S DA 1A 1	Equipment :	Piercing M/C		Loss Type :	Defect	Loss									
BAJAJ	Department	Quality		Result :	N	Р	Q	2 C	D	S	М	KAIZE	N IDEA SH	IEET	
Distinctly Ahead				Type :											
Cell : K1 sile	encer		Operation : Piercing												
Kaizen Theme: To elir	minate IHR of pipe E	piercing hole position shift		Idea :	Prov	ision in	pres	s tool for p	ipe B st	opper resti	ng durir	ng piercing opera	tion		
Problem / Present Status			Counter Measure					Benchmark : 3			35 N	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 drowing.					Target : zer			zero	ero nos.			
			pipe b resung to avoid note position shift & As per drowing.						Start : 15/09/2014			Finished : 22/09/2014		2014	
								Note :							
	State of the local division of the local div		14+0.5					Team Members :							
	-							1. Mr. P K Mule			2. Mr. D S Hanwate				
								3. Mr. S K Shinde				4.			
								5.				6.			
								Benefits							
A STATE OF	100 mg	- 14						C eliminate rework cost Rs 1250.00							
	۲	lole position shift hence burn during welding													
Why Why Analysis :			Result :						Kaizen Sustenance :						
W1 : Why pipe B piercing hole position shift ?			IHR of pipe B hole shift & burn zero						What To Do : Point added in PM checksheet for stopper and cylinder checking.						
WI : Why pipe B piercing r								What TO	00.10	nini added i	n Pivi Ci	iecksneet for sto	opper and cyline	der checking.	
A1 : Pipe B and cap weld ru								What TO	00.10	ont added i		iecksneet for sto	opper and cyline	der checking.	
A1 : Pipe B and cap weld ru	un burn												pper and cyline	der checking.	
A1 : Pipe B and cap weld ru	un burn veld run burn ?									ily inproces			pper and cylin	der checking.	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we	un burn veld run burn ? ld run		40										pper and cyline	der checking.	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we	un burn veld run burn ? Id run to weld run ?	g during operation	40 35 30 25 26	22	-				Do : Dai	ily inproces			pper and cyline	Jer Checking.	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in p	un burn veld run burn ? ld run to weld run ? g tool for pipe resting		40 35 - 30 - 76	²² 21 18 17	Afte	r		How To I	Do : Dai cy : Dail	ily inproces	s Audit		pper and cyline	Jer Checking.	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in p	un burn veld run burn ? ld run to weld run ? g tool for pipe resting		$ \begin{array}{c} 40 \\ 35 \\ 30 \\ 25 \\ 25 \\ 19 \\ 19 \\ 19 \\ 19 \\ 19 \\ 19 \\ 19 \\ 19$	²² 21 18 17	Afte	r		How To I Frequence	Do : Dai cy : Dail	ily inproces y for Making	ss Audit Kaizer			otal	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in p	un burn veld run burn ? ld run to weld run ? g tool for pipe resting		$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	²² 21 18 17 0 0	Afte	r		How To I Frequence Cost Inc	Do : Dai cy : Dail urred F	ily inproces ly For Making	ss Audit Kaizer	1 :	T		
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in p	un burn veld run burn ? ld run to weld run ? g tool for pipe resting		$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	²² 21 18 17 0 0 17 18 19 20 22 23	0 1		330	How To I Frequence Cost Inc	Do : Dai cy : Dail urred F aterial C 3500.00	ily inproces	ss Audit Kaizer	a : abour Cost	T	otal	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in p A4 :	un burn veld run burn ? ld run to weld run ? g tool for pipe resting		$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	²² 21 18 17 0 0 17 18 19 20 22 23	0 1		30	How To I Frequence Cost Inc	Do : Dai cy : Dail urred F aterial C 3500.00	ily inproces	Kaizer	abour Cost 500.00	Target	otal 00.00 Status	
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A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in pi A4 : Root Cause No provision in piercing too	un burn veld run burn ? Id run to weld run ? g tool for pipe resting iercing tool for pipe	resting during operation ?	$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	²² 21 ¹⁸ 17 0 0 17 18 19 20 22 23	0 1		30	How To I Frequence Cost Inc Ma Scope &	Do : Dai cy : Dail urred F aterial C 3500.00	ily inproces	Kaizer	abour Cost 500.00	Target	otal 00.00 Status	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in pi A4 : Root Cause No provision in piercing too Date : 14/09/	un burn veld run burn ? ld run to weld run ? g tool for pipe resting iercing tool for pipe	resting during operation ?	$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	²² 21 18 17 0 0 17 18 19 20 22 23	0 1		30	How To I Frequence Cost Inc Ma Scope &	Do : Dai cy : Dail urred F aterial C 3500.00	ily inproces	Kaizer	abour Cost 500.00	Target	otal 00.00 Status	
A1 : Pipe B and cap weld ru W2 : Why Pipe B and cap w A2 : Pipe B hole near to we W3 : Why Pipe B hole near A3 : No provision in piercing W4 : Why No provision in pi A4 : Root Cause No provision in piercing too Date : 14/09/	un burn veld run burn ? ld run to weld run ? g tool for pipe resting iercing tool for pipe l for pipe resting du 2014 M Sonawane	resting during operation ?	$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	²² 21 ¹⁸ 17 0 0 17 18 19 20 22 23	0 1		2 30	How To I Frequence Cost Inc Ma Scope &	Do : Dai cy : Dail urred F aterial C 3500.00	ily inproces	Kaizer	abour Cost 500.00	Target	otal 00.00 Status	