

TPM CIRCLE NO :-
 TPM CIRCLE NAME :
 DEPT :-QA

ACTIVITY
 LOSS NO. / STEP
 RESULT AREA

KK QM PM JH SHE OT DM E&T
 P Q DEF :- A C D S M

CELL :-A456

CELL NAME:- CB Assy

MACHINE / STAGE:- Sub Assembly

OPERATION :- Bracket+Switch Assembly

KAIZEN THEME :- To Prevent the defect of CBS Assembly not fitment at customer end.

IDEA – In-process inspection for C Profile.

WIDELY/DEEPLY:- >>

PROBLEM / PRESENT STATUS :- "C Profile" bent bracket found at Final inspection as Customer end.

COUNTERMEASURE:- Poka yoke Block Provided at Bracket+Switch Sub Assembly, if any defect casting found during Sub assembly, it will not enter in Fixture

BENCHMARK	02 No.
TARGET	0 No.
KAIZEN START	20.12.2014
KAIZEN FINISH	25.12.2014



BEFORE



AFTER

TEAM MEMBERS :-
 Mr. Sharath, Mr Dsharath-QA,
 Mr. Manjunath

BENEFITS :-

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

KAIZEN SUSTENANCE

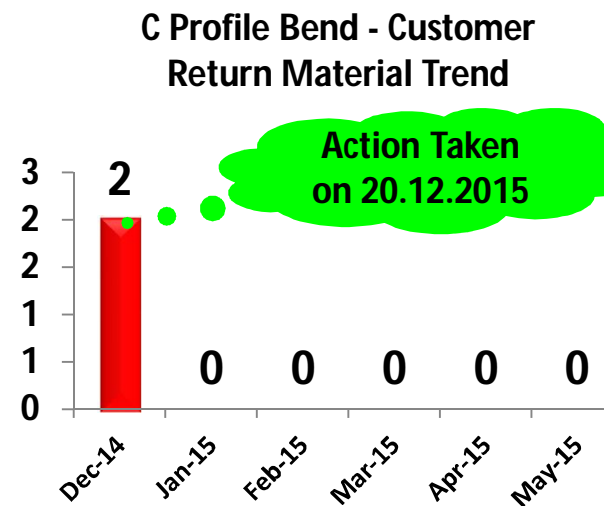
WHY - WHY ANALYSIS :-

- Why 1 –** CBS Assembly not fitment at customer end.
- Why 2 –** C Profile not assembled with handle bar assembly.
- Why 3 –** C Profile Not Ok (Bend)
- Why 4 –** No In-process inspection for C Profile.

WHAT TO DO : Added in Poke-Yoke Check sheet .
HOW TO DO : Verifying with Defective Master Sample & Monitoring in Daily Poka yoke Sustenance Check Sheet.
FREQUENCY : Daily /Day.

ROOT CAUSE :- No In-process inspection for C Profile.

RESULT :-



COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
500 Rs	0 Rs	500 Rs

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456-2	05.01.15	Sharath / Dashrath	Comp

REGISTRATION NO. & DATE: 476 & 25/12/2014

REGISTERED BY :- Mr. Gurubasappa

MANAGER'S SIGN :- Mr. Narayanan