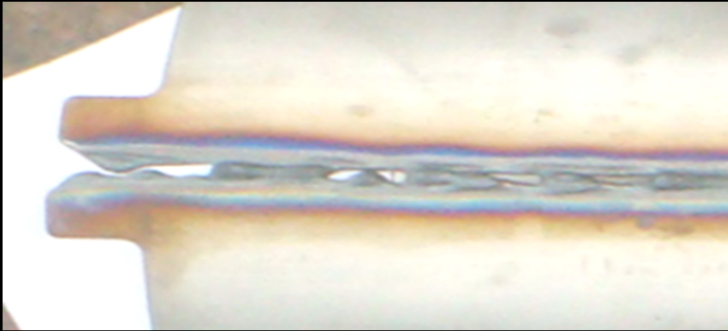
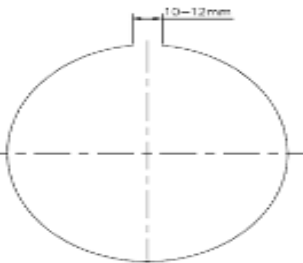
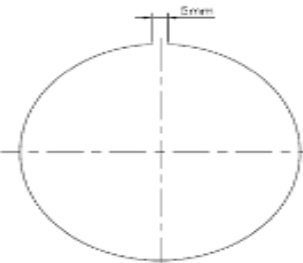


	Equipment :	Rolling Machine	Loss Type :		Defect Loss							KAIZEN IDEA SHEET					
	Department :	Production	Result :	N	P	Q	C	D	S	M							
	Unit Name :	100199 - LAXMI RIKSHAW BODY PVT LTD, Aurangabad	Type :														
Cell :			Platina Silencer Assly.		Operation :								Rolling				
Kaizen Theme:			To eliminate Inhouse quality defect in Platina Rolled body due to welding burn.				Idea :						Bigger step OD of Metallic shaft of Rolling SPM				
Problem / Present Status			Counter Measure				Benchmark :										
In house rejection of Platina Rolled Muffler body, due to burn hole in TIG welding. Rejection part percentage was @ 5 % per month & rejection cost w			Changing bearing step OD of metallic shaft from existing 40 mm to 60 mm .				Target :										
			<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p style="color: red;">Before Improvement:</p>  </div> <div style="text-align: center;"> <p style="color: green;">After Improvement:</p>  </div> </div>				Start :		10/08/2013		Finished :		28/08/2013				
							Note :										
							Team Members :										
							1.				2.						
							3.				4.						
5.				6.													
Benefits																	
C			saving cost of rejected muffler body Rs 118000.00														
Q			In house rejection of rolled muffler body due to burn hole in TIG welding is eliminated. Nos 1008.00														
Why Why Analysis :			Result :				Kaizen Sustenance :										
W1 : Why In house rejection of Rolled Muffler body due to burn hole, in TIG welding ? A1 : Gap between edges was more (observed 10 -12 mm against required 5 mm) after rolling. W2 : Why Gap between edges was more (observed 10 -12 mm against required 5 mm) after rolling. ? A2 : Less forming pressure between PU roller and metallic shaft W3 : Why Less forming pressure between PU roller and metallic shaft ? A3 : Step bearing OD of metallic shaft was weak to sustain forming load W4 : Why Step bearing OD of metallic shaft was weak to sustain forming load ? A4 : Bearing step OD of metallic shaft was less			In house rejection of rolled muffler body due to burn,hole in Tig welding is eliminated. 				What To Do : To change & increase the bearing step OD of metallic shaft of Rolling SPM ,in drawing. How To Do : In Metallic shaft drawing, bearing step OD size changed from earlier existing 40 mm to 60 mm.										
Root Cause			IHR 				Frequency : Irreversible Kaizen										
Weak design							Cost Incurred For Making Kaizen :										
Date :							<table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>0.00</td> <td>0.00</td> <td>0.00</td> </tr> </table>					Material Cost	Labour Cost	Total	0.00	0.00	0.00
Material Cost	Labour Cost	Total															
0.00	0.00	0.00															
Date :			Scope & Plan For Horizontal Deployment :														
Registered By :			<table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> </table>					Equipmnet	Target	Status							
Equipmnet	Target	Status															
Registered By :																	
Manager's Sign :																	
----- Bajaj Auto Ltd. (Fabrication) -----																	