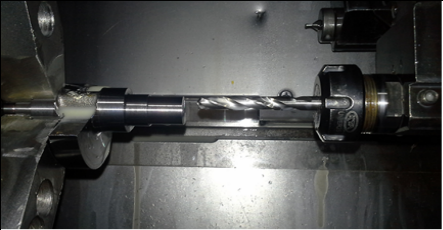
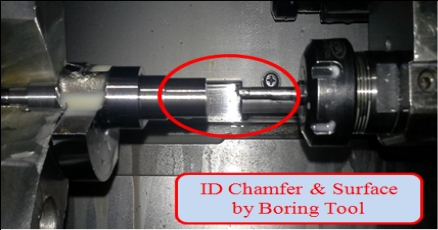

	Equipment :	CNC	Loss Type :	Material loss							KAIZEN IDEA SHEET Kaizen ID : 2701												
	Department :	PRODUCTION	Result :	N	P	Q	C	D	S	M													
	Cell :	CNC	Type :																				
Unit Name : KAP ENGINEERING, Pune			Operation : CNC 2nd Operation																				
Kaizen Theme: To Eliminate the Grinding Problem & ID Surface not Ok due to id drilling problem			Idea : ID Drilling & finishing by Boring Bar instead of Drill																				
Problem / Present Status		Counter Measure			Benchmark :																		
Surface Finish not OK Uneven ID chamfer on Dia.8.5 Causes Problem in Grinding Operation		OK Surface Finish Variation in ID Chamfer eliminated No Quality Issues in Grinding			Target :		Zero Rejection																
		 <div>ID Chamfer & Surface by Boring Tool</div>			Start :		20/03/2015		Finished :		20/03/2015												
					Note :																		
					Team Members :																		
					1. Mr. Mohnish Suri		2. Mr. George																
					3. Mr. Shankar		4.																
5.		6.																					
Benefits																							
Q		ID Chamfer,ID Surface & OD to ID Concentricity achieved to OK Rs 0.00																					
Why Why Analysis :		Result :			Kaizen Sustenance :																		
W1 : Grinding Rejection A1 : Center not ok W2 : Why Center not ok ? A2 : ID Chamfer not OK W3 : Why ID Chamfer not OK ? A3 : Tool used as Drill W4 : Why Tool used as Drill ? A4 :		Good Quality Result in Grinding 			What To Do : Daily Inprocess Inspection How To Do : As per Frequency Frequency : after every one hr Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>0.00</td><td>0.00</td><td>0.00</td></tr></table> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td colspan="3"></td></tr></table>							Material Cost	Labour Cost	Total	0.00	0.00	0.00	Equipmnet	Target	Status			
Material Cost	Labour Cost	Total																					
0.00	0.00	0.00																					
Equipmnet	Target	Status																					
Root Cause Tool used as Drill																							
Date : 08/09/2015																							
Registered By : Mr. Mohit Suri																							
Manager's Sign : Mr. Mohit Suri																							
----- Bajaj Auto Ltd. (Forging and Machining) -----																							