

CELL :- A CELL NAME:- CBS Assy MACHINE / STAGE:-Hex tightening stage OPERATION :- 40

KAIZEN THEME :- To prevent defect Probability of A456 CBS Assy Poor Function of break lever

IDEA :- Provide Poka Yoke block

WIDELY/DEEPLY:-

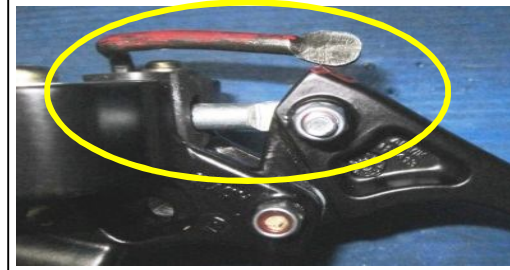
COUNTERMEASURE:
Provide the Poka-Yoke block at Hexagonal nut tightening stage.

BENCHMARK	00 No.
TARGET	0 No.
KAIZEN START	26.06.15
KAIZEN FINISH	30.06.15

PROBLEM / PRESENT STATUS :-To prevent A456 CBS Assy Poor Function of break lever

TEAM MEMBERS :-
Mr. Dasarath
Mr. Sharath ,Mr. Manju

BENEFITS :-



BEFORE



AFTER

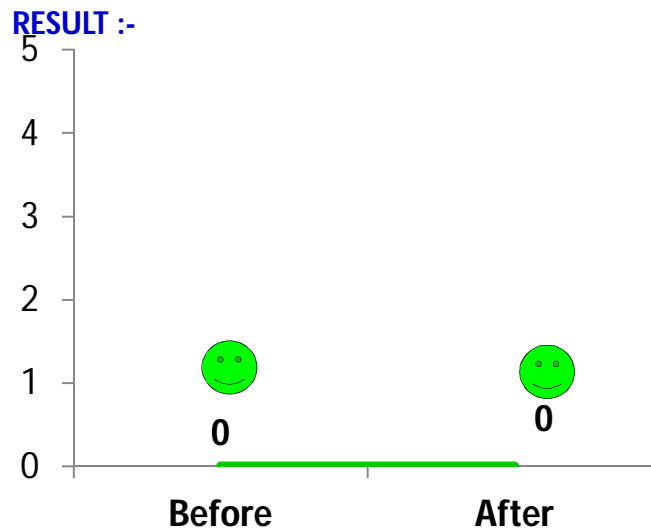
- 1) Prevent the in-house rejection & Rework .
- 2) Prevent the customer complaints, Warranty complaints.

- Why 1** - To prevent defect Probability of A456 CBS Assy Poor Function of break lever.
- Why 2** - Arm comp parking lever fouling with Break Lever.
- Why 3** - Arm comp lever angle less.
- Why 4** - Arm comp lever bend .

KAIZEN SUSTENANCE

WHAT TO DO : Added in Poka- Yoke check sheet & Limit sample provided in line.
HOW TO DO : Cross verification with limit sample.
FREQUENCY : - Shift starting.

ROOT CAUSE :- Arm comp lever bend .



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
50	00	50

REGISTRATION NO. & DATE: 729 & 30.06.15

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456-L2	27.6.15	Sharath	Comp

REGISTERED BY :- Guru

MANAGER'S SIGN :- Mr. Vijay Kumar