

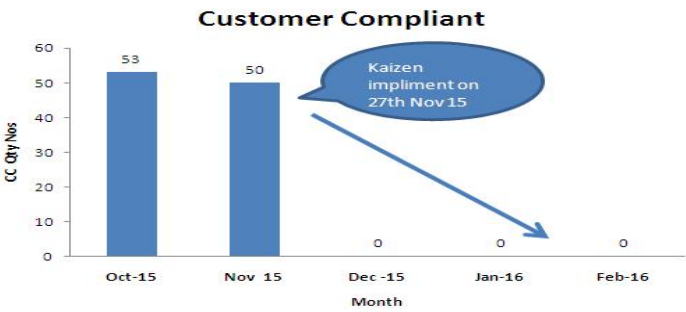
	Equipment :	Tail pipe assy welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2780						
	Department :	Silencer shop	Result :	N	P	Q	C	D	S	M							
	Cell :	PD SILENCER	Type :														
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Manual Welding														
Kaizen Theme: To Eliminate customer compliant of end cap fitment			Idea : Provide full proof location for orientation of tail pipe														
Problem / Present Status		Counter Measure		Benchmark :		53 nos											
On PD Sil tail pipe variation in tail pipe to baffle assy welding stage . at the time of final end cap fitment is improper so in the month of Oct 15 ,		Provided orientation pin in piercing hole in order to get correct orientation of tail tube wrt baffle.Modifying the design and provided pneumatic loca		Target :		zero											
				Start :		28/11/2015		Finished :		06/04/2016							
				Note :													
				Team Members :													
				1. Mr.Y.B.Mainkar		2. Mr.S. Vanky											
				3. Mr.S.B.Talap		4.											
5.		6.															
				Benefits													
				P	Production increased by 53 Nos Nos 0.00												
				Q	IHR PPM reduced by100 % Rs 0.00												
				C	Cost of rework saved (Rs. 400/shift) Rs 0.00												
Why Why Analysis :		Result :		Kaizen Sustenance :													
W1 : Why To Eliminate customer compliant of end cap fitment ? A1 : Rejection at BAL -C due to end cap fitment . W2 : Why Rejection at BAL -C due to end cap fitment . ? A2 : Tail pipe length variation W3 : Why Tail pipe length variation ? A3 : Tail pipe wrong orientation while positioning W4 : Why Tail pipe wrong orientation while positioning ? A4 : No full proof location for orientation of tail pipe		To Eliminate the Customer Compliant from 53 Nose to Zero 		What To Do : In process & first piece audit How To Do : Daily check First piece 2) Daily check by prod. & Quality In process audit . Frequency : Daily													
Root Cause No full proof location for orientation of tail pipe				Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>300.00</td> <td>700.00</td> <td>1000.00</td> </tr> </table>								Material Cost	Labour Cost	Total	300.00	700.00	1000.00
Material Cost	Labour Cost	Total															
300.00	700.00	1000.00															
Date : 26/11/2015 Registered By : Mr. D M Sonawane Manager's Sign : Mr. Arun Gawali				Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td colspan="3"> </td> </tr> </table>								Equipmnet	Target	Status			
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----- Bajaj Auto Ltd. (Fabrication) -----																	