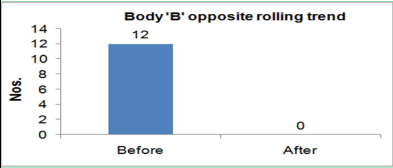


	Equipment :	D-130	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2736												
	Department :	PRODUCTION SILENCER	Result :	N	P	Q	C	D	S	M													
	Cell :	K1 Silencer	Type :																				
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Body B Rolling																				
Kaizen Theme: To Prevent IHR of opposite body 'B' rolling.			Idea : Easy to maintain exact piercing by both side guide pin stopper.																				
Problem / Present Status		Counter Measure			Benchmark :		12 NOS																
Daily 10-12 qty reject on D-130 stage for body 'B' opposite rolling.		To provide Stopper from both side with respect to locating pin provided to avoid cross rolling & opposite rolling. Also provision made on base plate f			Target :		zero																
					Start :		04/03/2015		Finished :		06/03/2015												
					Note :																		
					Team Members :																		
					1. Mr.S N Sondekar		2. Mr.S B Talap																
					3. Mr.T N Bhujbal		4.																
5.		6.																					
Benefits																							
P		PU roller utilization increased by 25 %. Nos 0.00																					
Q		HR reduced to Zero. Nos 0.00																					
C		25% Cost of PU roller save. Rs 0.00																					
Why Why Analysis :		Result :			Kaizen Sustenance :																		
W1 : Why To Prevent IHR of opposite body 'B' rolling. ? A1 : Opposite rolling of body 'B' W2 : Why Opposite rolling of body 'B' ? A2 : Body B blank can locate in opposite direction in fixture. W3 : Why Body B blank can locate in opposite direction in fixture. ? A3 : Only 1 Guide pin provided to guide piercing hole. W4 : Why Only 1 Guide pin provided to guide piercing hole. ? A4 : Difficult to maintain exact piercing by 1 guide pin.		Eliminate IHR of Body 'B' opposite rolling. 			What To Do : Stopper wear out condition to be check How To Do : By weekly PM Frequency : WEEKLY Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>500.00</td><td>300.00</td><td>800.00</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	500.00	300.00	800.00	Equipmnet	Target	Status			
Material Cost	Labour Cost	Total																					
500.00	300.00	800.00																					
Equipmnet	Target	Status																					
Root Cause Difficult to maintain exact piercing by 1 guide pin.																							
Date : 15/10/2015																							
Registered By : Mr. D M Sonawane																							
Manager's Sign : Mr. Arun Gawali																							
----- Bajaj Auto Ltd. (Fabrication) -----																							