Kaizen Theme: To Eliminate Inhouse rejection cost of Body Muffler due to dent at Humping machine. (CT-100 Body Idea: Cleaning provision for welcting spatter while humping. (POKA-YOKE) Problem / Present Status Counter Measure Provider National Counter Measure Provider Aud cleaning through Air blow. Benchmark: 312 nos Target:	Cell: Muffle Kaizen Theme: To Eli Mu Problem / Present Status	rassly ninate Inhouse reject		to dent at Humping machine. (CT-100 B	Type :	뻳			Q C	D	S	М	KAIZEN	IDEA SH	IEET			
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During process spatter gets deposited in humping die and during humping operation de contact after removal of Body Muffler f Cell Start: 10/11/2013 Finished: 18/11/2013 Note: Team Members:		st of Body Muffler -	· · · · · · · · · · · · · · · · · · ·			Counter Measure					Benchmark: 312			2 nos				
operation de	During process spatter gets deposited in humping die and during humping								Target: 0			0						
Team Members: U M MADNE										Start : 10/11/2013			Finished :	18/11/	2013			
## 1. U M MADNE 2. SK CHAVAN 3. SP SHINDE 4. 5. 6. 8. ## 1. Why Why Analysis : Result : Wi : 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 W3 : Why No cleaning of die after every cycle A3 : 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 : **Rediag Spatter, before humping operation W4 : Why No cleaning provision for welding spatter, before humping operation A4 : **Rediag Spatter, before humping operation W5 : Why Welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W7 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W7 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W7 : Why No cleaning provision for welding spatter, before humping operation W6 : Why No cleaning provision for welding spatter, before humping operation W7 : Why No cleaning of the structure caliberation W7 : Why N					m .				Note :				•	•				
3. SP SHINDE 4. 5. 6. Why Why Analysis: Will will not be provided a system of the author of the structure									Team Me	mbers	:							
S. G.			A COMMAND						1. U M M	ADNE			2. SK CHAVAN					
Why Why Analysis: We will an any or cost reduced Rs 35100.00 Result: Wind 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 provision for welding spatter, before humping operation? A4: Was part of the after every cycle? A3: No cleaning provision for welding spatter, before humping operation? A4: Root Cause Root Cause Result: Kaizen Sustenance: What To Do: Fixture caliberation What To Do: Point added in Fixture caliberation plan. Frequency: As per plan Cost Incurred For Making Kaizen: Material Cost Labour Cost Total 600.00 225.00 825.00 Scope & Plan For Horizontal Deployment: Equipmet Target Status			0						3. SP SH	INDE			4.					
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Registered By: Mr. B D Rathod			_															
Manager's Sign: Mr. D T RANE																		
D. C. A. C. Lieb	Bajaj Auto Ltd.																	