

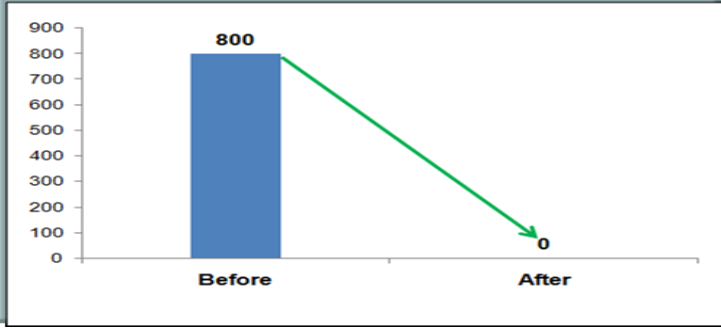
	Equipment :	Leakage Testing Machine	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2718
	Department :	Production	Result :	N	P	Q	C	D	S	M	
	Cell :	Pipe Bending Cell	Type :								
Unit Name : 100189 - BADVE ENGINEERING LIMITED,			Operation : Pipe Leakage Testing								
Kaizen Theme: To Eliminate the IHR for pipe A assembly welding crack due to less natural cooling time.			Idea : POKAYOKE								
Problem / Present Status			Counter Measure			Benchmark :		800			
During Inner pipe ring round welding,after welding process immediately leakage testing process is followed due to which crack has been obser. at next			Locking cylinder (Sensor) locks the Pipe inside the stand & proximity sensor will open the gate only after 33 nos.natural cooling time 8 to 9 min.			Target :		0			
						Start :		18/01/2015		Finished : 25/01/2015	
						Note :					
						Team Members :					
						1. Mr.V.K.Taley			2. Mr.G.R. Magar		
						3. Mr.R.A.Kale			4. Mr. D. N. Raut		
						5. Mr. S. P. Shinde			6.		
						Benefits					
						C		Rejection cost reduced by Rs 75000.00			
						Q		IHR Reduced. Nos 800.00			
						P		Productivity improved Nos 0.00			
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why Ring to inner pipe round welding leakage. ? A1 : Ring to inner pipe welding crack. W2 : Why Ring to inner pipe welding crack. ? A2 : Welding joint strength reduced. W3 : Why Welding joint strength reduced. ? A3 : Immediate cooling after ring round welding. W4 : Why Immediate cooling after ring round welding. ? A4 : o provision for natural cooling.			IHR Qty / Monthly 			What To Do : Working of master cylinder & proximity sensor How To Do : Through PM POKAYOKE check sheet Frequency : Daily Pokayoke Audit					
Root Cause POKA						Cost Incurred For Making Kaizen :					
Date : 17/09/2015						Material Cost		Labour Cost		Total	
Registered By : Mr. B. R. Kangre						1500.00		500.00		2000.00	
Manager's Sign : Mr. D T RANE											
----- Bajaj Auto Ltd. (Fabrication) -----						Scope & Plan For Horizontal Deployment :					
						Equipmnet		Target		Status	
						Res. Box Leakage Testing		16/03/2015		COMPLETE	