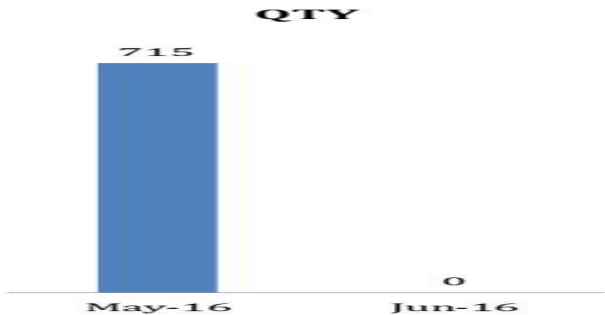


	Equipment :	PRESS MACHINE	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2988												
	Department :	QUALITY	Result :	N	P	Q	C	D	S	M													
	Cell :	INWARD QUALITY	Type :																				
Unit Name : 100189 - BADVE ENGINEERING LIMITED,			Operation : Piercing operation on press M/c																				
Kaizen Theme: 1.Piercing die grinding frequency reset from 8000 nos to 6000 nos			Idea : 1. Piercing die plate grinding frequency reset from 8000 No's to 6000 No's																				
Problem / Present Status		Counter Measure			Benchmark :																		
Burr ,Damage and Dent found in flange.		Piercing die plate grinding frequency reset from 8000 No's to 6000 No's			Target :																		
					Start :		21/02/2017		Finished :		21/02/2017												
					Note :																		
					Team Members :																		
					1. Rameshwar Phate		2. Sadashiv Khare																
3. Ashwini Jagtap		4. Shraddha Suste																					
5.		6.																					
Benefits																							
Q		No burr, no dent damage Nos 0.00																					
Why Why Analysis :		Result :			Kaizen Sustenance :																		
W1 : Burr,Damage and Dent inside the id flange. A1 : Load of the shearing gate shifted W2 : Why Load of the shearing gate shifted ? A2 : Mismatch of the punch. W3 : Why Mismatch of the punch. ? A3 : Alignment of the punch disturbed. W4 : Why Alignment of the punch disturbed. ? A4 : Alignment of the punch disturbed.		Rejection reduced 			What To Do : 4s flange pearcing die plate replaced. How To Do : Piercing die plate grinding frequency reset from 8000 No's to 6000 No's Frequency : 8000 No's to 6000 No's Cost Incurred For Making Kaizen : <table><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> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td>Hyd Press for Disco-M Flange</td><td>25/07/2017</td><td>COMPLETE</td></tr></table>							Material Cost	Labour Cost	Total	0.00	0.00	0.00	Equipmnet	Target	Status	Hyd Press for Disco-M Flange	25/07/2017	COMPLETE
Material Cost	Labour Cost	Total																					
0.00	0.00	0.00																					
Equipmnet	Target	Status																					
Hyd Press for Disco-M Flange	25/07/2017	COMPLETE																					
Root Cause Alignment of the punch disturbed.																							
Date : 21/02/2017																							
Registered By : Mr. B. R. Kangre																							
Manager's Sign : Mr. D T RANE																							
----- Bajaj Auto Ltd. (Fabrication) -----																							