

CELL :-A351 **CELL NAME:-** Drum Change Line **MACHINE / STAGE :-** VMC/Machining **OPERATION :-** Operation No. 40

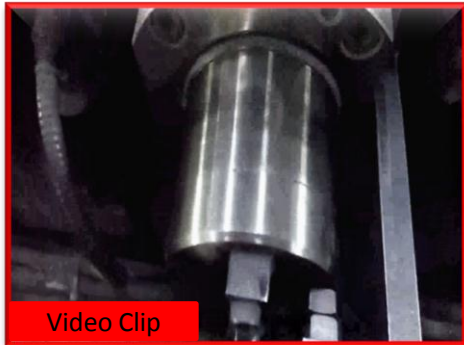
KAIZEN THEME : To Prevent defect of A351 DGS at grooving stage.

IDEA :- Poka Yoke to be provide

WIDELY/DEEPLY:-

COUNTERMEASURE:- Poka yoke provided by adjusted the tail stock stroke length sensor & now machine will not start in component wrong loading.

PROBLEM / PRESENT STATUS :- A351 DGS track damage due to wrong loading happening at grooving stage.



BEFORE



AFTER

BENCHMARK	5 Nos
TARGET	Zero
KAIZEN START	16.01.2016
KAIZEN FINISH	17.01.2016

TEAM MEMBERS :-
N.S.Pujari , Mr. Pavan, Mr. Chethan.

- BENEFITS :-**
- 1.Prevent In-house rejection.
 2. Prevent Ø7.1 EM tool breakage.
 - 3.Prevent Ø4.1 locating pin breakage

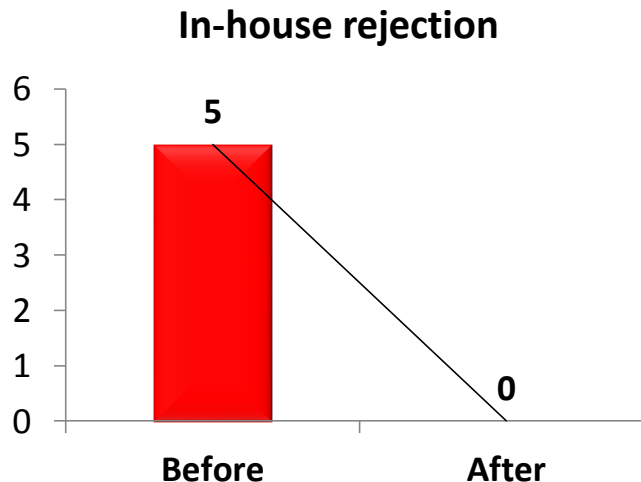
KAIZEN SUSTENANCE

WHAT TO DO: Check Tail stock stroke length sensor correct position.
HOW TO DO: By component wrong loading.
FREQUENCY : Once in a week.

WHY - WHY ANALYSIS :-

- Why1:** 05 Nos In-house rejection happened at grooving stage.
- Why 2:-** Component wrong loading.
- Why 3:-** Machine Not detected.
- Why 4:-** No Poka Yoke

RESULT :- Defect trend



ROOT CAUSE :- No Poka Yoke

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE: 1310 ,30.01.16

REGISTERED BY :- Guru Basappa

MANAGER'S SIGN :- N.S.Pujari

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

Sr. No.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	-----	-----	-----	-----.