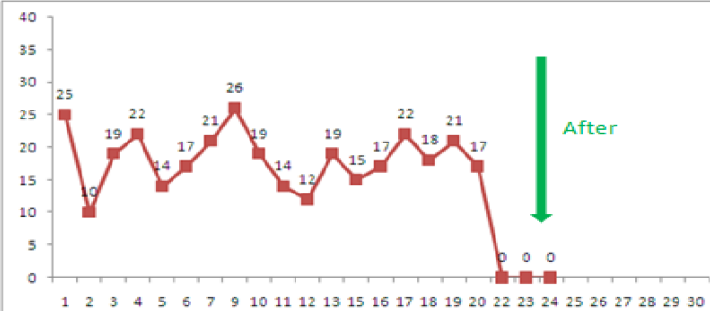
	Equipment :	Piercing M/C	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department	Quality	Result :	N	P	Q	C	D	S	M	
			Type :								
Cell : K1 silencer			Operation : Piercing								
Kaizen Theme: To eliminate IHR of pipe B piercing hole position shift			Idea : Provision in press tool for pipe B stopper resting during piercing operation								
Problem / Present Status			Counter Measure			Benchmark :		35 Nos.			
pipe B hole position shift jobs rejection is high as in press tool no provision for pipe B resting location while piercing.			'C' stopper with pneumatic operating valve added in piercing press tool for pipe B resting to avoid hole position shift & As per drawing.			Target :		zero nos.			
						Start :	15/09/2014	Finished :	22/09/2014		
						Note :					
						Team Members :					
						1. Mr. P K Mule		2. Mr. D S Hanwate			
						3. Mr. S K Shinde		4.			
						5.		6.			
						Benefits					
						C	eliminate rework cost Rs 1250.00				
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why pipe B piercing hole position shift ? A1 : Pipe B and cap weld run burn W2 : Why Pipe B and cap weld run burn ? A2 : Pipe B hole near to weld run W3 : Why Pipe B hole near to weld run ? A3 : No provision in piercing tool for pipe resting during operation W4 : Why No provision in piercing tool for pipe resting during operation ? A4 :			IHR of pipe B hole shift & burn zero 			What To Do : Point added in PM checksheet for stopper and cylinder checking. How To Do : Daily inprocess Audit Frequency : Daily					
Root Cause						Cost Incurred For Making Kaizen :					
No provision in piercing tool for pipe resting during operation						Material Cost		Labour Cost		Total	
						3500.00		500.00		4000.00	
Date : 14/09/2014						Scope & Plan For Horizontal Deployment :					
Registered By : Mr. D M Sonawane						Equipmnet		Target		Status	
Manager's Sign : Mr. Arun Gawali						Piercing M/C		23/09/2014		COMPLETE	
----- Bajaj Auto Ltd. -----											