

POKA-YOKE SHEET

PROBLEM: Dowel hole position with respect to marking position could not be maintained.

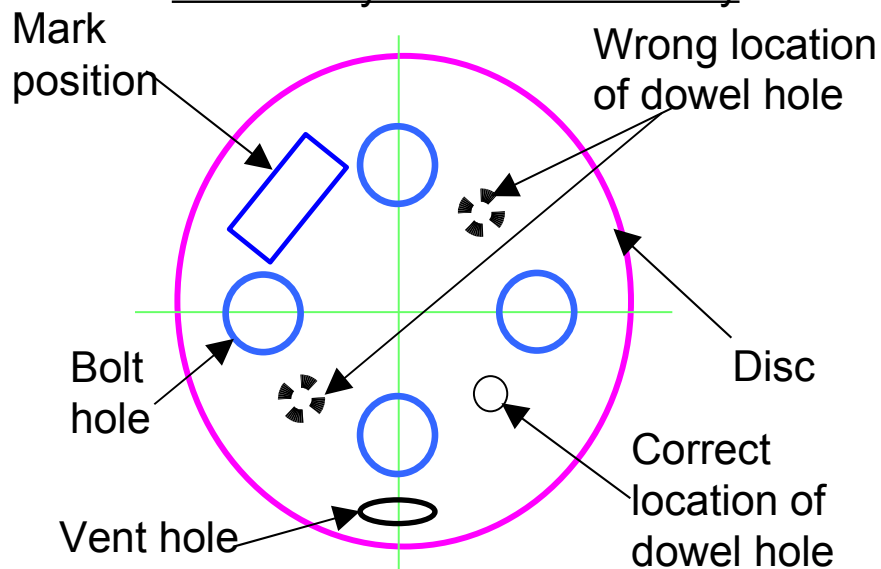
SOLUTION: The dowel hole piercing operation has been shifted from BHP operation which has BH location only, to pierce bore flange down operation in which the marking position is maintained automatically by the nature of tool configuration by both VH and BH location provided

KEY IMPROVEMENT: The operational scrap has been reduced to zero by this modification

*	Prevent Error		Shutdown
		*	Control
	Detect Error		Alarm

Before

Located by bolt hole form only



After



Located by both bolt hole and vent hole form

