

✘	Equipment :	Drilling M/c	Loss Type : Defect loss					KAIZEN IDEA SHEET							
	Department :	QA	Result :									N	P	Q	C
	Cell :	M/C Shop	Type :												
Unit Name : S B R Auto Component, Rudrapur			Operation : To solve drill dia. undersize problem												
Kaizen Theme: To solve drill dia. undersize problem			Idea : Drilling process to be change & fixture to be modify for detection												
Problem / Present Status			Counter Measure					Benchmark :		zero					
8.2 dia. undersize in case upper (0682-case upper)			Direct drilling process divide into 2 process 1-drilling 7mm 2-Reamer 8.3 mm used Modification had done in fixture for 100% detection.					Target :		Zero					
								Start :		19/10/2015		Finished :		20/10/2015	
								Note :							
Why Why Analysis :			Result :					Team Members :							
W1 : Why 8.2 dia. undersize in case upper (0682-case upper) ? A1 : During drilling slit 3.5 mm regain its shapes causes dia undersize W2 : Why During drilling slit 3.5 mm regain its shapes causes dia undersize ? A2 : Due to direct drilling of dia 8.2 mm in case upper W3 : Why Due to direct drilling of dia 8.2 mm in case upper ? A3 : W4 : A4 :			1-Drill dia ok after 8.3 reaming process used . 2-fixutre had been modified for ensuring 100% drill dia. 3-Zero customer complaint					1. Veer Vikram Singh		2. Sachin Saini					
Root Cause Due to direct drilling of dia 8.2 mm in case upper			✘					Benefits		Q Zero customer complaint Nos 0.00					
								Kaizen Sustenance :		What To Do : poka yoke check sheet update					
Date : 17/10/2015								How To Do :		Poka yoke check point checking on daily basis					
Registered By : Vineet Grover								Frequency :		Daily Basis					
Manager's Sign : Keshav Kumar Koundal								Cost Incurred For Making Kaizen :							
								Material Cost		Labour Cost		Total			
								0.00		0.00		0.00			
								Scope & Plan For Horizontal Deployment :							
								Equipmnet		Target		Status			
								0681-case upper		16/05/2016		PENDING			
----- Minda Corporation Ltd. - Rudrapur Plant -----															