

|                        |                 |    |    |          |    |     |    |    |     |
|------------------------|-----------------|----|----|----------|----|-----|----|----|-----|
| TPM CIRCLE NO :-1      | ACTIVITY        | KK | QM | PM       | JH | SHE | OT | DM | E&T |
| TPM CIRCLE NAME : Josh | LOSS NO. / STEP |    |    |          |    |     |    |    |     |
| DEPT :- Maintenance    | RESULT AREA     | P  | Q  | DEF :- A | C  | D   | S  | M  |     |

|             |                       |                                       |                             |
|-------------|-----------------------|---------------------------------------|-----------------------------|
| CELL :-A247 | CELL NAME:- CBS Assy. | MACHINE / STAGE :- A247 Assembly Line | OPERATION :- Grouping Stage |
|-------------|-----------------------|---------------------------------------|-----------------------------|

**KAIZEN THEME :** To Prevent defect probability of Spring fitment miss in A247 CBS Assembly.

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-** Probability of Spring- miss in A247 CBS Assembly Line at Grouping Stage.

**IDEA :-** Poka Yoke

**COUNTERMEASURE:-** Provided interfacing in-between Spring pick up and Next stage () Pneumatic Gun start up cycle, to prevent Poka.



BEFORE

AFTER

|                      |            |
|----------------------|------------|
| <b>BENCHMARK</b>     | 0 No.      |
| <b>TARGET</b>        | 0 No.      |
| <b>KAIZEN START</b>  | 10.05.2014 |
| <b>KAIZEN FINISH</b> | 12.05.2014 |

**TEAM MEMBERS :-**  
 Dinesh Kumar  
 Pawan Kumar

- BENEFITS :-**
1. Prevent Potential Customer Complaint.
  2. Process Enhancement.

**KAIZEN SUSTENANCE**

**WHAT TO DO:** Validation of Interfacing activity.  
**HOW TO DO:** Visual Inspection .  
**FREQUENCY :** Daily start of Shift.

**WHY - WHY ANALYSIS :-**  
**Why1:** Probability of Spring Fitment Miss.  
**Ans.1:** Poka

**RESULT :-**

**ROOT CAUSE :- Poka**

Probability of Spring Miss                      No Probability of Spring Miss

| <b>COST INCURRED FOR MAKING KAIZEN</b> |                          |                         |
|--|--------------------------|-------------------------|
| <b>MATERIAL COST IN RS</b>             | <b>LABOUR COST IN RS</b> | <b>TOTAL COST IN RS</b> |
| 3500/-                                 | -----                    | 3500/-                  |

**REGISTRATION NO. & DATE:** 47 & 25.05.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** A.Shaivashankar



| <b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b> |                      |          |                |        |
|---|----------------------|----------|----------------|--------|
| SR. NO.   | CELL                 | TARGET   | RESPONSIBILITY | STATUS |
| 1.  | 2 <sup>nd</sup> Cell | 30.05.14 | Shankar        | Comp.  |