
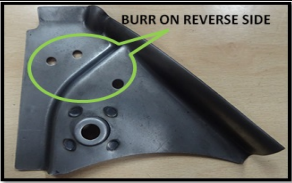
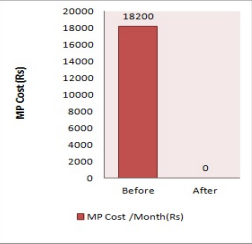
	Equipment :	Piercing Tool	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2692
	Department :	Purchase	Result :	N	P	Q	C	D	S	M	
	Cell :	K1 Line	Type :								
Unit Name : 112236 - BADVE ENGINEERING LIMITED. (2 Wh Waluj), Aurangabad			Operation : Welding								
Kaizen Theme: To reduce cost of poor quality.			Idea :								
Problem / Present Status		Counter Measure		Benchmark :		5					
HP Gusset DH161078/79 Piercing hole ø 6 & 7 mm found heavy burr after piercing operation results into CC & cost of poor quality		By adding add-on tool for piercing hole burr position changed. (Reverse/opposite side)		Target :		0					
				Start :		14/04/2015		Finished :		06/07/2015	
				Note :							
				Team Members :							
				1. Mr. T.S Nannaware		2. Mr. S.D. Gakwad					
				3. Mr. S. V. Gaikwad		4. Mr. A.D. Borude					
				5. Mr. V.R. Pande		6.					
				Benefits							
				C		Cost of poor quality saved Rs 0.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Heavy burr at ø 6 & 7 mm piercing hole. A1 : Manual operation - Deburring is required to remove burr. W2 : Why Manual operation - Deburring is required to remove burr. ? A2 : After De-burring burr folds into piercing three holes. W3 : Why After De-burring burr folds into piercing three holes. ? A3 : Due to folded burr in hole ø 6 & 7 I.D. undersized results into difficult fitment at Bajaj Auto line. W4 : Why Due to folded burr in hole ø 6 & 7 I.D. undersized results into difficult fitment at Bajaj Auto line. ? A4 :		Cost of poor quality reduced 		What To Do : Point added in Tool/Fixture P.M.check sheet. How To Do : Thru PM Frequency : Daily							
Root Cause Due to folded burr in hole ø 6 & 7 I.D. undersized results into difficult fitment at Bajaj Auto line.				Cost Incurred For Making Kaizen :							
Date : 14/04/2015				Material Cost		Labour Cost		Total			
Registered By : Mr. A S Pawar				6750.00		18200.00		24950.00			
Manager's Sign : Mr. D T RANE				Scope & Plan For Horizontal Deployment :							
				Equipmnet		Target		Status			
----- Bajaj Auto Ltd. (Fabrication) -----											