

POKA-YOKE SHEET

PROBLEM :

HEAD MILLING OPERATION MISSING IN HBFT-384 (M&M)

(2 PCS FOUND AT FINAL PACKING STAGE)

SEC : HUB BOLT

DATE: 09.11.02

IMP : PS,RC,PS

	PREVENT ERROR		SHUTDOWN
		★	CONTROL
★	DETECT ERROR		ALARM

BEFORE

AFTER



No provision on next operation i.e. on stamping press to detect the missed operation



GUIDE WAY is provided in the stamping die to locate the piece from Head milling zone. Without Head milling piece will not rest in the die