Sparkline 6				KAIZEN		-					
complete solution for material handling			Dept: Quality	Dept: Quality			Kaizen No.:				
Cell No.: - 01	Cell Name:	-9T UFA	Machine : - UFA levelling jig Proces	ss / Stage : UFA Levelling & Part Fixing			Operation :	Part	Fixing		
Kaizen Theme:			Idea: End stoper is provided to control attachment	beam fitment issue and inproper mounting on the le	evelling fi	xture duri	ng levelling.				
Process and Product	Improveme	nt									
Present status:			COUNTERMEASURE IN PICTORIAL:			KAIZEI	I Ctt	05.0	2040		
1) Bottom attachmen	beam dista	nce is checked by using	BEFORE	AFTER		KAIZEI	N Start	05-0	3-2018		
measurement tape.			and the same of th				Finish	07-1	Mar-18		
2) Inproper mounting	on the levell	ing fixture during levelling		AND WATER AT	Team M	embers:					
			- 4200				1- S.Praveenkumar				
No poke-yoke is av	ailable							2- Rajesh			
						Benefits:					
						1-Attachment beam distance can be ensured					
			Bottom attachment beam distance is checked by using	End stoper id used to control attachement beam is fixed within specific.	2-Custo	omer com	plaint can be av	voided			
			measurement tape and inproper mounting on the fixture	and proper mounting on the fixture			KAIZEN SUS	TENANCE :			
Why Why Analysis:			Countermeasure & Results:		What to do:						
W1. To Avoid the Fitment	issue					Irreversible Kaizen					
W2 .To avoid the custom	er complaint		Time can be reduced and customer complaint can be avoide	d.							
			Result:		Ť						
Root Cause :			1-Dimension between the 8th cross member to attachment beam bracket can be maintained with in limit.			How to do :					
			1-bimension between the 8th cross member to attachment beam bracket can be maintained with in limit.			Scope & Plan for Horizontal Deployment					
							Target				
	1 1		2-Time of inspection can be reduced	2-Time of inspection can be reduced			-	Responsibility	Status		
Registration no. & Date:	05-	03-2018					Date				
Registered by :	S.Praveenki	umar			1	UFA	07-03-2018	Operetor	Implemented		
Manager's Sign :	Sai krishna	<u> </u>			1						

Sparkline(6)		KAIZEN								
co-matelle autation for material b	- CTOA		Dept: Quality			Kaizen No.:				
Cell No.: - 01	Cell Name:	- Project area		ss / Stage: Bottom cup and square block assembly			Operation :	Part	Fixing	
Kaizen Theme:			Idea: Small jig is made for control fitment issues a	nd increase productivity						
Process and Product	Improvement		COUNTERMEASURE IN PICTORIAL:		Bench M	ark				
Present status:			COUNTERMEAGURE INTROTORIAE.		Delicitivi	KAIZEN	10		0.0010	
			BEFORE	AFTER		KAIZE	Start	02-0	2-2018	
Solid square block	and J hook a	e assembled by manual		of the same arrange with the	KAIZEN		Finish	03-F	eb-18	
2) Square block and	J hook assem	bly is checked by measurement		The second second	Team Members:					
3) No poke-yoke is a		<u> </u>			1- S.Praveenkumar					
							can be avoided		oductivity	
			1) Solid square block and J hook are assembled by manual	Solid square block and J are assembled by small fixture	2-Custo	mer com	plaint can be av			
Why Why Analysis:	1		Countermeasure & Results:		What to do		KAIZEN 505	TENANCE :		
W1. To Avoid the Fitmen W2 .To avoid the custom			— Time can be reduced and customer complaint can be avoided.			Irreversible Kaizen				
			Result:							
Root Cause :		<u> </u>	1-Bottom cup and j hook offset dimensions can be maintained within limit			How to do : Scope & Plan for Horizontal Deployment				
Registration no. & Date : 02-Feb-18			1-Bottom cup and j hook offset can be maintained SI n			Model	Target Date	Responsibility	Status	
Registered by : Manager's Sign :	S.Praveenkur Sai krishna	nar	2-Time of inspection can be reduced		1	Stillage	03-02=2018	Operator	Implemented	

Sparkline 6				KAIZEN						
COMMITTED TO SECURIT TO			Dept: Quality				Kaizen No.:			
Cell No.: - 01	Cell Name:	- Project area	Machine: - Stillage project Proce	ss / Stage : Bottom cup and square block assembly			Operation :	Part	Fixing	
Kaizen Theme:			Idea: Small fixture is made for control fitment issue	es and straightness of the square block						
Process and Product Improvement			COUNTERMEASURE IN PICTORIAL:			1ark				
Present status:	Present status:		South Entitle Historian E.			KAIZEN Start		12-02	2-2018	
4) 0 51			BEFORE	AFTER					12 02 2010	
Solid square block	and bottom c	up are assembled by manual				KAIZEN	I Finish	13-F	eb-18	
2) Square block and of	cup assembly	is checked by measurement		A STATE OF THE PARTY OF THE PAR	Team Members:					
3) No poke-yoke is av	nilabla			THE RESERVE TO SERVE THE PARTY OF THE PARTY	1- S.Praveenkumar					
3) No poke-yoke is av	dilable									
					Benefits:					
					1-Fitment issues can be avoided & increase productivity				ductivity	
					2-Customer complaint can be avoided					
						KAIZEN SUSTENANCE :				
Why Why Analysis:			Countermeasure & Results:			What to do:				
W1. To Avoid the Fitment			Time can be reduced and customer complaint can be avoided.			Irreversible Kaizen				
W2 .To avoid the custom	er complaint		Result:		+					
Root Cause :					How to do	:				
TOOL DAUGE .			1-Bottom cup and square block offset can be maintained with in limit.			Scope & Plan for Horizontal Deployment				
Registration no. & Date :	Registration no. & Date : 12-Feb-18		2-Straightness of the square block can be maintained		Sr no	Model	Target	Responsibility	Status	
Registration no. & Date :	S.Praveenkun				1		Date			
Manager's Sign :	Sai krishna		2-Time of inspection can be reduced			Stillage	13-02-2018	Operator	Implemented	

Sparklin	E Ø			KAIZEN							
complete solution for material baselling			Dept: Quality		Kaizen No.:						
Cell No.: - 01	Cell Name:	- Project area	Machine: - B3 Side frame assembly fixture Proces	s / Stage : B3 Side frame part fixing			Operation :	Part	Fixing		
Kaizen Theme:			Idea: In order to maintain the rivet hole dimension and hole position poka-yoke on the fixture has been provided to				э.				
Process and Product I	mprovement										
Present status:			COUNTERMEASURE IN PICTORIAL:			KAIZEN	I Stort	10.0	1-2018		
Rivet hole position is checked by using measurement tape.		using measurement tape.	BEFORE AFTER			KAIZEN Start			1-2018		
,	.,					KAIZEN	Finish	11-J	an-18		
2)Hole missing is ensu	red visually				Team Members:						
					1- S.praveenkumar						
Poke-yoke not availa	ible						2-Balvan				
				n							
						Benefits:					
						1-Hole position and hole missing can be ensured					
			Rivet hole position is checked by using measurement tape.	Poke-yoke is provided on the fixture	2-Custo	mer com	plaits can be av	oided .			
			Never note position is checked by using measurement tape.	Poke-yake is provided on the lixture			1211 321 1212				
Why Why Analysis:			Countermeasure & Results: What to do :					TENANCE:			
W1. To Avoid the Fitment i	ssue					Irreversible Kaizen					
W2 .To avoid the customer	complaint		Time can be reduced and customer complaint can be avoide	d.							
VZ .10 avoid the customer	Complaint		Result:		-						
			Result.								
Root Cause :			1- Rivet hole dimension can be maintained with in limit and hole position also ensured.			How to do:					
						So	ope & Plan for Hor	rizontal Deployme	nt		
			2-Time of inspection can be reduced		SIno	Model	Target	Responsibility	Status		
Registration no. & Date :	10.0	1.18					Date				
Registered by :	S.Praveenkur	nar			1	B3 collier	11-01-2018	Operator	Implemented		
Manager's Sign :	Sai krishna										

Sparkline 6			KAIZEN							
complete solution for material handling	Dept: Quality				Kaizen No.:					
Cell No.: - 01 Cell Name:	- Project area	Machine: - B3 base frame assembly fixture Proces	s / Stage : B3 base frame part fixing		Operation :	Part	Fixing			
Kaizen Theme:		Idea: In order to maintain the rivet hole dimension a	nd hole position poka-yoke on the fixture has been	provided to en	sure.					
Process and Product Improvement	t									
Present status:		COUNTERMEASURE IN PICTORIAL:		KΔI	7FN Start	18-01	1-2018			
1) Base frame locking hole position	n is checked by using	BEFORE	AFTER			10-01	1-2010			
measurement tape.				KAI	EN Finish	18-J	an-18			
2)Hole missing is ensured visually				Team Members						
			6	1-S.Praveenkumar						
3)Poke-yoke not available				2-Balvan						
				Benefits:						
					n and hole missing	can be ensure	d			
		Base frame locking hole position is checked by using measurement	Poke-yoke is provided on the fixture	2-Customer of	omplaits can be av	oided/				
		tape.	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		KAIZEN SUS	TENIANIOE -				
Why Why Analysis :		Countermeasure & Results:		What to do :	KAIZEN SUS	TENANCE:				
W1. To Avoid the Fitment issue				Irreversible Kaiz	en					
W2 .To avoid the customer complaint		Time can be reduced and customer complaint can be avoided	d.							
		Result:		1						
Root Cause :		1- Base frame locking hole dimension can be maintained with in limit and hole position also ensured.			How to do:					
		•			Scope & Plan for Ho	rizontal Deployme	nt			
					Target					
		2-Time of inspection can be reduced		SI no Mod	el arget	Responsibility	Status			
Registration no. & Date : 18.0	1.18 PM				Date					
Registered by :	mar			1 B3 col	lier 18-01-2018	Operator	Implemented			
Manager's Sign : Sai krishna										