

CELL :-A351      CELL NAME:- A351 machining      MACHINE / STAGE :- A351 1st VMC (Dart Plus)      OPERATION :- Op. 50Stage

**KAIZEN THEME :** To Prevent defect of Drum Change damage at Soft Cell

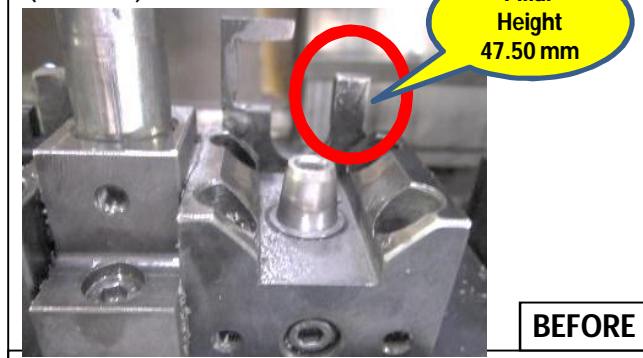
**IDEA :-** Robust poke yoke Design

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Changed the existing Poka Yoke Plate design by increasing its side pillar height from 47.50 mm to 62.00mm (Increased height 14.50 mm), so that component could not clamp at wrong position

<b>BENCHMARK</b>	06 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	16.08.14
<b>KAIZEN FINISH</b>	21.08.14

**PROBLEM / PRESENT STATUS :-** 6 Nos. A351Drum Change damaged at Soft Cell. (1<sup>st</sup> VMC).

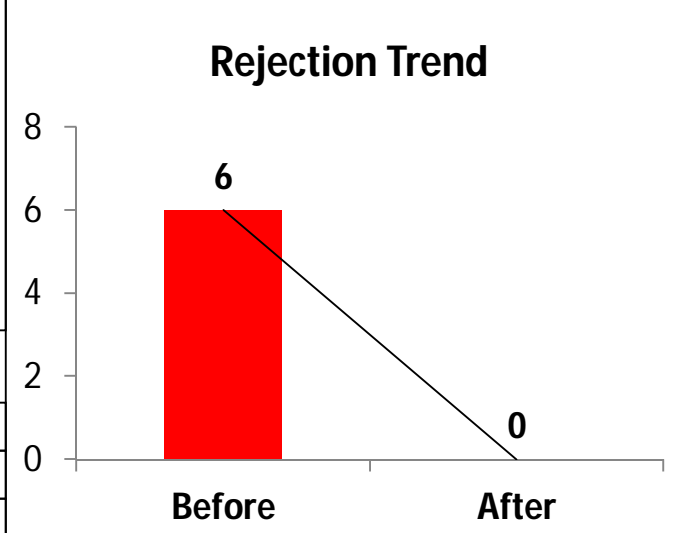


**TEAM MEMBERS :-**  
 Dasrath Kumar  
 Sharad Kumar

**BENEFITS :-**  
 1. Avoid in house and customer complaint

**WHY - WHY ANALYSIS :-**  
**Why 1 :** 6 Nos. A351Drum Change damaged at Soft Cell (1<sup>st</sup> VMC).  
**Why 2 :** Damage because of Center Drill offset.  
**Why 3 :** Component clamped at wrong position.  
**Why 4 :** Component can be clamp at wrong position.  
**Why 5 :** Weak Poka Yoke Design

**RESULT :-**



**KAIZEN SUSTENANCE**

**WHAT TO DO:** 1. Changed the Fixture Drawing.  
 2. Revise Checkpoint in Poka-Yoke Check-Sheet.  
**HOW TO DO:** -Drawing Modification & Poka Yoke Check Sheet modification.  
**FREQUENCY :** 1 Time activity

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
100	150	250

**ROOT CAUSE :-** Weak poke yoke Design

**REGISTRATION NO. & DATE :** 179 & 21.08.14

**REGISTERED BY :-** Guru

**MANAGER'S SIGN :-** Narayanan

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	2 <sup>ND</sup> VMC	21.08.14	Ravi	Completed