

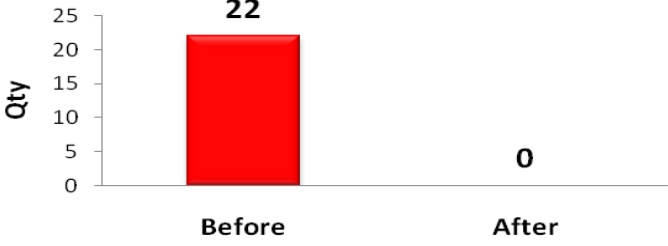
	Equipment :	Welding Machine.	Loss Type :	Defect Loss							KAIZEN IDEA SHEET												
	Department	QA	Result :	N	P	Q	C	D	S	M													
			Type :																				
Cell : KTM muffler fabrication cell.			Operation : Pipe B assy to transfer tube assy welding.																				
Kaizen Theme: To eliminate CC in KTM muff assy - Pipe B length undersize.			Idea : Poka yoke to be provided to arrest incomplete insertion of transfer tube locator.																				
Problem / Present Status		Counter Measure		Benchmark :		22																	
No provision to arrest incomplete insertion of transfer tube locator.		Proximity sensor provided to arrest incomplete insertion of transfer tube assy.		Target :		0																	
				Start :		20/04/2014		Finished :		23/04/2014													
				Note :																			
				Team Members :																			
				1. Mr. D K Thorve		2. Mr. S K Parhad																	
				3. Mr. S R Shaikh		4. Mr. S R More																	
				5.		6.																	
				Benefits																			
				Q		Pipe B length undersize defect eliminated Nos 0.00																	
																							
No provision to arrest incomplete insertion of transfer tube locator.		STOPPER & POKAYOKE SENSOR PROVIDED FOR LOCATING PIN OF PERFORATED TUBE																					
Why Why Analysis :		Result :		Kaizen Sustenance :																			
W1 : Why To eliminate CC in KTM muff assy - Pipe B length undersize. ? A1 : Pipe B length undersize during perforated body to transfer tube assy. W2 : Why Pipe B length undersize during perforated body to transfer tube assy. ? A2 : Transfer tube assy shifted downward side w.r.t tail pipe hole in perforated body assy stage. W3 : Why Transfer tube assy shifted downward side w.r.t tail pipe hole in perforated body assy stage. ? A3 : At transfertube assy stage transfer tube shifted to pipe B side W4 : Why At transfertube assy stage transfer tube shifted to pipe B side ? A4 : Transfer tube locator inserted incompletely.		Pipe B length undersize defect eliminated. <div style="text-align: center;"> CC trend - Pipe Length undersize.  </div>		What To Do : Working of proximity sensor. How To Do : Add in Poka yoke audit chek sheet. Frequency : Daily Cost Incurred For Making Kaizen : <table border="1" style="width: 100%;"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>0.00</td> <td>0.00</td> <td>0.00</td> </tr> </table> Scope & Plan For Horizontal Deployment : <table border="1" style="width: 100%;"> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> <tr> <td> </td> <td> </td> <td> </td> </tr> </table>								Material Cost	Labour Cost	Total	0.00	0.00	0.00	Equipmnet	Target	Status			
Material Cost	Labour Cost	Total																					
0.00	0.00	0.00																					
Equipmnet	Target	Status																					
Root Cause																							
No provision to arrest incomplete insertion of transfer tube locator.																							
Date : 20/04/2014																							
Registered By : Mr. D K Thorve																							
Manager's Sign : Mr Shivakumar																							
----- Bajaj Auto Ltd. -----																							