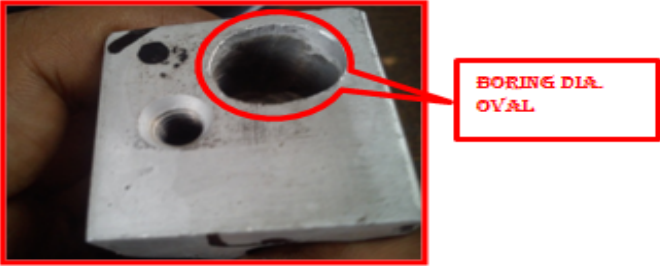
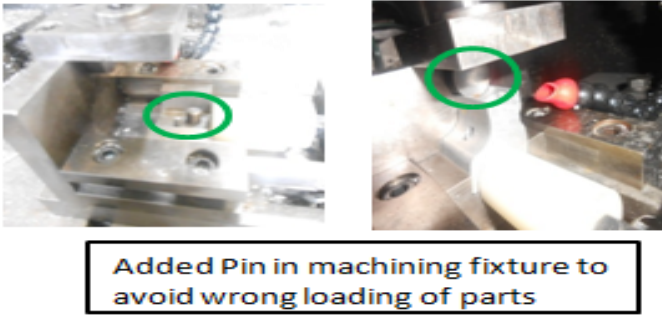
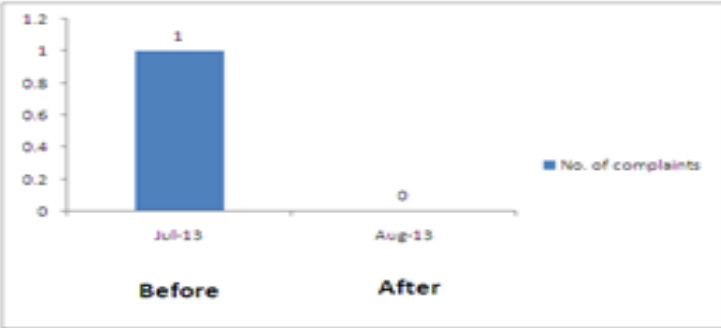


|                                                                                  |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
|----------------------------------------------------------------------------------|---------------------|-----------------------------|-------------------------------------------------------------------------------------|--------------|---|---|-----------------------------------------------------|---------------------------------|----------------------|------------|--------------------------|--|------------|----------|
| ✖                                                                                | <b>Equipment :</b>  | Nissan Outlet drill machine | <b>Loss Type :</b>                                                                  | Failure Loss |   |   |                                                     |                                 |                      |            | <b>KAIZEN IDEA SHEET</b> |  |            |          |
|                                                                                  | <b>Department :</b> | Production                  | <b>Result :</b>                                                                     | N            | P | Q | C                                                   | D                               | S                    | M          |                          |  |            |          |
|                                                                                  | <b>Cell :</b>       | CNC Machine Engine          | <b>Type :</b>                                                                       |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
| <b>Unit Name :</b> Sharda Motor Pvt. Ltd, Nasik                                  |                     |                             | <b>Operation :</b> Nissan Outlet drilling                                           |              |   |   |                                                     |                                 |                      |            | <b>Kaizen ID : 589</b>   |  |            |          |
| <b>Kaizen Theme:</b> ID oval dure to wrong drilling operation                    |                     |                             | <b>Idea :</b> Avoid wrong loading of parts in fixture.                              |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
| <b>Problem / Present Status</b>                                                  |                     |                             | <b>Counter Measure</b>                                                              |              |   |   | <b>Benchmark :</b>                                  |                                 | 0 defect             |            |                          |  |            |          |
| ID oval dure to wrong drilling operation                                         |                     |                             | Eliminate chances of part wrong loading in fixture                                  |              |   |   | <b>Target :</b>                                     |                                 | 0 defect             |            |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | <b>Start :</b>                                      | 02/08/2013                      | <b>Finished :</b>    | 02/08/2013 |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | <b>Note :</b>                                       |                                 |                      |            |                          |  |            |          |
|  |                     |                             |   |              |   |   | <b>Team Members :</b>                               |                                 |                      |            |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | 1. Mr. Ram More                                     |                                 | 2. Mr. Ravi Kumar    |            |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | 3. Mr. Sunil Joshi                                  |                                 | 4. Mr. Amit Mane     |            |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | 5. Mr. Ajay Patil                                   |                                 | 6. Mr. Akshay Shelar |            |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | <b>Benefits</b>                                     |                                 |                      |            |                          |  |            |          |
|                                                                                  |                     |                             |                                                                                     |              |   |   | Q                                                   | No customer complaints Nos 1.00 |                      |            |                          |  |            |          |
| <b>Why Why Analysis :</b>                                                        |                     |                             | <b>Result :</b>                                                                     |              |   |   | <b>Kaizen Sustenance :</b>                          |                                 |                      |            |                          |  |            |          |
| W1 : Why Drill dia getting oval ?                                                |                     |                             | No complaint from customer end from last 1 month                                    |              |   |   | What To Do : Validation of pokyake                  |                                 |                      |            |                          |  |            |          |
| A1 : Part loading from wrong side                                                |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
| W2 : Why Part loading from wrong side ?                                          |                     |                             |                                                                                     |              |   |   | How To Do : During First piece Insoection           |                                 |                      |            |                          |  |            |          |
| A2 : Wrong side part loading possibility in fixture                              |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
| W3 : Why Wrong side part loading possibility in fixture ?                        |                     |                             |                                                                                     |              |   |   | Frequency : Daily                                   |                                 |                      |            |                          |  |            |          |
| A3 :                                                                             |                     |                             |                                                                                     |              |   |   | <b>Cost Incurred For Making Kaizen :</b>            |                                 |                      |            |                          |  |            |          |
| W4 : Why ?                                                                       |                     |                             |                                                                                     |              |   |   | Material Cost                                       |                                 | Labour Cost          |            | Total                    |  |            |          |
| A4 :                                                                             |                     |                             |                                                                                     |              |   |   | 12000.00                                            |                                 | 600.00               |            | 12600.00                 |  |            |          |
| <b>Root Cause</b>                                                                |                     |                             |  |              |   |   | <b>Scope &amp; Plan For Horizontal Deployment :</b> |                                 |                      |            |                          |  |            |          |
| No full proof pokayoke available in fixure                                       |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            | Equipmnet                |  | Target     | Status   |
| <b>Date :</b> 02/08/2013                                                         |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            | MAZAK H.M.C. 630 N(200.2 |  | 02/08/2013 | COMPLETE |
| <b>Registered By :</b> pournima.menge@opexworks.com                              |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
| <b>Manager's Sign :</b> Mr. Ashwini Daftardar                                    |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |
| ----- Sharda Motor Pvt. Ltd -----                                                |                     |                             |                                                                                     |              |   |   |                                                     |                                 |                      |            |                          |  |            |          |