

CELL :-A351      CELL NAME:-Gear shifter      MACHINE / STAGE:- 140      OPERATION :-Hard Part Turning

**KAIZEN THEME :-** To prevent the defect of excess machining during 140 operation(HPT)

**IDEA :-** No Pin miss in fixture , No Wrong loading.

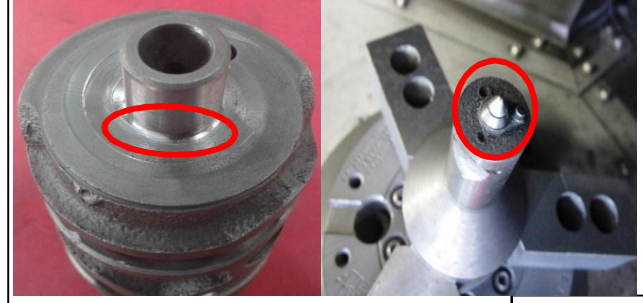
**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-)**  
 1) Micro- programmed in CNC to detect Wrong loading, that time CNC will gives , the alarm that "*Component was not in range*".  
 2) Poka-Yoke pin placed properly.  
 3) Machine operator has to check Availability of Locating Pins 2x.

<b>BENCHMARK</b>	01 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	30.10.14
<b>KAIZEN FINISH</b>	31.10.14

**PROBLEM / PRESENT STATUS:** 1 No. excess machining during 140 operation (HPT) Actual:52.30-0.1mm/ Observed : 52.12mm Distance U/S(0.18).

**TEAM MEMBERS :-**  
Mr. NS Pujari, Mr, Ravigouda



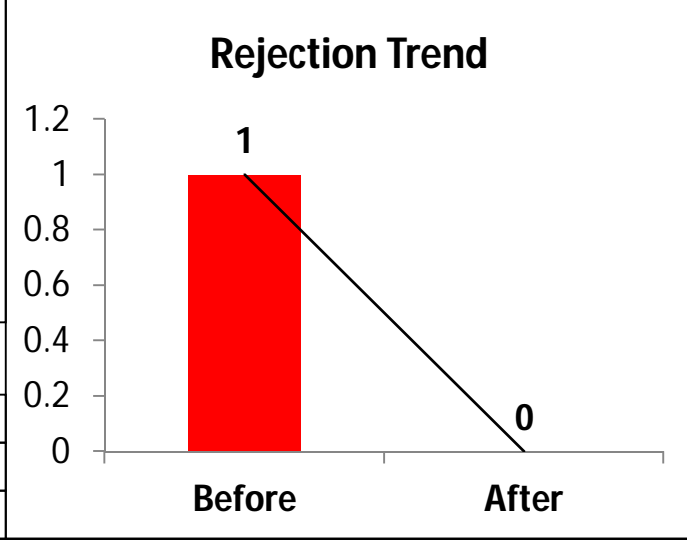
BEFORE

AFTER

**BENEFITS :-**  
1. Reduction in in-house rejection

**WHY - WHY ANALYSIS :-**  
**Why 1 :** 1 No. excess machining during 140 operation (HPT) Actual:52.30-0.1mm/ Observed - 52.12mm Distance U/S(0.18).  
**Why 2 :** Component wrong loading by operator.  
**Why 3 :** Dia 3.025mm locating **Poka-Yoke pin** missed in fixture.  
**Why 4 :** Locating **Poka-Yoke pin loose** in fixture, pin came out along with component .  
**Why 5 :** Operator not observed – POKA.

**RESULT :-**



**KAIZEN SUSTENANCE**

**WHAT TO DO :** Daily inspection / Check .  
**HOW TO DO :** Visually check presence of 2 pin .  
**FREQUENCY :** Shift 3 time.

**ROOT CAUSE :-**Poka-yoke pin miss in fixture .

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
100	200	300

**REGISTRATION NO. & DATE :** 289 & 31.10.14

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

**REGISTERED BY :-**Guru

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A351	31.10.14	Mr. Ravi	Comp

**MANAGER'S SIGN :-** Narayanan