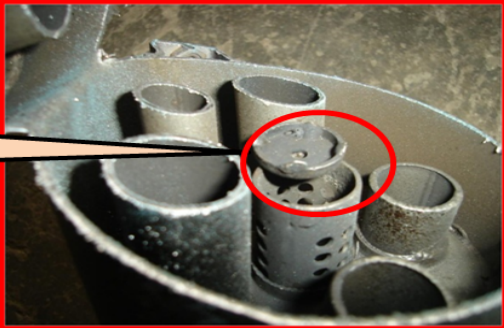
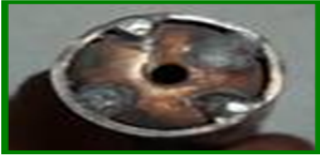
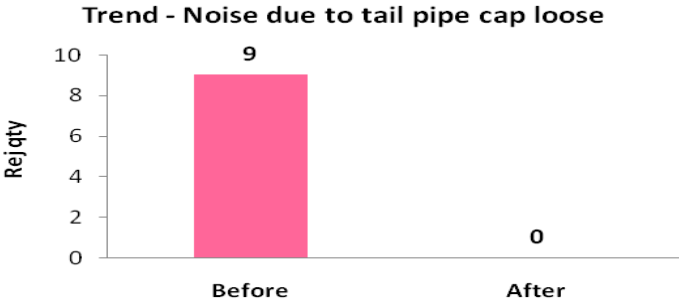


	Equipment :	Welding machine	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department :	QA	Result :	N	P	Q	C	D	S	M	
	Cell :	Disco-M fabrication cell	Type :								
Unit Name : 107350 - S M AUTO ENGINEERING PVT LTD-Mhalunge, Pune			Operation : Tail pipe cap tack welding								Kaizen ID : 524
Kaizen Theme: To eliminate EFR/ Warranty rejection in Disco-m Silencer - Noise due to tail pipe cap loose.			Idea : More land for fillet welding.								
Problem / Present Status		Counter Measure		Benchmark :		9					
When = from Dec 10 Who = Tail pipe cap welding operator. What =Tail pipe cap welding shift due to less land for fillet welding. Where = Tail pipe A		Tail pipe to cap welding with cap position change in reverse direction.		Target :		0					
 Tail pipe cap welding broken.		 BEFORE  AFTER  Cap collar at top side.  Cap collar at bottom side.		Start :		09/01/2013		Finished :		30/07/2013	
				Note :							
				Team Members :							
				1. Mr. D K Thorve		2. Mr. S K Kulkarni					
				3. Mr. Chetan Daule		4.					
				5.		6.					
				Benefits							
				Q		EFR/ Warranty rejection for tail pipe cap loose eliminated. Nos 0.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Tail pipe cap loose. ? A1 : Tail pipe cap welding broken. W2 : Why Tail pipe cap welding broken. ? A2 : Tail pipe cap tack welding failed. W3 : Why Tail pipe cap tack welding failed. ? A3 : Tail pipe cap tack shift. W4 : Why Tail pipe cap tack shift. ? A4 : Less land for fillet welding.(No approach for welding torch)		EFR/ Warranty rejection for tail pipe cap loose eliminated		What To Do : Design Change							
				How To Do : Implimentation of ECR							
Frequency :											
Cost Incurred For Making Kaizen :											
				Material Cost		Labour Cost		Total			
				0.00		0.00		0.00			
Root Cause				Scope & Plan For Horizontal Deployment :							
Less land for fillet welding.(No approach for welding torch)				Equipmnet		Target		Status			
				Welding machine		09/05/2012		COMPLETE			
Date : 09/01/2013											
Registered By : Mr. D K Thorve											
Manager's Sign : Mr Shivakumar											
----- Bajaj Auto Ltd. (Fabrication) -----											