


|  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
|--|-------------|---|-----------------------------------|--|---|-------------------------------------|---|----------------|---|------------|-------------------|
|  | Equipment : | Fixture   | Loss Type :                       | Defect Loss                                  |   |                                     |   |                |   |            | KAIZEN IDEA SHEET |
|  | Department  | Fabrication   | Result :                          | N  | P | Q                                   | C | D              | S | M          |                   |
|  |             |   | Type :                            |  |   |                                     |   |                |   |            |                   |
| Cell : Swing Arm   |             |   | Operation : Rivet Welding         |  |   |                                     |   |                |   |            |                   |
| Kaizen Theme: To eliminate rivet wrong position weld                             |             |   | Idea : Provision of Rivet holding |  |   |                                     |   |                |   |            |                   |
| Problem / Present Status   |             | Counter Measure   |                                   | Benchmark :                                  |   | 50                                  |   |                |   |            |                   |
| Rivet tilted weld due to wrong position  |             | BY providing spring tension to hold rivet to fix during welding |                                   | Target :                                     |   | 0                                   |   |                |   |            |                   |
|  |             |   |                                   | Start :                                      |   | 15/07/2014                          |   | Finished :     |   | 15/07/2014 |                   |
| <div>✖</div>   |             | <div>✖</div>  |                                   | Note :                                       |   | Done                                |   |                |   |            |                   |
|  |             |   |                                   | Team Members :                               |   |                                     |   |                |   |            |                   |
|  |             |   |                                   | 1. Santosh Jain                              |   |                                     |   | 2. Tolaji Gore |   |            |                   |
|  |             |   |                                   | 3. Kshirsagar                                |   |                                     |   | 4.             |   |            |                   |
|  |             |   |                                   | 5.   |   |                                     |   | 6.             |   |            |                   |
|  |             |   |                                   | Benefits                                     |   |                                     |   |                |   |            |                   |
|  |             |   |                                   | Q  |   | IHR reduced Nos 0.00                |   |                |   |            |                   |
|  |             |   |                                   | Q  |   | Customer complaint reduced Nos 0.00 |   |                |   |            |                   |
|  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| Why Why Analysis :   |             | Result :  |                                   | Kaizen Sustenance :                          |   |                                     |   |                |   |            |                   |
| W1 : Why IHR of Swing Arm more ?   |             | Rivet tilt weld reduced to Zero                                 |                                   | What To Do : Inspection by JH operator       |   |                                     |   |                |   |            |                   |
| A1 : Rejection due to Rivet tilted weld  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| W2 : Why Rejection due to Rivet tilted weld ?                                    |             |   |                                   | How To Do : Check the availability of spring |   |                                     |   |                |   |            |                   |
| A2 : Rivet position tilted during locating                                       |             | <div>✖</div>  |                                   |  |   |                                     |   |                |   |            |                   |
| W3 : Why Rivet position tilted during locating ?                                 |             |   |                                   | Frequency : Daily                            |   |                                     |   |                |   |            |                   |
| A3 : Rivet fixing not proper   |             |   |                                   | Cost Incurred For Making Kaizen :            |   |                                     |   |                |   |            |                   |
| W4 : Why Rivet fixing not proper ?   |             |   |                                   | Material Cost                                |   | Labour Cost                         |   | Total          |   |            |                   |
| A4 : Rivet holding provision not provided  |             |   |                                   | 0.00   |   | 0.00                                |   | 0.00           |   |            |                   |
|  |             |   |                                   | Scope & Plan For Horizontal Deployment :     |   |                                     |   |                |   |            |                   |
|  |             |   |                                   | Equipmnet                                    |   |                                     |   | Target         |   | Status     |                   |
|  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| Root Cause   |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| Rivet holding provision not provided   |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| Date : 15/07/2014  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| Registered By : Mr. Rahul Deshpande  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| Manager's Sign : Mr. Nyayadhish  |             |   |                                   |  |   |                                     |   |                |   |            |                   |
| ----- Bajaj Auto Ltd. -----  |             |   |                                   |  |   |                                     |   |                |   |            |                   |