

POKA-YOKE SHEET

PROBLEM: Undersized or oversized gutter

ANALYSIS OF GUTTER SECTION REJECTION

MONTH	INTERNAL REJECTION QTY.		EXTERNAL REJECTION QTY.		REMARKS.
	OVER SIZE	UNDER SIZE	OVER SIZE	UNDER SIZE	
JUL -02	4	—	—	—	CUSTOMER - OTR (NORTH SHORE CANADA)
AUG -02	2	1	—	—	
SEP -02	1	—	—	—	
OCT -02	—	—	1	—	
NOV -02	1	—	—	—	

SOLUTION: Avoid assembly of defective components by 100% check

KEY IMPROVEMENT: Gauge introduced as an integral part of assembly fixture

Before

No Detection of defective components

	Prevent Error		Shutdown
		★	Control
★	Detect Error		Alarm

After

OD CHECKING GAUGE INTRODUCED FOR GUTTER SECTION IN TACK WELDING OPERATION

