

CELL :- A491	CELL NAME:- Auto Fuel Cock	MACHINE / STAGE :- Toggle Press /Assy.	OPERATION :- Operation No. 10
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KAIZEN THEME : To Prevent the may happen in house rejection of A491 AFC in cover blockage testing at assy. cell.

WIDELY/DEEPLY:-

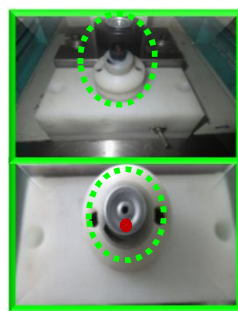
PROBLEM / PRESENT STATUS :- May happen in house rejection in cover blockage testing due to retainer hole $\varnothing 0.25 \pm 0.05$ presence & blockage inspection method it is not effective .



BEFORE

IDEA :- Visual Inspection method to be effective.

COUNTERMEASURE:- To change the visual inspection method by providing light blowing system for retainer inspection at retainer pressing station , If hole miss & blockage is there in retainer light will not pass from retainer hole.



AFTER

BENCHMARK	05 nos
TARGET	Zero
KAIZEN START	01.04.2016
KAIZEN FINISH	25.04.2016

TEAM MEMBERS :-
N.S.Pujari
Mr. Shanthkumar

BENEFITS :-

- 1.Prevent may happen In-house rejection.
2. Improved Inspection method.
2. Reduced Operator Fatigue.

KAIZEN SUSTENANCE

WHAT TO DO: Light working condition to be check .
HOW TO DO: Visual
FREQUENCY : Daily

WHY - WHY ANALYSIS :-
Why1: May Happen In house rejection at cover blockage testing.
Why2 : Retainer hole $\varnothing 0.25 \pm 0.05$ hole miss & Blockage.
Why 3:- Visual Inspection method was not effective.

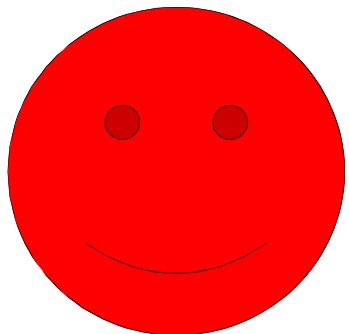
ROOT CAUSE :- Visual Inspection method was not effective.

REGISTRATION NO. & DATE: #1119, 30.04.16

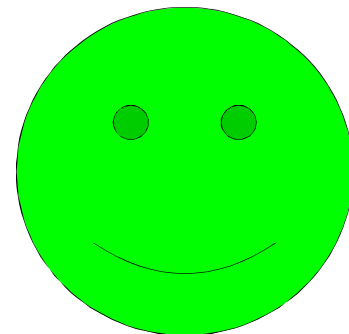
REGISTERED BY :- N.S.Pujari

MANAGER'S SIGN :- N.S.Pujari

RESULT :-



By luck no in house rejection



Improvement Done in house rejection 0 by action

COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
2350/-	400/-	2750/-

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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