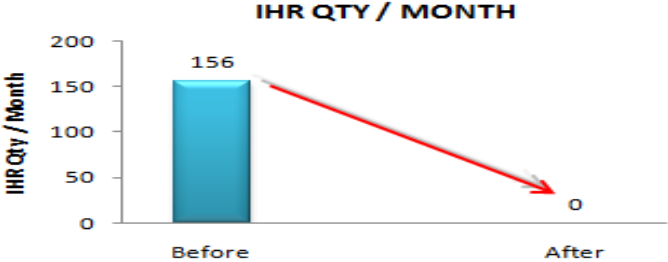
	Equipment :	Collar bush insertion	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2575
	Department :	Production	Result :	N	P	Q	C	D	S	M	
	Cell :	Pipe Bending Cell	Type :								
Unit Name : 100189 - BADVE ENGINEERING LIMITED,			Operation : Collar bush & Flange Insertion								
Kaizen Theme: To Eliminate the IHR of Collar bush damage			Idea : Provision for locating Collar bush and outer pipe								
Problem / Present Status			Counter Measure			Benchmark :		156 nos.			
CT-100 Collar bush , Inner and outer pipe damaged during Collar bush insertion.			Provided Pot magnet on top locator for Collar bush alignment with locator and with this no need to hold the bush during operation and provided Nylon			Target :		0			
						Start :		22/06/2015	Finished : 22/06/2015		
						Note :		done			
						Team Members :					
						1. D N Raut		2. V R Panchal			
						3. Shelke		4. G R Magar			
						5. V K Taley		6. S P Shinde			
						Benefits					
						C	Cost of poor quality reduced Rs 8370.00				
						C	Cost of poor quality reduced Rs 8370.00				
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why CT-100 Collar bush , Inner and outer pipe damaged during Collar bush insertion. ? A1 : Axis of locating block and Collar bush ID, Inner outer pipe are not aligned. W2 : Why Axis of locating block and Collar bush ID, Inner outer pipe are not aligned. ? A2 : No provision for locating Collar bush and outer pipe. W3 : Why No provision for locating Collar bush and outer pipe. ? A3 : No provision for locating Collar bush and outer pipe. W4 : Why No provision for locating Collar bush and outer pipe. ? A4 :			IHR Qty / Month 			What To Do : Daily audit How To Do : Through JH and PM check sheet. Frequency : Daily					
Root Cause No provision for locating Collar bush and outer pipe.						Cost Incurred For Making Kaizen :					
						Material Cost		Labour Cost		Total	
						1230.00		200.00		1430.00	
						Scope & Plan For Horizontal Deployment :					
						Equipmnet		Target	Status		
						(Disco M-100) Line		01/01/2015	PENDING		
----- Bajaj Auto Ltd. (Fabrication) -----											