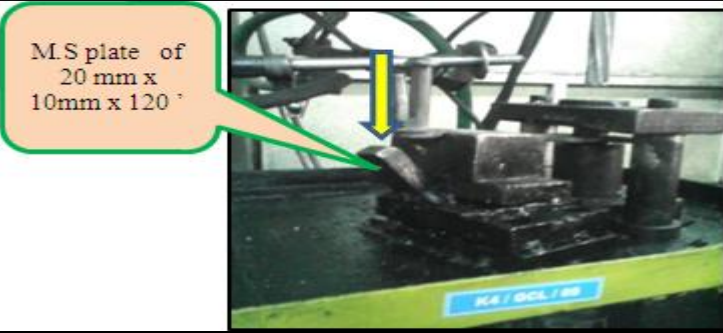
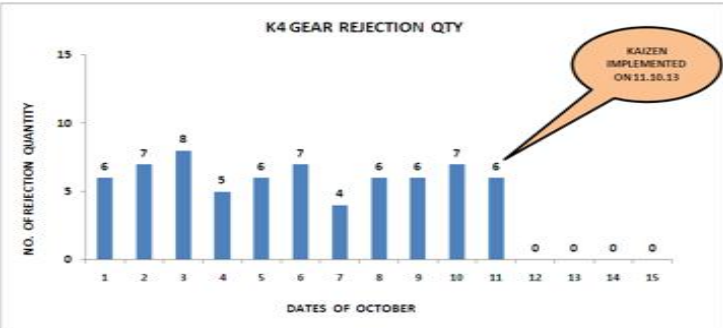


	Equipment :	Reaming	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 1166						
	Department :	Tool / Fixture maint.	Result :	N	P	Q	C	D	S	M							
	Cell :	BPGCL (k4 Gear)	Type :														
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : K4 Gear Reaming														
Kaizen Theme: To eliminate rejection due to part position shift on reaming fixture (K4 gear on K4 Gear reaming st			Idea : To provide pokayoke on K4 gear reaming fixture														
Problem / Present Status			Counter Measure			Benchmark :		12 nos/Day									
rejection of 6-7 nos as burr on boss area of K4 gear due to wrong locating of k4 gear on resting block at reaming stage.			Poka yoke provided on K4 gear reaming fixture of MS plate 20 mm x 10 mm x angle 120° to avoid wrong locating of job.			Target :		zero									
						Start :		11/10/2013		Finished : 12/10/2013							
						Note :											
						Team Members :											
						1. MR. D.S.Gurav		2. MR. A.R Akhare									
						3. MR. A.G.Narkhede		4.									
						5.		6.									
						Benefits											
						Q		To reduce Rejection . Nos 12.00									
Why Why Analysis :			Result :			Kaizen Sustenance :											
W1 : Why part position shift on reaming fixture (K4 gear on K4 Gear reaming stage.) ? A1 : Wrong locating of K4 gear on resting guide block W2 : Why Wrong locating of K4 gear on resting guide block ? A2 : poka W3 : Why poka ? A3 : W4 : A4 :			Eliminate the rejection from 7 Qty to 0. 			What To Do : PM to be done for MS plate dimensions How To Do : MS plate to be checked for dimension of 20 mm x 10 mm x 120° Frequency : monthly											
Root Cause poka						Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>0.00</td> <td>0.00</td> <td>0.00</td> </tr> </table>						Material Cost	Labour Cost	Total	0.00	0.00	0.00
Material Cost	Labour Cost	Total															
0.00	0.00	0.00															
Date : 11/10/2013						Scope & Plan For Horizontal Deployment :											
Registered By : Mr. D M Sonawane						Equipmnet		Target		Status							
Manager's Sign : Mr. Arun Gawali						Discover Gear Reaming		18/11/2013		COMPLETE							
----- Bajaj Auto Ltd. (Fabrication) -----																	