| × | Equipment : | SPM -Head pipe stopper v | Loss Ty | /pe : | Defect | t Lo | ss | | | | | KAIZEN IDEA SHEET | | | | | |
|--|--|--|--|-------------|--|--------------|--------|---|---------------------|-----------------------|------------|---|----------------------|------------------|---|--|--|
| | | QA | | | | | _ | | Τ. | D S | | | - RAIZEIN IDEA SITEE | | ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, | | |
| | | Frame fabrication D105 | | Result : | : | IN | F | Q | С | | 5 | М | 1 / | oizon ID + 26 | 20 | | |
| | 3 - Metalman Auto Pvt | | | |))nora | ration : | | lead pipe | stoppo | r woldin | a SDN | | | Kaizen ID : 2620 | | | |
| | | | | | • | | | | stoppe | weiuiii | y - 3FN | /I. | | | | | |
| Kaizen Theme: To pre- | event defect of head pip | pe stopper bkt missing in D | 105 frame. | : F | Provisi | ion for | inte | rlocking. | | | | | | | | | |
| Problem / Present Status | | | Counter Measure | | | | | Benchmark: 5 | | | | | | | | | |
| Head pipe stopper welding operation on SPM so one side welding missing during welding & customer complaint happen frequently. | | | Head pipe stopper both side welding interlocked with operation by PLC. | | | | | Target: 0 | | | | | | | | | |
| | | | | | | | | Start : 10/04/2015 | | | Finished : | 22/04/ | 2015 | | | | |
| | | | | | | | | Note : Interlocking poka fo | | | | poka for l | bkt missing. | | | | |
| | | | | | | | | Team Members : | | | | | | | | | |
| | | | | | | | | 1. Mr.Salunke P.A | | | | | 2. Mr.Nikhade M.L | | | | |
| | | | | | | | | 3. Mr.Lade D.S | | | | | 4. Mr.Rathod R.B | | | | |
| | | | | | | | | 5. Mr.Khairnar R.V | | | | | 6. | | | | |
| | | | | | | | | Benefi | ts | | | | | | | | |
| | | | | | | | | Q 1. Customer complaint PPM reduced from 250 PPM to "Zero" . 2. IHR reduced 1240 PPM to "Zero". Rs 27000.00 | | | | | | | | | |
| | | | | | | | | | | | | | | | | | |
| Why Why Analysis : | | | Result: | | | | | | Kaizen Sustenance : | | | | | | | | |
| W1 : Why Stg.lock difficult in D105 vehicle. ? | | | 1. Customer complaint reduced from 250 PPM to "Zero" PPM. 2. Rejection qty. reduced from 05 frame to "Zero". | | | | | What To Do: By JH/PM of SPM / Kaizen & Poka yoke check sheet. | | | | | | | | | |
| A1 : Head pipe stopper bkt r | missing. | | rqty. reduced from 05 frame to 2ero . | | | | | | | | | | | | | | |
| | er bkt missing. ? | | | | | | How To | How To Do : By Audit | | | | | | | | | |
| W2 : Why Head pipe stoppe | | A2 : Tack welding & full welding operation on SPM but not interlocked. | | | x Tow to be . By Addit | | | | | | | | | | | | |
| | ding operation on SPN | If but not interlocked. | × | | | | | | | | | | | | li di | | |
| A2 : Tack welding & full weld W3 : Why Tack welding & fu | | | × | | | | | | | | | | | | | | |
| A2 : Tack welding & full weld W3 : Why Tack welding & fu | ull welding operation o | n SPM but not | × | | | | | Freque | ncy : Da | aily / We | ekly | | | | | | |
| A2 : Tack welding & full welding & full welding & full welding & full full full full full full full fu | ull welding operation of missed during manufa | n SPM but not | × | | | | | Freque | | | | aizen : | | | | | |
| A2 : Tack welding & full weld W3 : Why Tack welding & fu interlocked. ? A3 : Interloacking provision | ull welding operation of missed during manufa | n SPM but not | × | | | | | Cost Ir | | For Ma | | | ur Cost | Т | otal | | |
| A2 : Tack welding & full weld W3 : Why Tack welding & fu interlocked. ? A3 : Interloacking provision W4 : Why Interloacking prov | ull welding operation of missed during manufa | n SPM but not | × | | | | | Cost Ir | curred | For Ma | | Labou | ur Cost | | otal 00.00 | | |
| A2 : Tack welding & full weld W3 : Why Tack welding & fu interlocked. ? A3 : Interloacking provision W4 : Why Interloacking prov | ull welding operation of missed during manufa | n SPM but not | × | | | | | Cost Ir | Material | For Ma Cost | king K | Labou | 00.00 | | _ | | |
| A2: Tack welding & full weld W3: Why Tack welding & fu interlocked. ? A3: Interloacking provision W4: Why Interloacking prov A4: No provision | ull welding operation of missed during manufa | n SPM but not | × | | | | | Cost Ir | Material | For Ma Cost 00 For Ho | king K | Labou 650 I Deployr | 00.00 | | _ | | |
| A2 : Tack welding & full weld W3 : Why Tack welding & fu interlocked. ? A3 : Interloacking provision W4 : Why Interloacking prov | ull welding operation of missed during manufa | n SPM but not | × | | | | | Cost Ir | Material 8000.0 | For Ma Cost 00 For Ho | king Ka | Labou 650 I l Deployr t | 00.00 ment : | 145 Target | 00.00 | | |
| A2: Tack welding & full weld W3: Why Tack welding & full interlocked.? A3: Interloacking provision W4: Why Interloacking prov A4: No provision Root Cause No provision | ull welding operation on missed during manufaction manufaction missed during manufaction missed during manufaction of missed during missed during manufaction of missed during manufaction of missed during misse | n SPM but not | × | | | | | Cost Ir | Material 8000.0 | For Ma Cost 00 For Ho | king Ka | Labou 650 I l Deployr t | 00.00 ment : | 145 Target | 00.00 Status | | |
| A2: Tack welding & full weld W3: Why Tack welding & full interlocked.? A3: Interloacking provision W4: Why Interloacking prov A4: No provision Root Cause No provision Date: 10/07/2 | ull welding operation of missed during manufaction manufaction missed during missed during missed during missed during missed during missed miss | n SPM but not | × | | | | | Cost Ir | Material 8000.0 | For Ma Cost 00 For Ho | king Ka | Labou 650 I l Deployr t | 00.00 ment : | 145 Target | 00.00 Status | | |
| A2: Tack welding & full weld W3: Why Tack welding & full interlocked.? A3: Interloacking provision W4: Why Interloacking prov A4: No provision Root Cause No provision | ull welding operation of missed during manufaction manufaction missed during missed during missed during missed during missed during missed miss | n SPM but not | × | | | | | Cost Ir | Material 8000.0 | For Ma Cost 00 For Ho | king Ka | Labou 650 I l Deployr t | 00.00 ment : | 145 Target | 00.00 Status | | |