

CELL :- A CELL NAME:- CBS Assy MACHINE / STAGE:-Continuity checking OPERATION :- 40

KAIZEN THEME :- To prevent the defect Probability of A456 CBS Assy fitment problem at customer end.

WIDELY/DEEPLY:-

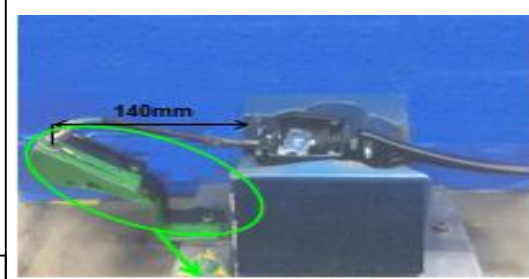
PROBLEM / PRESENT STATUS :-To prevent Probability of A456 CBA Arm comp lever bend .



BEFORE

IDEA :- Poka-Yoke

COUNTERMEASURE:
Increase the continuity testing block length **85mm to 140mm** at continuity checking station .



AFTER

WHY - WHY ANALYSIS :-
Why 1 - Probability of A456 CBS Assy fitment problem at customer end.
Why 2 - CBS Assy- Switch not fitted with meeting part .
Why 3 - Switch length U/S.
Why 4 - No provision to arrest the switch length U/S at existing Assy process.
Why 5 - No Poka yoke .

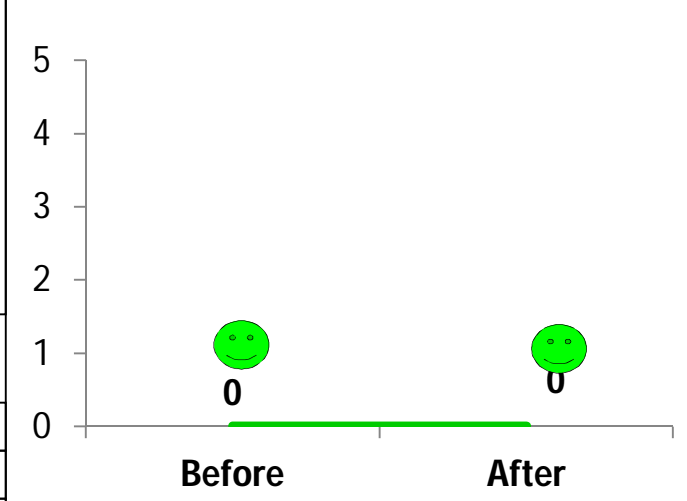
ROOT CAUSE :- No-Poka Yoke

REGISTRATION NO. & DATE: 748 & 10.07.15

REGISTERED BY :- Guru

MANAGER'S SIGN :- Mr. Vijay Kumar

RESULT :-



BENCHMARK	00 No.
TARGET	0 No.
KAIZEN START	26.06.15
KAIZEN FINISH	10.07.15

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

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

KAIZEN SUSTENANCE

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

COST INCURRED FOR MAKING KAIZEN

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

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456-L2	26.07.15	Sharath	OPEN