Poke-Yoke can be manually operated.

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.
3500	1200	4700

**REGISTRATION NO&DATE:**

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

**REGISTERED BY :-**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
2	A422	15.07.14	Mnt/Prod.	In process

**MANAGER'S SIGN :-**