
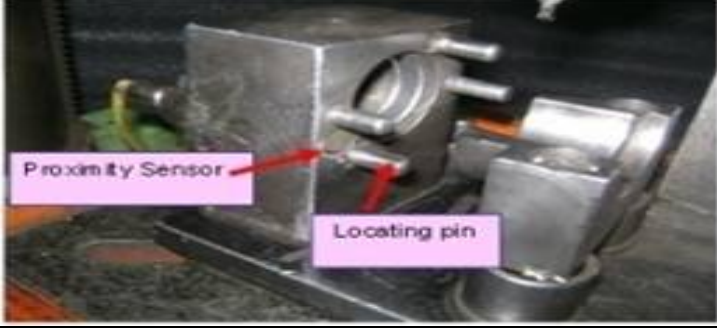
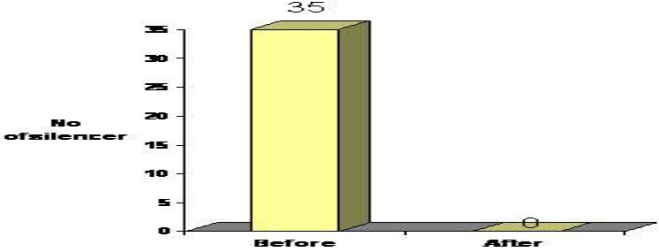
	Equipment :	Drilling	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 519											
	Department :	Production	Result :	N	P	Q	C	D	S	M												
	Cell :	Bending	Type :																			
Unit Name : 100189 - BADVE ENGINEERING LIMITED,			Operation : Vent hole drilling																			
Kaizen Theme: To eliminate in house rejection of silencer due to flange hole damage / CD not OK.			Idea : POKA-YOKE																			
Problem / Present Status		Counter Measure		Benchmark :		35																
In-house rejection of silencer @ 35 Nos / month due to flange hole damage (dia 8.5 mm) / flange hole CD not ok		Provided CD gauge with proximity switch at vent hole drilling stage. proximity switch sense the ok flange & then only starts the drilling motor		Target :		0																
				Start :		20/10/2012		Finished :		24/10/2012												
				Note :																		
				Team Members :																		
				1. OS SWAMI		2. AS WASEEM		3. MC KULKARNI		4. SP SHINDE												
				5.		6.																
				Benefits																		
Why Why Analysis :		Result :		Kaizen Sustenance :																		
W1 : Why In-house rejection of silencer @ 35 Nos / month due to flange hole damage (dia 8.5 mm) / flange hole CD not ok ? A1 : Flange hole damage/ CD not ok , pipe assly welded to Body muffler W2 : Why Flange hole damage/ CD not ok , pipe assly welded to Body muffler ? A2 : Pipe is with flange hole damage / CD not ok W3 : Why Pipe is with flange hole damage / CD not ok ? A3 : No arresting of flange damage/ CD not ok in pipe bending cell W4 : A4 :		Silencer Rejection due to flange hole damage & CD not ok reduced from 35 to 0 		What To Do : Checking of working of proximity How To Do : Point added in JH check sheet Frequency : Daily Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>1000.00</td> <td>200.00</td> <td>1200.00</td> </tr> </table>		Material Cost	Labour Cost	Total	1000.00	200.00	1200.00	Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td>Drilling machine second</td> <td>26/10/2012</td> <td>COMPLETE</td> </tr> </table>					Equipmnet	Target	Status	Drilling machine second	26/10/2012	COMPLETE
Material Cost	Labour Cost	Total																				
1000.00	200.00	1200.00																				
Equipmnet	Target	Status																				
Drilling machine second	26/10/2012	COMPLETE																				
Root Cause No arresting of flange damage/ CD not ok in pipe bending cell																						
Date : 20/10/2012																						
Registered By : Mr. B D Rathod																						
Manager's Sign : Mr. D T RANE																						
----- Bajaj Auto Ltd. (Fabrication) -----																						