

	Equipment :		Loss Type :	Failure Loss							KAIZEN IDEA SHEET						
	Department :	Press & Fab	Result :	N	P	Q	C	D	S	M							
	Cell :	C101 Silencer	Type :														
Unit Name : Press and Fab - Quality, Pune			Operation : Reso box + Reso box support bkt								Kaizen ID : 3156						
Kaizen Theme: Prevent CC / EFR / Warranty due to Pipe B to perforated tube welding joint failed in C101 Silencer.			Idea : Stopper to be provided in fixture														
Problem / Present Status		Counter Measure			Benchmark :		1										
Cat cover tube broken , Resonator mounting bracket welding 3X86 mm found 3 X 50 / 55 mm		Rear side Stopper bkt provided in Reso-Box support bkt fixture to eliminate the gap between cover tube & support bracket			Target :		0										
					Start :		10/08/2017		Finished :		14/08/2017						
					Note :												
					Team Members :												
					1. Mr Dhananjay Shitole					2. Mr Omkar Patinge							
					3.		4.										
					5.		6.										
					Benefits												
Why Why Analysis :		Result :			Kaizen Sustenance :												
W1 : Why Incomplete welding between R/box support bkt abd cover tube. ? A1 : Gap generate between R Box support bkt and cover tube. W2 : Why Gap generate between R Box support bkt and cover tube. ? A2 : Support bkt position shift rear side after clamping W3 : Why Support bkt position shift rear side after clamping ? A3 : Rear side support not available of Support bkt. W4 : Why Rear side support not available of Support bkt. ? A4 :		Prevented potential CC/EFR/Warranty Failures. <table><thead><tr><th>Month</th><th>Warranty Failure</th></tr></thead><tbody><tr><td>Aug</td><td>1.0</td></tr><tr><td>Sept</td><td>0.0</td></tr></tbody></table>			Month	Warranty Failure	Aug	1.0	Sept	0.0	What To Do : 1. Sustenance audit 2.Fixture PM /JH						
Month	Warranty Failure																
Aug	1.0																
Sept	0.0																
					How To Do : Weekly sustenance audit.												
					Frequency : Weekly.												
					Cost Incurred For Making Kaizen :												
					Material Cost		Labour Cost		Total								
					0.00		0.00		0.00								
					Scope & Plan For Horizontal Deployment :												
					Equipmnet				Target		Status						
Root Cause Rear side support not available of Support bkt.																	
Date : 25/09/2017																	
Registered By : Mr Dhananjay Shitole																	
Manager's Sign :																	
----- BAL Prass and Fab Team -----																	