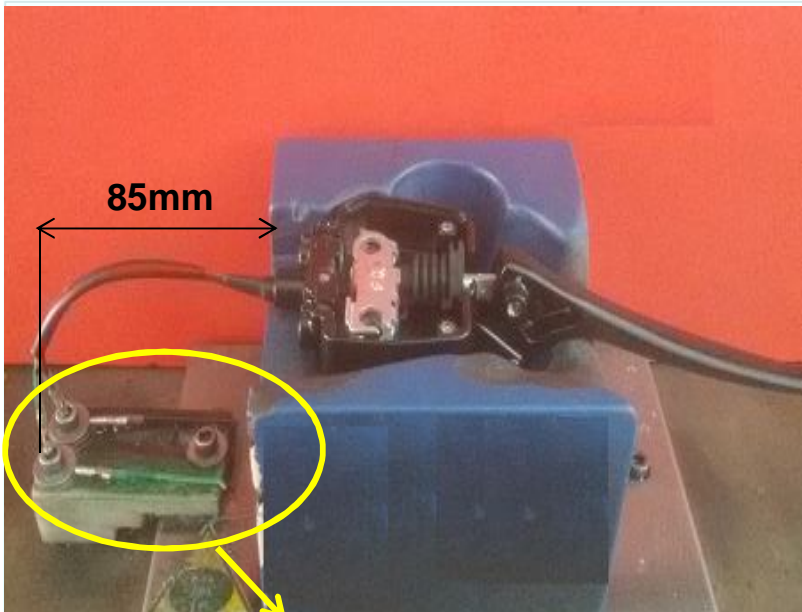


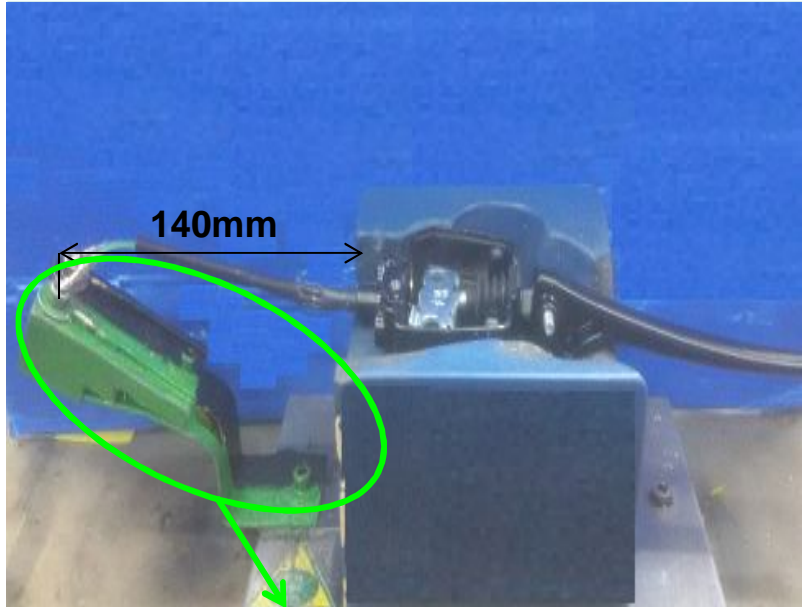
**Before**

**After**



Length U/S part not detected

**No Control of length U/S**



Length U/S part detected

**Control of Length U/S**

**CELL :- A**      **CELL NAME:- CBS Assy**      **MACHINE / STAGE:-Continuity checking**      **OPERATION :- 40**

**KAIZEN THEME :-** To prevent Probability of A456 CBA Arm comp lever bend .

**IDEA :- Poka-Yoke**

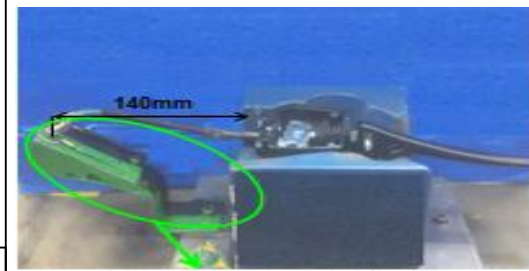
**WIDELY/DEEPLY:-**

**COUNTERMEASURE:**  
Increase the continuity testing block length **85mm to 140mm** at continuity checking station .

<b>BENCHMARK</b>	<b>00 No.</b>
<b>TARGET</b>	<b>0 No.</b>
<b>KAIZEN START</b>	<b>26.06.15</b>
<b>KAIZEN FINISH</b>	

**PROBLEM / PRESENT STATUS :-**To prevent Probability of A456 CBA Arm comp lever bend .

**TEAM MEMBERS :-**  
Mr. Sharath  
Mr. Surendra  
**BENEFITS :-**



Length U/S part not detected      **BEFORE**

Length U/S part detected      **AFTER**

- 1) Prevent the in-house rejection & Rework .
- 2) Prevent the customer complaints, Warranty complaints.

**WHY - WHY ANALYSIS :-**  
**Why 1** - Probability of A456 CBA switch length U/S.(140mm)  
**Why 2** - No provision to arrest the switch length U/S at existing Assy process.  
**Why 3** - No Poka yoke .

**RESULT :-**

**PROCESS IMPROVEMENT**

**KAIZEN SUSTENANCE**

**WHAT TO DO :** Added in Poka- Yoke check sheet.  
**HOW TO DO :** Simulation with master sample .  
**FREQUENCY :** - Once in shift

**ROOT CAUSE :- No-Poka Yoke**

**COST INCURRED FOR MAKING KAIZEN**

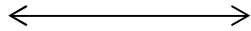
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
00	00	00

**REGISTRATION NO. & DATE : 729 & 26.06.15**  
**REGISTERED BY :- Mr.Sharath Prasad**  
**MANAGER'S SIGN :- Mr. Vijay Kumar**

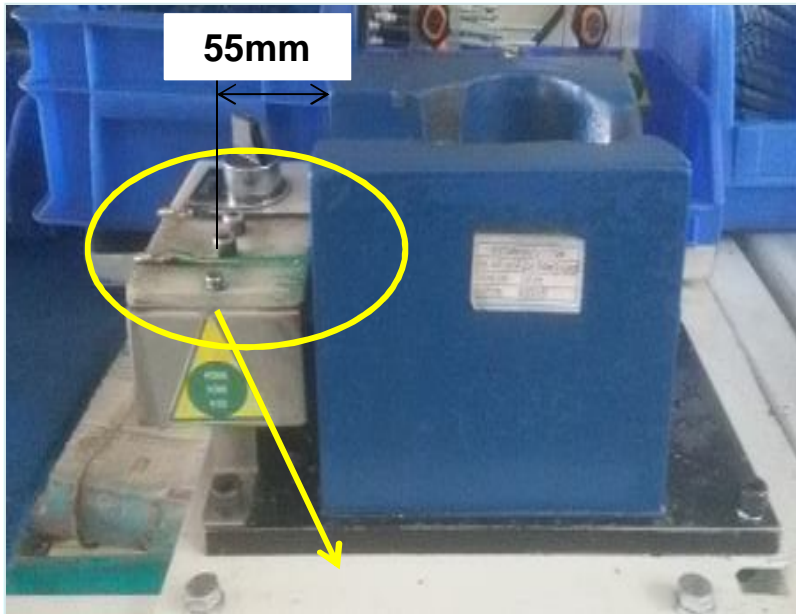
**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A456-L2	16.07.15	Sharath	OPEN

85mm



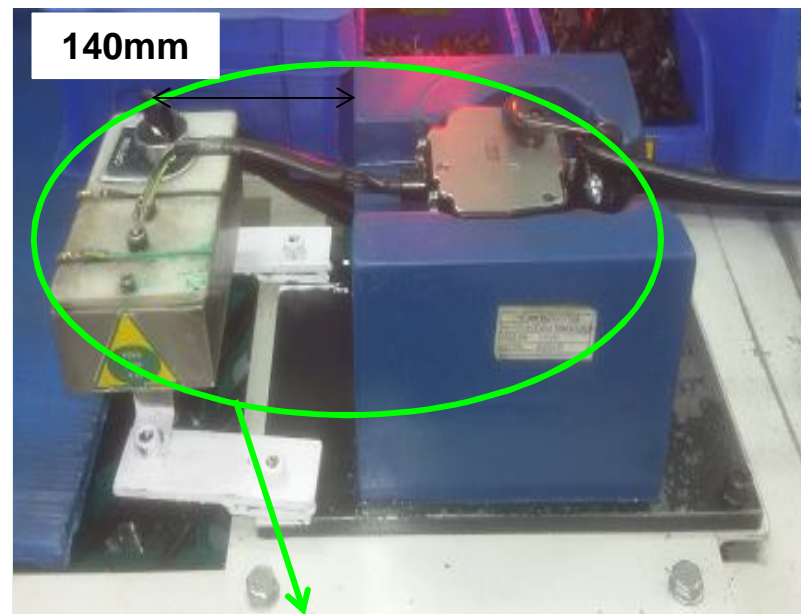
**Before**



Length U/S part not detected

**No Control of length U/S**

**After**



Length U/S part detected

**Control of Length U/S**

CELL :- Line-2    CELL NAME:- CBS Assy    MACHINE / STAGE:-Continuity checking    OPERATION :- 40

**KAIZEN THEME :-** To prevent Probability of A456 CBA Arm comp lever bend .

**IDEA :- Poka-Yoke**

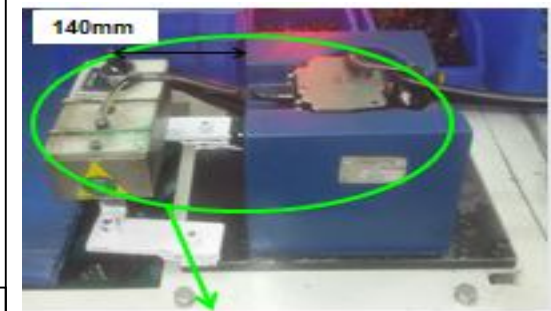
**WIDELY/DEEPLY:-**

**COUNTERMEASURE:**  
Increase the continuity testing block length **85mm to 140mm** at continuity checking station .

<b>BENCHMARK</b>	00 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	26.06.15
<b>KAIZEN FINISH</b>	26.06.15

**PROBLEM / PRESENT STATUS :-**To prevent Probability of A456 CBA Arm comp lever bend .

**TEAM MEMBERS :-**  
Mr. Sharath



**Mr. Manju**

Length U/S part not detected    **BEFORE**

Length U/S part detected    **AFTER**

- BENEFITS :-**
- 1) Prevent the in-house rejection & Rework .
  - 2) Prevent the customer complaints, Warranty complaints.

**WHY - WHY ANALYSIS :-**  
**Why 1** - Probability of A456 CBA switch length U/S.(140mm)  
**Why 2** - No provision to arrest the switch length U/S at existing Assy process.  
**Why 3** - No Poka yoke .

**KAIZEN SUSTENANCE**

**ROOT CAUSE :- No-Poka Yoke**

**RESULT :-**

**WHAT TO DO :** Added in Poka- Yoke check sheet.  
**HOW TO DO :** Simulation with master sample .  
**FREQUENCY :** - Once in shift

**PROCESS IMPROVEMENT**

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
00	00	00

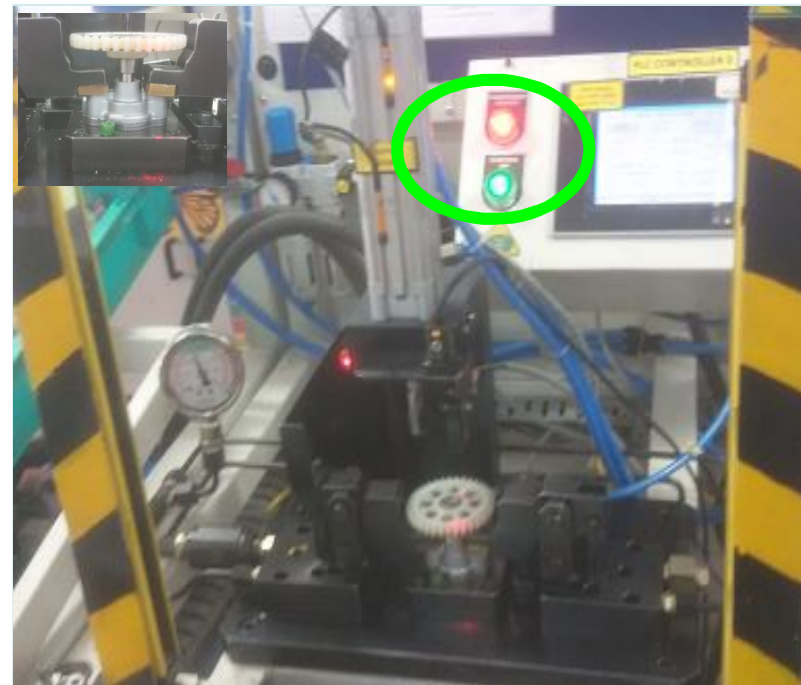
**REGISTRATION NO. & DATE:** 729 & 26.06.15  
**REGISTERED BY :-** Mr.Sharath Prasad  
**MANAGER'S SIGN :-** Mr. Vijay Kumar

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1		NA	NA	NA

**Before**

**After**



**Air nozzle height more**

**Air nozzle height reduced (2.5mm)**

**CELL :- A177**    **CELL NAME:-Oil pump assy.**    **MACHINE / STAGE:- Free Rotation**    **OPERATION :- 30**

**KAIZEN THEME :-**Probability of A177 Oil pump 2 Plate Assy at plate Assy station.

**IDEA :- Poka Yoke**

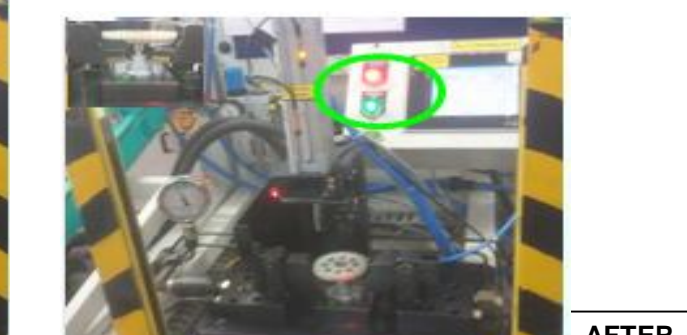
**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-**Decreases the Air nozzle height by 2.0 mm at free Rotation Process .

<b>BENCHMARK</b>	<b>00 No.</b>
<b>TARGET</b>	<b>0 No.</b>
<b>KAIZEN START</b>	<b>26.06.15</b>
<b>KAIZEN FINISH</b>	<b>27.06.15</b>

**PROBLEM / PRESENT STATUS :-**  
Probability of A177 Oil pump 2 Plate Assy at plate Assy station.

**TEAM MEMBERS :-**  
Mr. Pramod , Mr Sharath



**Mr.Dashrath**

- BENEFITS :-**
- 1) Prevent the in-house rejection as well PPM.
  - 2) Prevent the customer complaints.

**WHY - WHY ANALYSIS :-**  
**Why 1** - Probability of A177 Oil pump 2 Plate Assy at plate Assy station.  
**Why 2** - No provision to arrest the 2 plate Assy in existing process.  
**Why 3** - No Poka yoke .

**RESULT :-**

**Process improvements**

**KAIZEN SUSTENANCE**

**WHAT TO DO :** Added in Poka-Yoke sheet .  
**HOW TO DO :** Master samples (NG & OK) provided in line & daily cross check.  
**FREQUENCY :-** - Once in shift

**ROOT CAUSE :-** No Poka yoke .

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
00	00	00

**REGISTRATION NO. & DATE:**731 &27.06.15

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

**REGISTERED BY :-** Mr.Dashrath

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A374	15.06.2015	Sharath	Open

**MANAGER'S SIGN :-** Mr. Vijay Kumar