


	Equipment :	Bumper	Loss Type :		Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2438												
	Department :	Surface treatment	Result :		N	P	Q	C	D	S	M													
	Cell :	Powder coating	Type :																					
Unit Name :			112303 - NAHARS ENGINEERING INDIA PVT. LTD, Aurangabad			Operation :							Powder coating											
Kaizen Theme:			Reduce Jig-marks of hanger jigs in front side of Bumper (near hole)			Idea :							To create SINGLE POINT Contact between JIG Loading Hook and Bumper by Changing the Degree of "Loading Hook"											
Problem / Present Status			Counter Measure			Benchmark :		73%																
Jig-marks on front side of Bumper			Changing the Degree of "Loading Hook" from Angular to Semi-Circle			Target :		0 %																
						Start :		24/05/2014			Finished :		30/05/2014											
						Note :																		
						Team Members :																		
						1. S.T. Sanjeevi			2. Sukhdevsingh															
						3. Somesh Nilkanthrao B			4. Chetan Ingole															
						5.			6.															
						Benefits																		
						C		Total Annual Cost Rs 900000.00																
Why Why Analysis :			Result :			Kaizen Sustenance :																		
W1 : Why Reduce Jig-marks of hanger jigs in front side of Bumper (near hole) ? A1 : Jig marks on Bumper W2 : Why Jig marks on Bumper ? A2 : No deposition of powder W3 : Why No deposition of powder ? A3 : Improper charging of powder at the localized area W4 : Why Improper charging of powder at the localized area ? A4 : Multiple points contact between JIG Loading Hook and Bumper			Reduce in Manpower for Touch-up – 4 Nos Reduce in scratches due to Material handling Reduce the rework cost due to additional Powder Coating <div style="text-align: center;"> Bumper Jig-marks rejection in percentage  </div>			What To Do : Inspection Side – Weekly Monitoring of all hangers How To Do : Checking with special in-house developed tool for monitoring the degree of the "Loading Hook" Frequency : Weekly Cost Incurred For Making Kaizen : <table border="1" style="width: 100%;"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>0.00</td> <td>0.00</td> <td>0.00</td> </tr> </table> Scope & Plan For Horizontal Deployment : <table border="1" style="width: 100%;"> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> <tr> <td>Mudguard</td> <td>30/09/2014</td> <td>PROCESS</td> </tr> </table>							Material Cost	Labour Cost	Total	0.00	0.00	0.00	Equipmnet	Target	Status	Mudguard	30/09/2014	PROCESS
Material Cost	Labour Cost	Total																						
0.00	0.00	0.00																						
Equipmnet	Target	Status																						
Mudguard	30/09/2014	PROCESS																						
Root Cause			<div style="text-align: center;">  </div>																					
Multiple points contact between JIG Loading Hook and Bumper																								
Date :																								
Registered By :																								
Manager's Sign :																								
----- Bajaj Auto Ltd. (Fabrication) -----																								