

	Equipment :	Stay Hanger Bkt + plate welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2276
	Department :	K3 silencer tool fix. maint.	Result :	N	P	Q	C	D	S	M	
	Cell :	K3 silencer	Type :								
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Welding								
Kaizen Theme: To eliminate warranty for K3 silencer stay hanger & Body B joint.due to weld shift			Idea : To provide pneumatic both end side clamp at stay hanger bkt & plate for eliminating gap								
Problem / Present Status		Counter Measure		Benchmark :		1 nos					
Leakage at stay hanger bkt & plate joint on leakage testing stage		We have done modification in fixture for stay hanger bkt. & plate both side locating. Poka yoke provision made by pneumatic cylinder.		Target :		Zero					
				Start :		12/10/2013		Finished : 05/11/2013			
				Note :							
				Team Members :							
				1. MR.Gurav D.S		2. MR.Pal A.S					
				3. MR. Akhare A.N		4.					
				5.		6.					
				Benefits							
				Q		Eliminate warranty claim for leakage at stay hanger Nos 0.00					
				S		Improve safety by eliminate manual clamping Nos 0.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Stay hanger bkt & plate joint weld shift ?		Eliminate warranty claim for leakage at stay hanger bkt & plate joint		What To Do : Point added PM check of upper & lower locator dimension							
A1 : Gap between stay hanger bkt & plate											
W2 : Why Gap between stay hanger bkt & plate ?				How To Do : 1)Upper Locator ID = 15 mm & OD = 20mm to be checked at time of PM.							
A2 : Plate moves more upside during clamping				2)Lower Locator OD = 17.5 x							
W3 : Why Plate moves more upside during clamping ?				Frequency : Weekly							
A3 : manual center locating clamp				Cost Incurred For Making Kaizen :							
W4 : Why manual center locating clamp ?				Material Cost		Labour Cost		Total			
A4 :				3000.00		500.00		3500.00			
				Scope & Plan For Horizontal Deployment :							
				Equipmnet		Target		Status			
				No Scope		04/04/2014		PENDING			
Root Cause manual center locating clamp											
Date : 12/10/2013											
Registered By : Mr. D M Sonawane											
Manager's Sign : Mr. Arun Gawali											
----- Bajaj Auto Ltd. (Fabrication) -----											