Coling   Post painting   Projection   Post painting   Type	S DA IA I	Equipment :	wrapping M/C	Loss Type :	Defect	Los	ss					KAIZ	KAIZEN IDEA SHEET			
All Name: 100/28 - BADVE AUTOCOMPS PVT LTD, Pune   Operation: Glass wood wrapping clearance dimentional error   Idea : glass wood wrapping on the previous plant in silencer due to glass wood wrapping clearance dimentional error   Idea : glass wood and stall pipe to matish dimention between tail pipe & wrapped glass wood and pipe on the previous plant plant in silencer after use   Counter Measure   Counter	BAJAJ Dohnely Ment	Department :	Production	oduction					С	D	S		M			
Counter Measure  Counter Measure  Counter Measure  Counter Measure  Class wool wrapping on tail pipe with sight firment leads to tail pipe holes  And then put by carbon after use in field, croater socie in silencer  And then put by carbon after use in field, croater socie in silencer  And then put by carbon after use in field, croater socie in silencer  Counter Measure  Class wool wrapping operation change from tail pipe to shaft of OD 30mm.  And then put by the wool on fail pipe to avoid sight wrapping.  Counter Measure  Class wool wrapping operation change from tail pipe to shaft of OD 30mm.  And then put by the wool on fail pipe to avoid sight wrapping.  Counter Measure  Class wool wrapping operation change from tail pipe to shaft of OD 30mm.  And then put by the wool on fail pipe to avoid sight wrapping.  Counter Measure  Class wool wrapping operation change from tail pipe.  Counter Measure  Counter Measure  Class wool wrapping operation change from tail pipe to shaft of OD 30mm.  And then put by the wool on fail pipe to avoid sight wrapping.  Counter Measure  Class wool wrapping operation change from tail pipe to shaft of OD 30mm.  And then put by the wool on fail pipe to avoid sight wrapping.  Counter Measure  Counter Measure  Class wool wrapping operation change from tail pipe to shaft of OD 30mm.  And then put by the wool on fail pipe to avoid sight wrapping.  Counter Measure  Counter Measure  Class wool wrapping on tail pipe to avoid sight wrapping.  Counter Measure  Counter Measure  Counter Measure  Counter Measure  Class wool wrapping on tail pipe to avoid sight wrapping.  Counter Measure  Counter Measure  Counter Measure  Counter Measure  Class wool wrapping on tail pipe to avoid sight wrapping.  Counter Measure  Co		Cell:	Post painting		Type :									Kaizen ID : 500		
Counter Measure    Beachmark :	Unit Name: 10042	8 - BADVE AUTOCON		Operation: Glass wool wrapping												
Slass wool wrapping on tail pipe with tight fitment leads to tail pipe holes And then push the wool on hall pipe to avoid fight wrapping.    Start   1501/2013   Finished   2301/2013	Kaizen Theme: To elir	minate field complaint i	n silencer due to glass woo													
And then push the wool on tail pipe to avoid tight wrapping.    Start :   15/01/2013   Finished :   23/01/2013	Problem / Present Status			Counter Measure					Benchmark :							
Start   1501/2013   Finished   2301/2013	Glass wool wrapping on tail pipe with tight fitment leads to tail pipe holes						m.	Target: 0				0				
Team Members:  1. Mr. V B Dhole 2. Mr. S S Shinde 3. Mr. S K Satav 4. 5. 6.  Benefits  Why Thy Analysis:  Will Why To eliminate field complaint of noise in silencer?  Why Why Analysis:  Will Why To eliminate field complaint of noise in silencer?  Why To Variant place holes choke up by carbon after sile. See the see that the selection of the sel	choke up by carbon after us	se in field, creates nois	e in sliencer	And then push the wool on tall pipe to avoid tight wrapping.					Start : 15/01/2013				Finished :	23/01/2013		
Tarrige like whose up Glass wood wagelying on tall pipe with your point of the complaints from 26 nos/month for this defect phenomenon.  Result:  Zero Field complaints from 26 nos/month for this defect phenomenon.  Result:  Zero Field complaints from 26 nos/month for this defect phenomenon.  Fred Complaints - Noise  Why Ty Tail pipe holes choke up by carbon ?  3. Mr. St Satav 4.  S. Benefits  C   Warranty debit cost zero for noise due to tail pipe chock up by carbon after sit. use Rs 0.00  C   Warranty debit cost zero for noise due to tail pipe chock up by carbon after sit. use Rs 0.00  Why Ty Analysis:  What To Do: Audit by Supervisor  What To Do: Audit by Supervisor  How To Do: To be ensured Working of machine  Frequency: Start of shift daily  Cost Incurred For Making Kalzen:  Material Cost   Labour Cost   Total    6000.00   200.00   6200.00  Scope & Plan For Horizontal Deployment:  Equipment   Target   Status    Was played with the propried of the propried		1						Note :					<b>"</b>	1		
As Class wood function wrapping on tail pipe  Tail Topic Mode duck up  Why Why Analysis:  Teal Topic Mode and wrapping on tail pipe  All Noise in silencer after use  W2: Why Noise in silencer after use?  W2: Why Noise in silencer after use?  W3: Why Noise in silencer after use?  W3: Why Noise in silencer after use?  W4: Why Noise in silencer after use?  W3: Why Noise in silencer after use?  W4: Why Noise in silencer after use?  W3: Why Noise in silencer after use?  W4: Why Noise in silencer after use?  W3: Why Noise in silencer after use?  W4: Why Noise in silencer after use?  W5: To Field complaints from 26 nos/month for this defect phenomenon.  Field Complaint - Noise  Field Complaint			TAO / S					Team Members :								
3. Mr. S K Statv 4. 5. 6.  Benefits  Class word wrapping on tail pipe  Wity Why Analysis:  Result:  Zero Field complaints from 26 nos/month for this defect phenomenon.  With Yhry To eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use R 80.00  Eliminate warranty claim of noise due to tail pipe chock up by carbon after sail. use Result :  Katzen Susteins Susteins Susteins Susteins Susteins Sustei	<b>《</b> 图》		-	wrap on shaft				1. Mr. V B Dhole					2. Mr. S S	Shinde		
Second Cause   Second Cause   Second Warpping on tail pipe   Second Cause   Sec	(0 111000000	5	VIEW I					3. Mr. S K Satav					4.	4.		
Tail Figure Holes debuck up by carbon after gill. use Nts 0.00  Tail Figure Holes debuck up by carbon after gill. use Nts 0.00  Registered By:  Mr. D M Sonawane  C Warranty debit cost zero for noise due to tail pipe chock up by carbon after gill. use Nts 0.00  Q Eliminate warranty claim of noise due to tail pipe chock up by carbon after gill. use Nts 0.00  Akizen Sustemance:  What To Do: Audit by Supervisor  What To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  Frequency: Start of shift daily  Cost Incurred For Making Kaizen:  Material Cost  Food Cause  Glass wool directly wrap on tail pipe manually  Tail Feb-13 Mar-13 Apr-13 May-13 Jun-13 Jul-13 Aug-13 Sep-13  Registered By:  Mr. D M Sonawane			- 3 10/-					5.					6.	6.		
Tail Proportion de chock up by Carbon after gell use Nos 0.00  Tail Proportion de chock up by Carbon after gell use Nos 0.00  Q Eliminate warranty claim of noise due to tail pipe chock up by carbon after gell use Nos 0.00  All : Noise in silencer after use  With y Why Noise in silencer after use  With y Why Tail pipe holes choke up by carbon  With y Tail pipe holes choke up by carbon  With y Tail pipe holes choke up by carbon  With warpping on tail pipe  With y Why Glass wool tight wrapping on tail pipe?  With Glass wool directly wrap on tail pipe manually  Tail Proportion of this defect phenomenon.  Why Why Carbon Agriculture after use  With y Carbon Agriculture after				glass wool on tail pipe												
Tail Pipe Holes chock up by carbon after view with your properties and the properties of the propertie								sil. use Rs 0.00  Q Eliminate warranty claim of noise due to tail pipe chock up by carbon after								
Result:  Result:  Result:  Kaizen Sustenance:  What To Do : Audit by Supervisor  What To Do : Audit by Super																
M1: Why To eliminate field complaint of noise in silencer? A1: Noise in silencer after use A2: Tail pipe holes choke up by carbon A3: Why Tail pipe holes choke up by carbon? A3: Glass wool tight wrapping on tail pipe A4: Class wool directly wrap on tail pipe manually  A4: Glass wool directly wrap on tail pipe manually  A6: Glass wool directly wrap on tail pipe manually  A6: Glass wool directly wrap on tail pipe manually  A7: Tail pipe holes choke up by carbon? A8: Glass wool directly wrap on tail pipe manually  A8: Glass wool directly wrap on tail pipe manually  A8: Glass wool directly wrap on tail pipe manually  A8: Glass wool directly wrap on tail pipe manually  A8: Glass wool directly wrap on tail pipe manually  A8: Glass wool directly wrap on tail pipe manually  A8: A8: Glass wool directly wrap on t	•	Gla	iss wool wrapping on tail pipe	Result ·	All											
At : Noise in silencer after use  ### A2 : Yail pipe holes choke up by carbon  ### A3 : Glass wool tight wrapping on tail pipe  ### A4 : Why Glass wool tight wrapping on tail pipe  ### A4 : Glass wool directly wrap on tail pipe manually  ### A6 : Glass wool directly wrap on tail		I complaint of noise in	silencer ?		nis defect phenome	enon.		_			Super	visor	r			
A2: Tail pipe holes choke up by carbon W3: Why Tail pipe holes choke up by carbon? A3: Glass wool tight wrapping on tail pipe W4: Why Glass wool tight wrapping on tail pipe ? W4: Glass wool directly wrap on tail pipe manually  Root Cause Glass wool directly wrap on tail pipe manually  Date: 15/01/2013  Registered By: Mr. D M Sonawane  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  How To Do: To be ensured Working of machine  Frequency: Start of shift daily  Cost Incurred For Making Kaizen:  Material Cost	A1 : Noise in silencer after	use		·												
A2: Tail pipe holes choke up by carbon?  A3: Why Tail pipe holes choke up by carbon?  A3: Glass wool tight wrapping on tail pipe  A4: Why Glass wool directly wrap on tail pipe manually  A4: Glass wool directly wrap on tail pipe manually  A6: Glass wool directly wrap on tail pipe manually  A6: Glass wool directly wrap on tail pipe manually  A6: Glass wool directly wrap on tail pipe manually  A7: Tail pipe holes choke up by carbon?  A6: Why Glass wool tight wrapping on tail pipe  A6: Glass wool directly wrap on tail pipe manually  A7: Tail pipe holes choke up by carbon?  A8: Glass wool tight wrapping on tail pipe  A6: Glass wool directly wrap on tail pipe manually  A8: Glass wool directly wrap on tail pipe was believed to take the tail of the tail wrap was believed to take the tail of tail	W2 : Why Noise in silencer	after use ?							Haw To Do To be appared Warling of working							
W3: Why Tail pipe holes choke up by carbon? A3: Glass wool tight wrapping on tail pipe W4: Why Glass wool tight wrapping on tail pipe? A4: Glass wool directly wrap on tail pipe manually  Material Cost Incurred For Making Kaizen:  Material C	A2 : Tail pipe holes choke u	ıp by carbon		30 26					How To Do : To be ensured Working of machine							
A3 : Glass wool tight wrapping on tail pipe  W4 : Why Glass wool tight wrapping on tail pipe ?  A4 : Glass wool directly wrap on tail pipe manually  Material Cost Incurred For Making Kaizen :  Scope & Plan For Horizontal Deployment :  Equipment Target Status  Wrapping M/C 25/10/2013 PROCESS  PROCESS  Registered By : Mr. D M Sonawane	W3 : Why Tail pipe holes ch	noke up by carbon?														
Material Cost Labour Cost Total  Material Cost Labour Cost Total  Material Cost Labour Cost Total  Material Cost Labour Cost Scope & Plan For Horizontal Deployment:  Equipmet Target Status  Wrapping M/C 25/10/2013 PROCESS  Registered By: Mr. D M Sonawane	A3 : Glass wool tight wrapping on tail pipe								Frequency : Start of shift daily							
Material Cost Labour Cost Total    Material Cost Labour Cost Total	W4 : Why Glass wool tight	wrapping on tail pipe?		8 15					Cost Incurred For Making Kaizen :							
Jan-13 Feb-13 Mar-13 Apr-13 May-13 Jun-13 Jul-13 Aug-13 Sep-13   Scope & Plan For Horizontal Deployment :   Equipmet   Target   Status	A4 : Glass wool directly wrap on tail pipe manually			10 -		<b>→</b>			Material Cost				Labour Cost Total			
Root Cause Glass wool directly wrap on tail pipe manually  Date: 15/01/2013  Registered By: Mr. D M Sonawane				0			12		6000.0	00			200.00	6200.00		
Glass wool directly wrap on tail pipe manually  Date: 15/01/2013  Registered By: Mr. D M Sonawane  Wrapping M/C 25/10/2013 PROCESS				Jan-13 Pen-13 Mai-13 Apr-13 May-13 J	uli-13 Jul-13 Aug-	Jul-13 Aug-13 3ep-1			& Plan	For Ho	rizonta	al De	eployment :			
Glass wool directly wrap on tail pipe manually  Date: 15/01/2013  Registered By: Mr. D M Sonawane	Root Cause									Eq	uipmne	et				
Registered By: Mr. D M Sonawane		n tail pipe manually						Wrappir	ng M/C					25/10/2013 PROCESS		
Registered By: Mr. D M Sonawane	Date : 15/01/	2013														
	-															
Manager's Sign: Mr. Arun Gawali																
Bajaj Auto Ltd. (Fabrication)																