

Problem Description :- To Prevent the defect probability of M8*1.25mm Thread miss,



Why Why Analysis :-

Why 1 – Defect probability of M8* 1.25mm Thread miss at Final assembly as Well Customer end,

Why 2 – Manual checking process,

Why 3 – Human error!

Why 4 – No Poka yoke to ensure Thread availability/ Non- availability

Root Cause :- No Poka yoke

Kaizen Idea :- Poka yoke to be made to arrest Thread miss part at Switch press assembly Before moving part Final inspection.

Countermeasure :- Kaizen implemented at Switch pressing station with step by step,

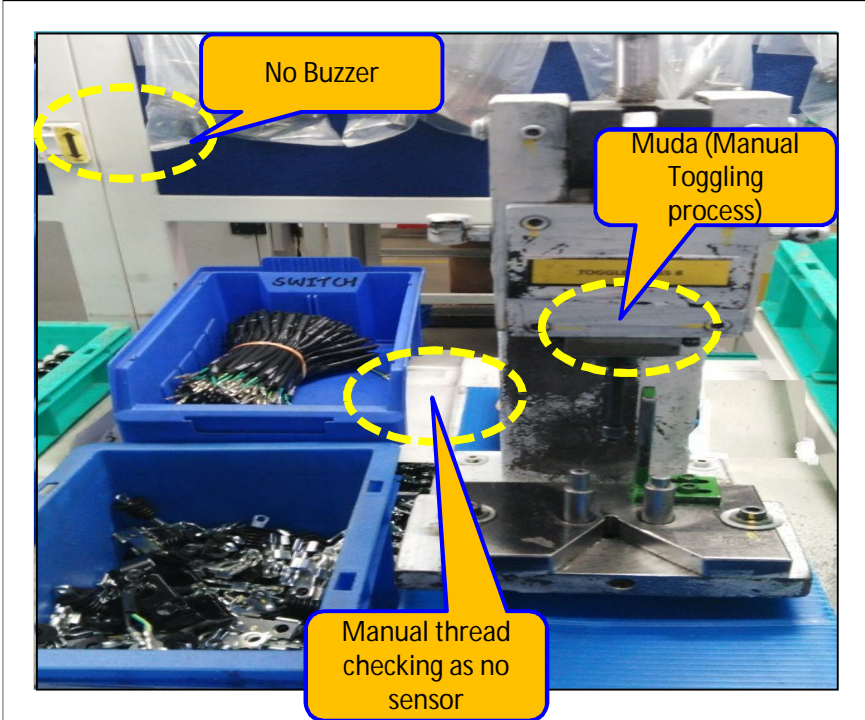
Step -1 :- Auto thread check sensor provided,

Step -2 :- Provided :- Buzzer with Red Light

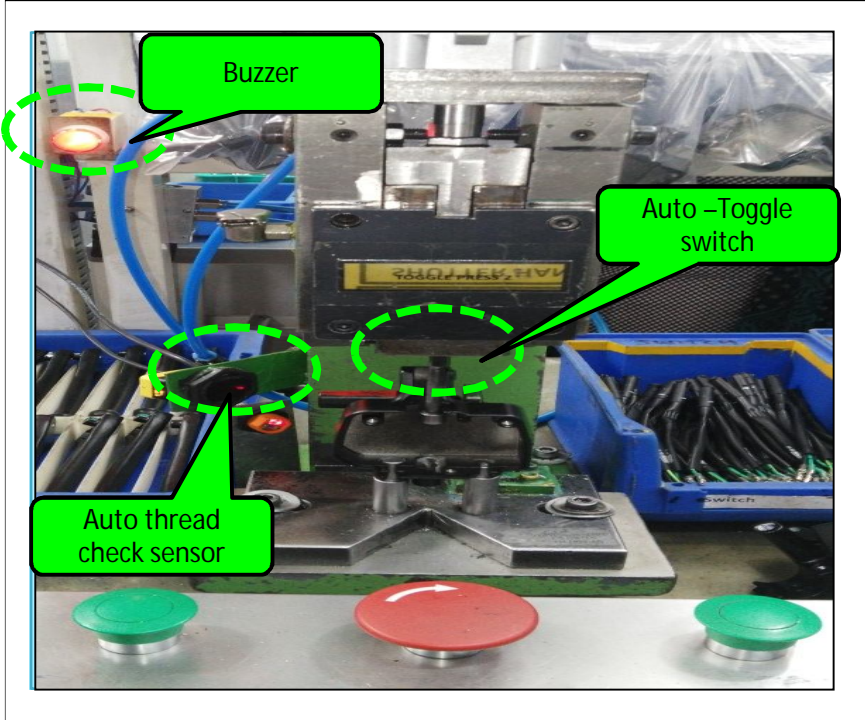
Step -3 :- Sensor interfaced with Pneumatic toggle switch press.

Before

After



- 1) Manual thread checking as No thread check sensor
- 2) No Buzzer for arrest defect out-flow
- 3) Probability Defect out-flow as No interfacing,
- 4) Probability of Defect part out-flow



- 1) Auto -Thread check sensor provided
- 2) Buzzer provided :- with red lamp+ Sound
- 3) Thread check sensor interfaced with Auto toggle switch press if any, Thread miss component found Toggle press will not work, Buzzer gives the alarm with Red Lght.

CELL :-A456 CELL NAME:- Combi-Brake assy

MACHINE / STAGE:- Sub -Assembly

OPERATION :-30-Bracket Switch pressing

KAIZEN THEME :- To Prevent the defect probability of M8*1.25mm Thread miss

IDEA :-Implement Poka yoke to be made to arrest Thread miss part at Switch press assembly -
- Before moving part Final inspection.

WIDELY/DEEPLY:- Deeply

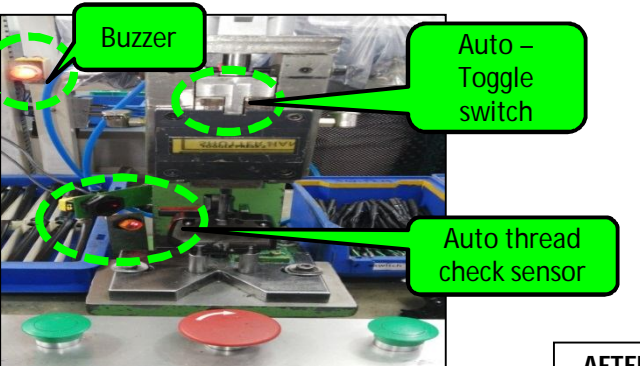
PROBLEM / PRESENT STATUS :- No poka yoke to arrest M8*1.25mm Threading missed operation, probability of in-house as well Customer complaint.

COUNTERMEASURE:-
Kaizen implemented at Switch pressing station with,
1) Auto thread check sensor provided,
2) Provided :- Buzzer with Red Light
3) Sensor interfaced with Pneumatic toggle switch

BENCHMARK	01 No.
TARGET	0 No.
KAIZEN START	20.12.2015
KAIZEN FINISH	12.01.2016

TEAM MEMBERS :-
Team QA & Maintenance

BENEFITS :-
1) No customer complaint,
2) Arrest Defect at primary stage,
3) Rework and Cost saving.



BEFORE

AFTER

WHY - WHY ANALYSIS :-
Why 1 – Defect probability of M8* 1.25mm Thread miss at Final assembly as Well Customer end,
Why 2 – Manual checking process,
Why 3 – Human error!
Why 4 – No Poka yoke to ensure Thread availability/ Non- availability

RESULT :- Result in Q



KAIZEN SUSTENANCE

WHAT TO DO : Checkpoint add in Daily poka yoke check sheet.

HOW TO DO : Validate sensor with Thread miss **NOT OK** as well **OK** Master Sample

FREQUENCY : Daily Start of Shift

ROOT CAUSE :- No Poka yoke

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
22 K	In-house	22 K

REGISTRATION NO. & DATE: 972 & 12.01.2016

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Mr, Gurubasappa

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	(All plant)	...	Dashrath	Open.

MANAGER'S SIGN :- Mr, Vijay Kumar