
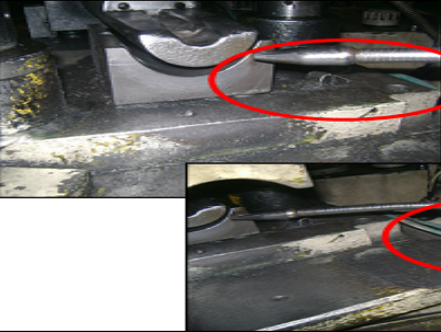
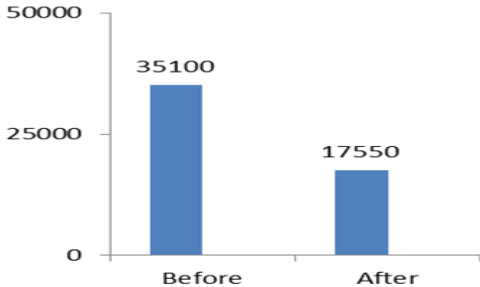
	<b>Equipment :</b>	Humping	<b>Loss Type :</b>	Defect Loss							<b>KAIZEN IDEA SHEET</b>					
	<b>Department</b>	Production	<b>Result :</b>	N	P	Q	C	D	S	M						
			<b>Type :</b>													
<b>Cell :</b> Muffler assly			<b>Operation :</b> Humping													
<b>Kaizen Theme:</b> To Eliminate Inhouse rejection cost of Body Muffler due to dent at Humping machine. ( CT-100 Body Mu			<b>Idea :</b> Cleaning provision for welding spatter while humping. (POKA-YOKE)													
<b>Problem / Present Status</b>			<b>Counter Measure</b>			<b>Benchmark :</b>		312 nos								
More In-House Rejection cost of Body Muffler - @ Rs 45994/Month During process spatter gets deposited in humping die and during humping operation de			Provided Auto cleaning through Air blow. Proximity sensor provided to (sense completion of cycle) sense metal contact after removal of Body Muffler f			<b>Target :</b>		0								
						<b>Start :</b>		10/11/2013		<b>Finished :</b> 18/11/2013						
						<b>Note :</b>										
						<b>Team Members :</b>										
						1. U M MADNE		2. SK CHAVAN								
3. SP SHINDE		4.														
5.		6.														
			<b>Benefits</b>													
			C			Manpoer cost reduced Rs 35100.00										
<b>Why Why Analysis :</b>			<b>Result :</b>			<b>Kaizen Sustenance :</b>										
W1 : Why To Eliminate Inhouse rejection cost of Body Muffler due to dent at Humping machine. ( CT-100 Body Muffler ). ? A1 : Welding spatter got deposited in die W2 : Why Welding spatter got deposited in die ? A2 : No cleaning of die after every cycle W3 : Why No cleaning of die after every cycle ? A3 : No cleaning provision for welding spatter, before humping operation W4 : Why No cleaning provision for welding spatter, before humping operation ? A4 :			Manpower cost reduced  			What To Do : Fixture calibration  How To Do : Point added in Fixture calibration plan.  Frequency : As per plan  <b>Cost Incurred For Making Kaizen :</b> <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>600.00</td> <td>225.00</td> <td>825.00</td> </tr> </table>					Material Cost	Labour Cost	Total	600.00	225.00	825.00
Material Cost	Labour Cost	Total														
600.00	225.00	825.00														
<b>Root Cause</b> No cleaning provision for welding spatter, before humping operation						<b>Scope &amp; Plan For Horizontal Deployment :</b> <table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td>Blanking</td> <td>04/12/2013</td> <td>COMPLETE</td> </tr> </table>					Equipmnet	Target	Status	Blanking	04/12/2013	COMPLETE
Equipmnet	Target	Status														
Blanking	04/12/2013	COMPLETE														
<b>Date :</b> 10/11/2013																
<b>Registered By :</b> Mr. B D Rathod																
<b>Manager's Sign :</b> Mr. D T RANE																
----- Bajaj Auto Ltd. -----																