

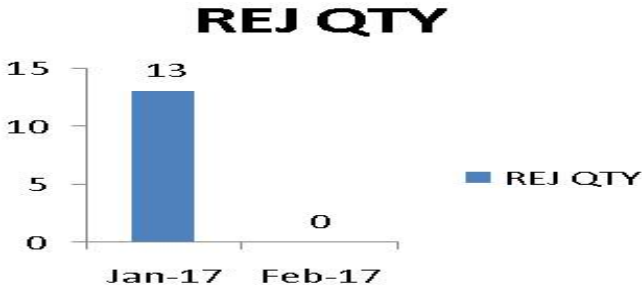
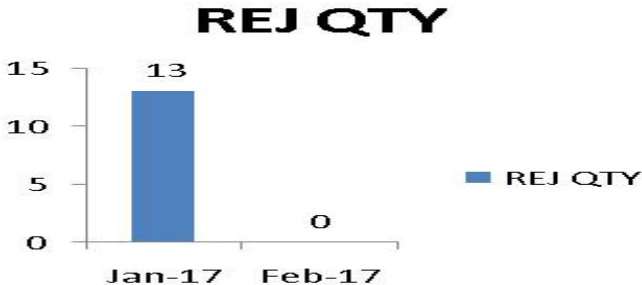
	Equipment :		Loss Type :	Defect Loss							<b>KAIZEN IDEA SHEET</b>  <b>Kaizen ID : 2989</b>			
	Department :	quality	Result :	N	P	Q	C	D	S	M				
	Cell :	inward quality	Type :											
Unit Name : 100189 - BADVE ENGINEERING LIMITED,			Operation : Piercing operation on press M/c											
Kaizen Theme: PIERCING SCRAP INSIDE THE NIPPLE WITH PIPE ASSLY.			Idea : a pokayke is made in pipe and nipple welding stage is that the pin is provided at welding stage so that if scrap is present in pipe then pipe will not											
Problem / Present Status			Counter Measure				Benchmark :							
burr present inside the nipple assly.			EARLIER THE FREQUENCY TO RESHARPENING THE PUNCH WAS 15000 AND NOE FREQUENCY IS REDUCE TO 12000 PM SHEET.				Target :							
							Start :		22/02/2017		Finished :		22/02/2017	
							Note :							
							Team Members :							
							1. Ashwini Jagtap      2. Rameshwar Phate 3. Sadashiv Khare      4. Shraddha Suste 5.                              6.							
Why Why Analysis :			Result :				Kaizen Sustenance :							
W1 : Why piercing scrap inside the nipple assly. ? A1 : piercing scrap present inside nipple assly. W2 : Why piercing scrap present inside nipple assly. ? A2 : piercing scrap not removed from pipe. W3 : Why piercing scrap not removed from pipe. ? A3 : piercing not done properly. W4 : Why piercing not done properly. ? A4 : piercing punch wear out.			PIERCING SCRAP REMOVED PROPERLY.  				What To Do : EARLIER THE FREQUENCY TO RESHARPENING THE PUNCH WAS 15000 AND NOW FREQUENCY IS REDUCED TO 12000.  How To Do : BY PM CHECK SHEET.  Frequency : DAILY.							
Root Cause piercing punch wear out.							Cost Incurred For Making Kaizen :							
Date : 22/02/2017							Material Cost		Labour Cost		Total			
Registered By : Mr. B. R. Kangre							0.00		0.00		0.00			
Manager's Sign : Mr. D T RANE							Scope & Plan For Horizontal Deployment :							
----- Bajaj Auto Ltd. (Fabrication) -----			Equipmnet		Target		Status							