

Poka-yoke Sheet

Problem : **Mix-up of Un ground Spgs**

Solution : **Loading and Unloading in grinding**
Machine is isolated
Flap is provided on

Key Improvement **magazine plate for one side loading only**

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Prevent Error

Shutdown

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Control

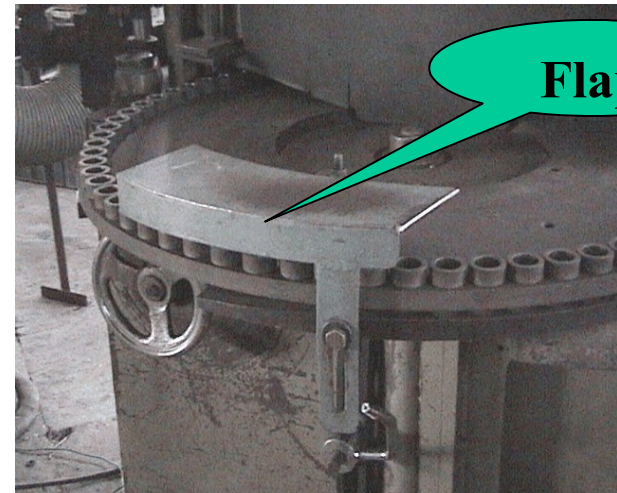
Detect Error

Alarm

Before

After

1. Loading/Unloading by both hands
2. By mistake unground spgs gets mixed in ground springs box



1. Loading at one end only
2. Flap ensure s ground spgs only to get collected