BASSESSA SERVICE CO.		Outland house by the annut and					т.	Loss Type : Defect Los			_										
× BAJAJ		Collar bush insertion							oss Type :	Detect	t Los	s ——					KAIZEN IDEA SHEET				
Depar	tment :	Production							Result :	N	P Q C D S M										
Cell:		Pipe Bending Cell	T	ype :									Kaizen ID :	2575							
Unit Name : 100189 - BAI	Operation :							Co	Collar bush & Flange Insertion												
Kaizen Theme: To Eliminate	Idea: Provision for locating									ating Collar bush and outer pipe											
Problem / Present Status				Counter Measure							Benchmark: 156 nos					S.					
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				0							
									Start : 22/06/2015					Finished	: 22	/06/201	5				
No provision for Collar holding				that and the same of the same								Note : done									
				Peal				Pot	Pot magnet Provided for self lignment cocating block Provided for elf alignment			Team N	1embei	s:							
								alig				1. D N Raut					2. V R Panchal				
					Lo	3. Shelke							4. G R Magar								
						5. V K Taley 6. S						S P Shinde									
	Clamp provided for pipe					-	Benefits														
									C Cost of poor quality reduced Rs 8370.00												
55								C Cost of poor quality reduced Rs 8370.00													
	holding																				
Why Why Analysis :				Result:							Kaizen Sustenance :										
Collar bush insertion. ?				IHR Qty / Month							What To Do : Daily audit										
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.?				IHR QTY / MONTH								How To Do: Through JH and PM check sheet.									
A2 : No provision for locating Collar bush and outer pipe.				200 7																	
W3 : Why No provision for locating Collar bush and outer pipe. ?				156 W W 100 - 156 W W 100 - 156 W W 150 W W						Frequency : Daily											
A3: No provision for locating Collar bush and outer pipe.												Cost Incurred For Making Kaizen :									
W4 : Why No provision for locating Collar bush and outer pipe. ?				ੈ '							N	1aterial	Cost L		Lab	Labour Cost		Total			
A4 :	- 0							0			1230.	00	200		00.00		1430.00				
	Before					After			Scope & Plan For Horizontal Deploy					ment :							
D1 O										Eq	uipmne	ŧ		Target		Status					
Root Cause No provision for locating Collar bush and outer pipe.										(Disco	M-100)					01/01/201	_	NDING			
	on and outer pip												,						•		
Date : 22/06/2015																					
Registered By: Mr. B D Rath																					
Manager's Sign: Mr. D T RAN																					
Bajaj Auto Ltd. (Fabric	ation)	-																			