

CELL :- A431 **CELL NAME:- CBS** **MACHINE / STAGE:-Welding stage** **OPERATION :- 20**

KAIZEN THEME : To Prevent the customer complaint : 2LP Decomp assy functional problem at Engine assy @ Yamaha

IDEA :- Height master provided (28.50mm)

WIDELY/DEEPLY:-

Countermeasure :-
To provided Height Master for riveting process during setting .(TDC – 18.11.2015)

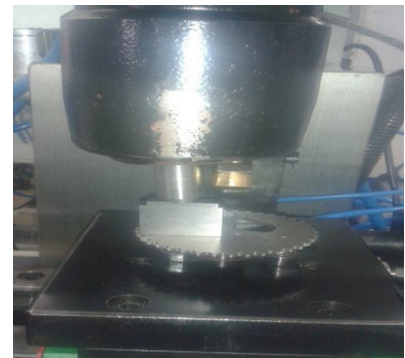
BENCHMARK	12No.
TARGET	0 No.
KAIZEN START	19.10.15
KAIZEN FINISH	

PROBLEM / PRESENT STATUS :-
To Prevent the customer complaint : 2LP Decomp assy functional problem at Engine assy @ Yamaha

TEAM MEMBERS :-
Mr.Mahesh V.N



BEFORE



AFTER

BENEFITS :-

- 1) Prevent the customer complaints
- 2) Prevent the customer return.
- 3) Prevent the supplier rejection & Reduce the PPM

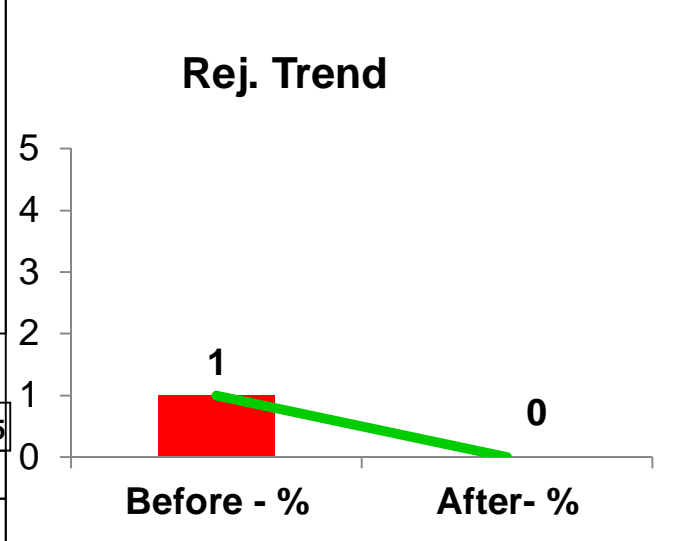
KAIZEN SUSTENANCE

WHAT TO DO : WI Updated
HOW TO DO : During setting time check with master .
FREQUENCY :- Once in shift .

WHY - WHY ANALYSIS :-

- Why 1** - 2LP Decomp Assy functional problem at Engine Assy @ Yamaha
- Why 2** - Decomp assembly fly-weight movement hard
- Why 3** - Less clearance in between sprocket & flyweight
- Why 4** - Rivet height observed less as against spec. (1± 0.2)
- Why 5** - Excess load applied on shaft1 during riveting process
- Why 6** - Height adjusted on trial & error basis during tool setting
- Why 7** - No height master provided (28.50mm)

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
1000	0	1000

SCOPE & PLAN FOR SELF PLANT HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456	25.11.15	Sharath	Under processes

SCOPE & PLAN FOR OTHER PLANT HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456	25.11.15	Sharath	Under processes

ROOT CAUSE :No height master provided (28.50mm)

REGISTRATION NO. & DATE: 869 & 29.10.2015

REGISTERED BY :- Mr.Mahesh V.N

MANAGER'S SIGN :- Mr. Vijay Kumar

CELL :- A456 CELL NAME:- CBS MACHINE / STAGE:-Welding stage OPERATION :-60

KAIZEN THEME : To Prevent the customer complaint : A456 CBS Assy functional problem at sub Assy (Handle Assy) at HMSI-3F.

WIDELY/DEEPLY:-

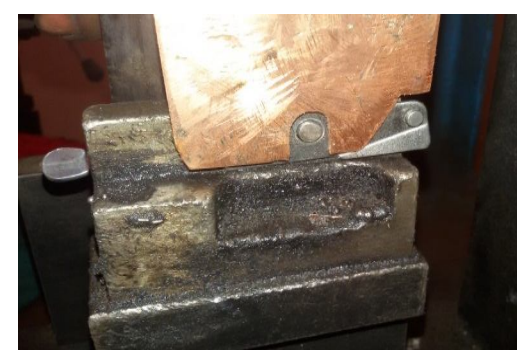
PROBLEM / PRESENT STATUS :-
To Prevent the customer complaint : A456 CBS Assy functional problem at sub Assy (Handle Assy) at HMSI-3F.



BEFORE

IDEA : -Welding dia should be OK.

Countermeasure:- Provided the copper strip in welding fixture to avoid the welding dia O/S



AFTER

WHY - WHY ANALYSIS :-
Why 1 - A456 CBS Assy functional problem at sub Assy (Handle Assy) at HMSI-3F.
Why 2 - CBS Assy Arm Comp - Parking Lock Free Movement NG (Slow)
Why 3 - The arm comp movement slow in assembly due to foul on face of - Bracket
Why 4 - Arm comp welding excess flow fouling with bracket face while assembly .
Why 5 - Welding overflow (No Control Over weld bead-travelling) (welding dia more)

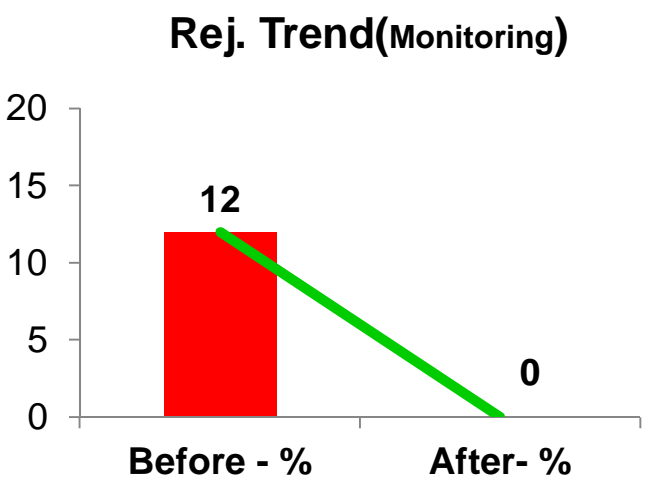
ROOT CAUSE : Operator maintained welding dia O/S due to past complaint (Weak welding / Weld broken).

REGISTRATION NO. & DATE: 882 & 29.10.15

REGISTERED BY :- QA Team

MANAGER'S SIGN :- Mr. Vijay Kumar

RESULT :-



BENCHMARK	12No.
TARGET	0 No.
KAIZEN START	19.10.15
KAIZEN FINISH	22.10.2015

TEAM MEMBERS :-
QA Team, Vijay , Jeewan Sunitech

BENEFITS :-

- 1) Prevent the customer complaints
- 2) Prevent the customer return.
- 3) Prevent the supplier rejection & Reduce the PPM

KAIZEN SUSTENANCE

WHAT TO DO : W I modified
HOW TO DO : Check with limit sample
FREQUENCY : - Once in shift .

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
1000	0	1000

SCOPE & PLAN FOR SELF PLANT HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456	25.11.2015	Sri ram auto	Under Process

SCOPE & PLAN FOR OTHER PLANT HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456	25.11.2015	Sri ram auto	Under Process