



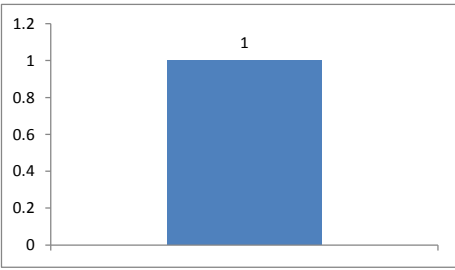


ADVIK	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	KAIZEN IDEA SHEET				
	TPM Circle Name:	Loss no.										Kaizen No.: 03			
	Dept: ASSY.	Result Area	P	Q-Def. A / B /C			C	D	S	M					
Cell No.: A294 Gear shifter assy.		Process / Stage : Assly							Operation : Rivetting.						
Kaizen Theme : To eliminate rejection of improper rivetting.		Idea : To avoid customer complaints													
		Counter Measure : Fixture guide pin height increased.					Bench Mark								
Problem / Present Status: 1.Rivetting dimension 0.50 mm not ok found. 2. Firm rivetting not found.		Before : 1.Guide pin height not adequate to hold bracket  					Target		0						
							Kaizen Start		2-Apr-14						
							Kaizen Finish		22-Apr-14						
							Team Members With Sign : 1.Sandeep Jadhav 2.Samadhan Visave								
Why Why Analysis : 1. Gear shifter assy. bracket rivet missing 2.Bracket riveting improper/loose 3.During rivetting bracket tilt & fall down below 4.Fixture guide pin height less. 5.Weak fixture design.		After : 1.Preventive type pokayoke implemented: Existing fixture pin height increased by 4 mm to avoid tilting of bracket . 2.Pin height checking started on weekly basis 3.FGCP revised frequency from 1pc/hr to 100 % visual checking . 4. After rivetting height 0.50 mm SPC study conducted . 5.Bracket resting fixture two guide pin to be provide to eliminate tilting issue .  					Benefits								
Root Cause : Weak fixture design.		Result : Customer complaint for rivet missing chances eliminated. 					P								
							Q								
							C								
Registration no.& dt : Submitted by : Sandeep Jadhav Manager's Sign :							D								
							S								
							M								
							Kaizen Sustenance :								
							What to do : Guide pin height checking on monthly once.								
							How to do : FGCP checkpoint added for rivetting vi								
							Scope & Plan for Horizontal Deployment								
							Sr no	Model	Target Dt	Responsibility	Status				
							1	A338	22.04.2014	Samadhan	Completed.				