

	Equipment :	k1 pipe A & spacer round welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department	Silencer Tool Fixture maintenance	Result :	N	P	Q	C	D	S	M	
			Type :								
Cell : k1 silencer			Operation : K1 Pipe A+ Spacer round welding								
Kaizen Theme: To eliminate IHR of K1 pipe A welding tilt on spacer round welding stage by preventing of part orie			Idea : OK Part Orientation								
Problem / Present Status			Counter Measure			Benchmark :		6 nos			
Daily 6-7 nos IHR of K1 Pipe A as spacer welding tilt at Pipe A + Spacer round welding stage due to improper locating of spacer.			To modify locating block profile of spacer from half to profile to full round profile Block ID = 43 mm			Target :		zero			
						Start :	02/10/2013	Finished :	05/10/2013		
						Note :					
						Team Members :					
						1. MR. S.B.Dhore		2. MR. D.H.Khalate			
						3. Mr. K.V.Dhondge		4.			
						5.		6.			
						Benefits					
						P	Cycle time reduced by 3 sec by eliminating clamping operation Nos 3.00				
						Q	To eliminate IHR of spacer welding shift Nos 0.00				
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why spacer welding tilt ? A1 : Improper locating of spacer W2 : Why Improper locating of spacer ? A2 : Spacer locating clamp not as per spacer profile(Part Orientation Not OK) W3 : Why Spacer locating clamp not as per spacer profile(Part Orientation Not OK) ? A3 : W4 : A4 :			1) Eliminate IHR of K1 Pipe A from 6-7 to zero qty 2)Clamping operation eliminated.			What To Do : Fixture PM to be done for block ID					
						How To Do : lock ID 43 mm to be checked at time of PM.					
						Frequency : monthly					
						Cost Incurred For Making Kaizen :					
						Material Cost		Labour Cost		Total	
						500.00		150.00		650.00	
						Scope & Plan For Horizontal Deployment :					
						Equipmnet		Target	Status		
						SPM Pipe A+ Spacer round weld		06/10/2013	COMPLETE		
Root Cause											
Spacer locating clamp not as per spacer profile(Part Orientation Not OK)											
Date : 02/10/2013											
Registered By : Mr. D M Sonawane											
Manager's Sign : Mr. Arun Gawali											
----- Bajaj Auto Ltd. -----											