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|--|--------------------|------------------|---|--|---|---|---|--|------------|----|-------------------|------------|---|-------------|-------|--|--|---|-----------|--------|--------|--|--|--|
|  | Equipment : | Notching Machine | Loss Type : | | | | | Defect Loss | | | | | KAIZEN IDEA SHEET | | | | | | | | | | | |
| | Department | Production | Result : | | N | P | Q | C | D | S | M | | | | | | | | | | | | | |
| | | | Type : | | | | | | | | | | | | | | | | | | | | | |
| Cell : | | | Center stand Disco-M | | | | | Operation : | | | | | | | | | | | | | | | | |
| Kaizen Theme: | | | Reduction in IHR at Center Stand (Disco M) Robotic welding Stage | | | | | Idea : | | | | | To make a provision for copleting pipe notching operation in one stroke | | | | | | | | | | | |
| Problem / Present Status | | | Counter Measure | | | | | Benchmark : | | | | | | | | | | | | | | | | |
| Center stand (Disco-M) Robotic welding cell In-House Rejection due to Shabby Welding is more i.e.2%. | | | By changing the process of pipe notching from power press notching operation to hydraulic pipe notching SPM operation | | | | | Target : | | | | | | | | | | | | | | | | |
| | | | | | | | | Start : | 17/01/2013 | | Finished : | 19/04/2013 | | | | | | | | | | | | |
| | | | | | | | | Note : | | | | | | | | | | | | | | | | |
| | | | | | | | | Team Members : | | | | | | | | | | | | | | | | |
| | | | | | | | | 1. | | 2. | | | | | | | | | | | | | | |
| | | | | | | | | 3. | | 4. | | | | | | | | | | | | | | |
| | | | | | | | | 5. | | 6. | | | | | | | | | | | | | | |
| | | | | | | | | Benefits | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | |
| Why Why Analysis : | | | Result : | | | | | Kaizen Sustenance : | | | | | | | | | | | | | | | | |
| W1 : Why In House Rejection at center stand robotic welding stage. (Disco –M/H) ? A1 : Shabby welding at Base Plate with Main Pipe joint & Top Bush with Main Pipe joint. W2 : Gap in Pipe joinery is more than specification i.e. 2-3 mm. A2 : Improper Notching profile to main pipe. W3 : Notching operation was done Manually in Four different stages was done Manually operation (on power press). A3 : No provision for complete operation in single stroke. W4 : A4 : | | | | | | | | What To Do : Tool resharpning frequency to maintained as per define frequency How To Do : Through History card Frequency : Daily Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td></td> <td></td> <td>0</td> </tr> </table> Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td colspan="3"></td> </tr> </table> | | | | | Material Cost | Labour Cost | Total | | | 0 | Equipmnet | Target | Status | | | |
| Material Cost | Labour Cost | Total | | | | | | | | | | | | | | | | | | | | | | |
| | | 0 | | | | | | | | | | | | | | | | | | | | | | |
| Equipmnet | Target | Status | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | | | | | | | | | | | | | | | | | | | | | | | | |
| No provision for complete operation in single stroke. | | | | | | | | | | | | | | | | | | | | | | | | |
| Date : | | | 17/01/2013 | | | | | | | | | | | | | | | | | | | | | |
| Registered By : | | | Mr. Amol Dadpe | | | | | | | | | | | | | | | | | | | | | |
| Manager's Sign : | | | | | | | | | | | | | | | | | | | | | | | | |
| ----- Bajaj Auto Ltd. ----- | | | | | | | | | | | | | | | | | | | | | | | | |