

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 :-A128      CELL NAME:- Tensioner Assy.      MACHINE / STAGE :- A128 Tensioner Assembly Line      OPERATION :- Cap Crimping Stage

**KAIZEN THEME :** To Prevent defect of Wrong Model Retainer fitment in Tensioner Assy.

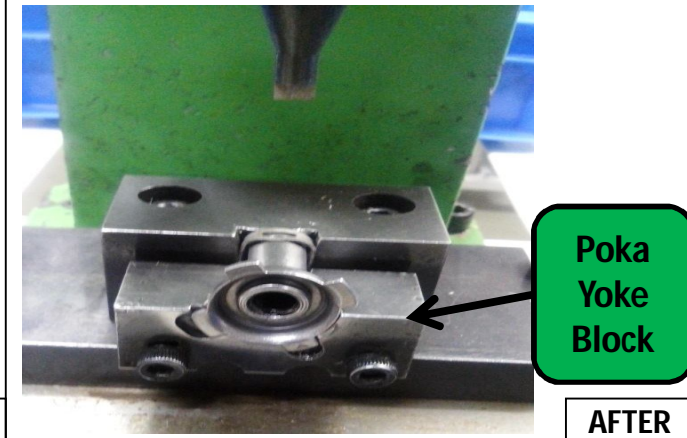
**IDEA :-** Poka Yoke

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Provided the Poka Yoke Block in Cap Crimping Fixture to arrest Wrong Retainer before Cap Crimping itself.

<b>BENCHMARK</b>	04 Nos.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	01.04.2014
<b>KAIZEN FINISH</b>	20.04.2014

**PROBLEM / PRESENT STATUS :-** 4 Nos. Wrong Model Retainer assembled in Tensioner Assy.



- TEAM MEMBERS :-**  
Sachin Kumar  
Shanta Kumar
- BENEFITS :-**
1. Prevent Potential Customer Complaint.
  2. Reduce COPQ



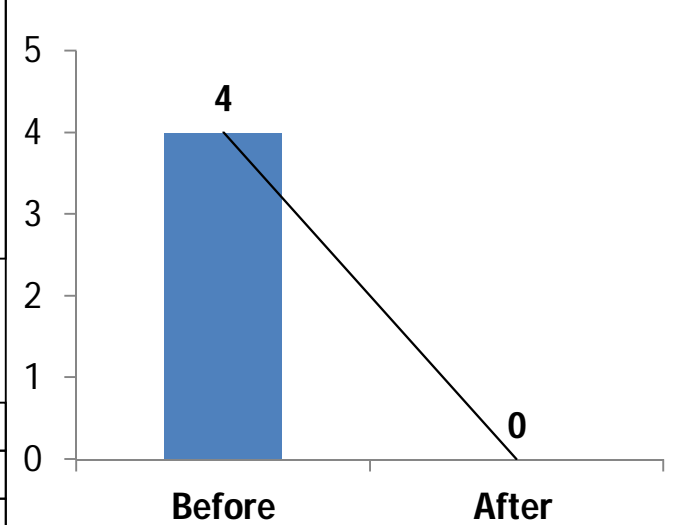
BEFORE

**KAIZEN SUSTENANCE**

**WHAT TO DO:** Change the Fixture Drawing.  
**HOW TO DO:** -----  
**FREQUENCY :** 1 Time Action

**WHY - WHY ANALYSIS :-**  
**Why1:** Wrong Model Retainer Fitment.  
**Why2 :** Wrong Model Retainer Fitment at Grouping Stage.  
**Why3:** Poka

**RESULT :-**



**ROOT CAUSE :-** Poka

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
INR 1066/-	-----	INR 1066/-

**REGISTRATION NO. & DATE:** 13 & 20.04.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** Narayanan

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A157	05.05.14	Appasab	Comp.