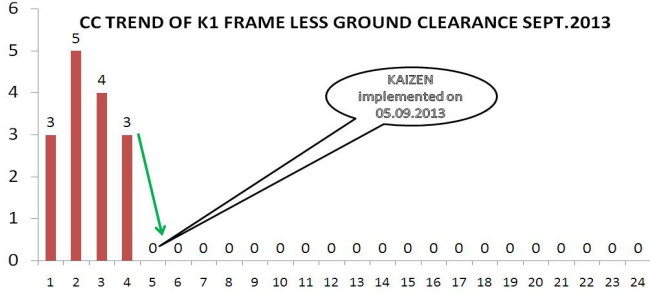


	Equipment :	press 150 ton	Loss Type :					Defect Loss					KAIZEN IDEA SHEET					
	Department	Frame Quiality	Result :		N	P	Q	C	D	S	M							
			Type :															
Cell :			K1 Frame Cell			Operation :			piercing									
Kaizen Theme:			To eliminate Customer complaint by preventing part position shift in die			Idea :			To provide reshape of stopper plate in piercing die to prevent part shift in die									
Problem / Present Status			Counter Measure			Benchmark :			5 nos									
3 mm less ground clearance in k1 frame rear case in LH side qty.- 5 nos.			1) Machine :- By Die rectification, reconditioning & profile of stopper plate grinding. 2) Material :- By Provide GO NOGO provision in gauge for			Target :			0									
						Start :		31/08/2013		Finished :		05/09/2013						
						Note :												
						Team Members :												
						1. Mr. P G Shelke				2. Mr. R M Shame								
						3. Mr. M M Bawkar				4.								
						5.				6.								
						Benefits												
						P		Maintain productivity by reducing defect & rework loss by 5 nos. Nos 5.00										
						Q		Eliminate CC of less ground clearance Nos 0.00										
Why Why Analysis :			Result :			Kaizen Sustenance :												
W1 : Why 3 mm less ground clearance in k1 frame rear case in LH side qty.- 5 nos. ? A1 : Main stand Assly 8.0mm bkt shifted towards engine LH side W2 : Why Main stand Assly 8.0mm bkt shifted towards engine LH side ? A2 : Piercing defect in 8 mm bkt. W3 : Why Piercing defect in 8 mm bkt. ? A3 : wear out 8 mm bkt resting stopper in piercing die (Part position shift in die) W4 : Why wear out 8 mm bkt resting stopper in piercing die (Part position shift in die) ? A4 :			CC of less ground clearance is eliminated 100% 			What To Do : Grinding Piercing die after 10000 stroke How To Do : Monthly PM plan instead of 3 month Frequency : Cost Incurred For Making Kaizen : <table border="1"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>1500.00</td> <td>200.00</td> <td>1700.00</td> </tr> </table>							Material Cost	Labour Cost	Total	1500.00	200.00	1700.00
Material Cost	Labour Cost	Total																
1500.00	200.00	1700.00																
Root Cause						Scope & Plan For Horizontal Deployment :												
wear out 8 mm bkt resting stopper in piercing die (Part position shift in die)						Equipmnet				Target		Status						
						piercing				15/10/2013		PROCESS						
Date :			31/08/2013															
Registered By :			Mr. D M Sonawane															
Manager's Sign :			Mr. Arun Gawali															
----- Bajaj Auto Ltd. (Fabrication) -----																		