

**CELL :-** A247 L-1    **CELL NAME:-** A247 C B S    **MACHINE / STAGE:-** Hex-nut tightening    **OPERATION :-** 40

**KAIZEN THEME :-** To Prevent the Potential Customer Complaint of Arm Comp Lever (A456 CBS Assembly Part) fouling with Mating Part at customer end.

**IDEA :-** Inspection for lever angle 80 degree > Spec.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Provided the Poka Yoke Block at Hex-Nut Tightening Fixture to prevent sitting of Arm Comp. Lever having angle > 80 degree in A456 CBS Assembly Cell.

|                      |          |
|----------------------|----------|
| <b>BENCHMARK</b>     | 01 No.   |
| <b>TARGET</b>        | 0 No.    |
| <b>KAIZEN START</b>  | 03.01.15 |
| <b>KAIZEN FINISH</b> | 04.01.15 |

**PROBLEM / PRESENT STATUS :-** Customer Complaint can report on account of Arm Comp Lever(A456 CBS Assembly Part) fouling with Mating Part at customer end.,

**TEAM MEMBERS :-**  
Sharath,Dsharath, Pramod



BEFORE



AFTER

**BENEFITS :-**

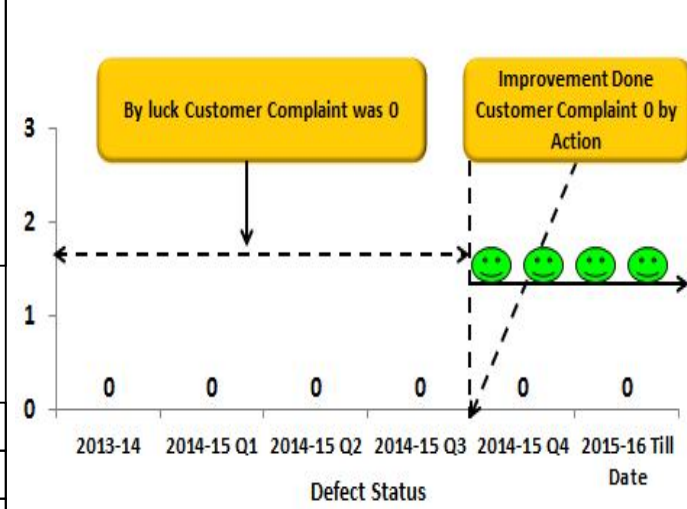
- 1) Avoid in customer complaint,
- 2) Arrest Defect at primary stage,
- 3) 3M, Reduction in Rework cost.

**WHY - WHY ANALYSIS :-**  
**Why 1** – Arm Comp Lever can foul with mating component at customer end.  
**Why 2** – Arm Comp. Lever Angle 80 degree > Spec.  
**Why 3** – No Inspection for lever angle 80 degree > Spec.

**KAIZEN SUSTENANCE**

**WHAT TO DO :** Added in Poke-Yoke Check sheet .

**RESULT :-**



**HOW TO DO :** Verifying with Defective Master Sample & Monitoring in Daily Poka yoke Sustenance Check Sheet.

**FREQUENCY :** Daily / Once.

**Root Cause – No Inspection for lever angle 80 degree > Spec.**

**COST INCURRED FOR MAKING KAIZEN**

| MATERIAL COST IN RS | LABOUR COST IN RS | TOTAL COST IN RS |
|---------------------|-------------------|------------------|
| 200                 | N A               | 200              |

**REGISTRATION NO. & DATE:** 536 & 05.01.15  
**REGISTERED BY :-** Mr. Gurubasappa  
**MANAGER'S SIGN :-** Narayanan

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

| SR. NO. | CELL | TARGET   | RESPONSIBILITY     | STATUS |
|---------|------|----------|--------------------|--------|
| 1       | A247 | 10.01.15 | Sharath / Dsharath | comp   |