
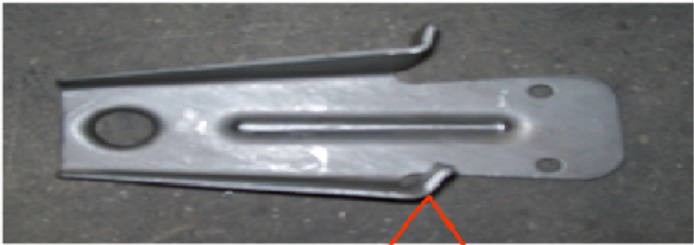
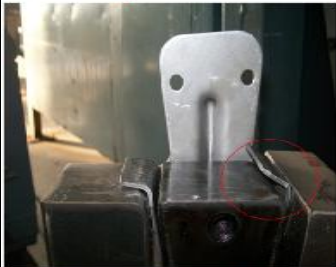




| | | | | | | | | | | | | | | | | | | |
|---|---------------------|-------------------|--|--|-------------|--|---|---|---|----------|-------------------|---|---------------|-------------|-------|------|------|------|
|  | Equipment : | Press machine die | Loss Type : | | Defect Loss | | | | | | | KAIZEN IDEA SHEET Kaizen ID : 2731 | | | | | | |
| | Department : | Maintenance | Result : | | N | P | Q | C | D | S | M | | | | | | | |
| | Cell : | Tool maintenance | Type : | | | | | | | | | | | | | | | |
| Unit Name : | | | 100264 - RUCHA ENGINEERING PVT LTD., Aurangabad | | | Operation : | | | | | | | Forming | | | | | |
| Kaizen Theme: | | | QUALITY IMPROVEMENT | | | Idea : | | To provide housing and guide pillar bush to pad | | | | | | | | | | |
| Problem / Present Status | | | Counter Measure | | | Benchmark : | | 850 | | | | | | | | | | |
| Collar not right angle in CBM tool | | | To Provide Housing & Guide Pillar Bush | | | Target : | | 0 | | | | | | | | | | |
| | | | | | | Start : | | 16/07/2015 | | | Finished : | | 17/07/2015 | | | | | |
|  <p>Collar not right angle in CBM</p> | | | <p>Before Improvement</p>  <p>One Extra operation done separate for Collar Right Angle.</p> <p>After Improvement</p>  <p>Collar Right Angle In This Operation in one Die.</p> | | | Note : | | | | | | | | | | | | |
| | | | | | | Team Members : | | | | | | | | | | | | |
| | | | | | | 1. Tool maintenance tea | | 2. | | | | | | | | | | |
| | | | | | | 3. | | 4. | | | | | | | | | | |
| | | | | | | 5. | | 6. | | | | | | | | | | |
| | | | | | | Benefits | | | | | | | | | | | | |
| | | | | | | P | | Production per hour Nos 750.00 | | | | | | | | | | |
| | | | | | | C | | Per day one operator cost saved Rs 7800.00 | | | | | | | | | | |
| | | | | | | D | | lead time decreased in sec Nos 5.00 | | | | | | | | | | |
| Why Why Analysis : | | | Result : | | | Kaizen Sustenance : | | | | | | | | | | | | |
| W1 : Why Collar not right angle in CBM tool ? A1 : Due to load is on one side of pad W2 : Why Due to load is on one side of pad ? A2 : Pad goes one side during collar forming W3 : Why Pad goes one side during collar forming ? A3 : No housing to pad and guide pillar bush W4 : Why No housing to pad and guide pillar bush ? A4 : Not consider in tool design | | | Zero loss sustained  | | | What To Do : Updated JH/PM check sheet For visual inspection. How To Do : Use JH/PM sheet Frequency : Daily Cost Incurred For Making Kaizen : <table border="1"> <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> | | | | | | | Material Cost | Labour Cost | Total | 0.00 | 0.00 | 0.00 |
| Material Cost | Labour Cost | Total | | | | | | | | | | | | | | | | |
| 0.00 | 0.00 | 0.00 | | | | | | | | | | | | | | | | |
| Root Cause | | | | | | Scope & Plan For Horizontal Deployment : | | | | | | | | | | | | |
| Not consider in tool design | | | | | | Equipmnet | | Target | | Status | | | | | | | | |
| | | | | | | 191/192 pier tool | | 24/07/2015 | | COMPLETE | | | | | | | | |
| Date : | | | 16/07/2015 | | | | | | | | | | | | | | | |
| Registered By : | | | Mr. Amol Girme | | | | | | | | | | | | | | | |
| Manager's Sign : | | | Mr.R S Makasare | | | | | | | | | | | | | | | |
| ----- Bajaj Auto Ltd. (Fabrication) ----- | | | | | | | | | | | | | | | | | | |