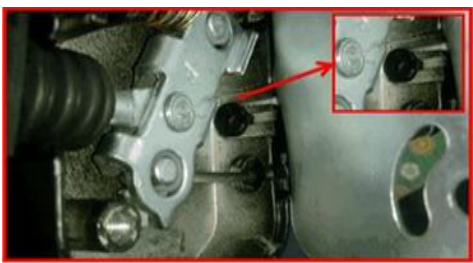


CELL :- A456 **CELL NAME:-** CBS Assy **MACHINE / STAGE:-** Lever Assy-OP-60 **OPERATION :-**Lever Assy

KAIZEN THEME : To Prevent the customer complaint for A456 CBS Assy (KWPJ) functional problem at Assy frame (Switch Assy) in HMSI 3F.

WIDELY/DEEPLY:-

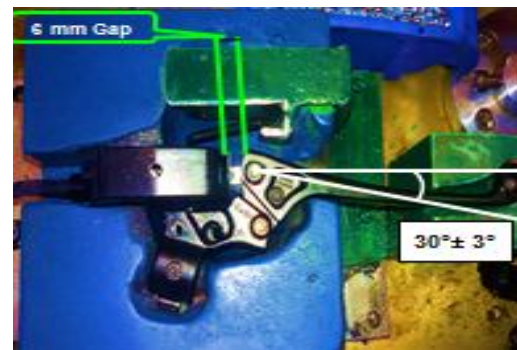
PROBLEM / PRESENT STATUS :-
To Prevent the customer complaint for A456 CBS Assy (KWPJ) functional problem at Assy frame (Switch Assy) in HMSI 3F.



BEFORE

IDEA :- Fixture modification

Countermeasure:- To change the exiting fixture by providing the Gap between the Equalizer & switch plunger to avoid the plunger being get hit by Equalizer .



AFTER

WHY - WHY ANALYSIS :-
Why 1 – Switch cable plunger broken at A456 Lever Assy
Why 2 - Equalizer may foul with switch plunger during Pivot-1 tightening at lever assembly.
Why 3 - The Gap between the Equalizer & Switch plunger is less at lever assembly may cause the plunger damage or broken.
Why 4 - Inadequate design of fixture

ROOT CAUSE :
Inadequate design of fixture

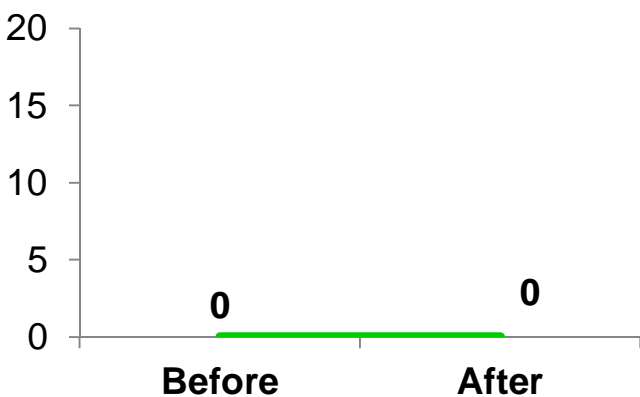
REGISTRATION NO. & DATE: 922 & 28.11.2015

REGISTERED BY :- Mr.Sharath

MANAGER'S SIGN :- Mr. Vijay Kumar

RESULT :-

IMPROVEMENT



BENCHMARK	0 No.
TARGET	0 No.
KAIZEN START	23.11.2015
KAIZEN FINISH	27.11.2015

TEAM MEMBERS :-
Mr .Sharath , Mr. Surandra , Mr.Chethan

- BENEFITS :-**
- 1) Prevent the customer complaint & PPM
 - 2) Prevent the In-house rejection

KAIZEN SUSTENANCE

WHAT TO DO : Added in Poka yoke check sheet .
HOW TO DO : Check with OK sample .
FREQUENCY : - Shift starting.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
100	0	100

SCOPE & PLAN FOR SELF PLANT HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	CBS LINE (line-2)	16.11.2015	Sharath	Open

CELL :- A456 **CELL NAME:- CBS** **MACHINE / STAGE:-Supplier End(Sri Ram)** **OPERATION :-Grinding**

KAIZEN THEME : To Prevent the defect of arm comp Poor function in CBS assembly.

IDEA : -To Control the Welding height.

WIDELY/DEEPLY:-

Countermeasure:-100% Grinding process added after welding process.

BENCHMARK	18534 No's
TARGET	0 No.
KAIZEN START	21.11.2015
KAIZEN FINISH	30.11.2015

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

TEAM MEMBERS :-
Quality Team
Kuldeep (Sri ram)

BENEFITS :-



BEFORE



AFTER

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

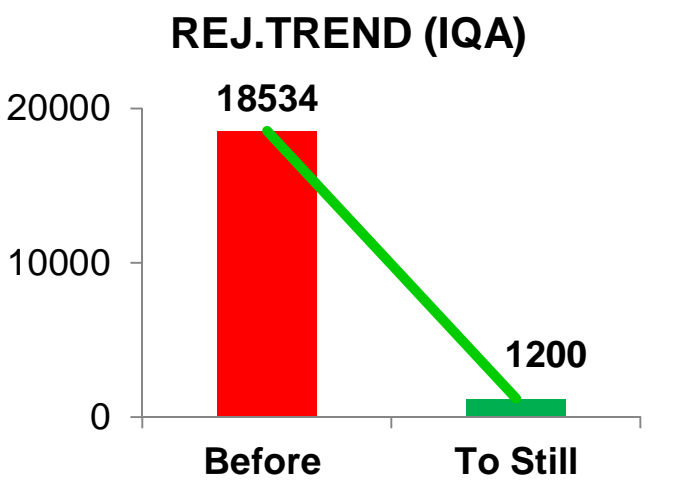
WHY - WHY ANALYSIS :-
Why 1 -5 no's Arm comp movement found with poor function at FI Stage.
Why 2 - Arm comp touches to Cover plate.
Why 3 Arm comp rest on High surface of bracket.
Why 4 - Arm comp welding height 2mm Max o/s by 0.9mm

KAIZEN SUSTENANCE

WHAT TO DO : Added in Process control sheet
HOW TO DO : As Per Process control sheet.
FREQUENCY : - 100%.

ROOT CAUSE :Arm comp welding height 2mm Max o/s by 0.9mm

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
1000	400	1400

SCOPE & PLAN FOR SELF PLANT HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	Shri ram	20/11/2015	Sandeep Sharma/Datta	Inprocess

SCOPE & PLAN FOR OTHER PLANT HORIZONTAL DEPLOYMENT

SR. NO.	Supplier	TARGET	RESPONSIBILITY	STATUS
1	Shri ram	20/11/2015	Sandeep Sharma/Datta	Inprocess

REGISTRATION NO. & DATE: 929 & 21.11.2015

REGISTERED BY :- Mr.Dashrath

MANAGER'S SIGN :- Mr. Vijay Kumar