

<div></div>	Equipment :	F-130	Loss Type :	Defect Loss							KAIZEN IDEA SHEET												
	Department :	Tool Maint.	Result :	N	P	Q	C	D	S	M													
	Cell :	K2/K3 Frame	Type :									Kaizen ID : 2446											
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Manual welding																				
Kaizen Theme: To Reduce the IHR of Main pipe & Center pipe LH/RH joint part position shift problem. (Namaskar joi			Idea : modified clamping block is provided for Center pipe LH/RH																				
Problem / Present Status		Counter Measure			Benchmark :		12 Nos.																
At F- 130 stage, Center pipe LH/RH found gap with main pipe at the time of welding.		New block is design for Center pipe LH/RH with more clamping area for guiding. Clamping block provided bolting & dowelling location for holding.			Target :		Zero Nos.																
					Start :		12/06/2014		Finished :		20/06/2014												
<div></div>		<div></div>			Note :																		
					Team Members :																		
					1. Mr. Rahul Tajane				2. Mr. Nikhil Kharade														
					3. Mr. Naushad Ansari				4.														
					5.				6.														
					Benefits																		
					C		COPQ reduce Rs 226.00																
					Q		quality improved by better welding strength & appearance. Nos 12.00																
Why Why Analysis :		Result :			Kaizen Sustenance :																		
W1 : Why Main pipe & Center pipe LH/RH joint part position shift problem. (Namaskar joint) ? A1 : Center pipe LH/RH clamping not done properly. W2 : Why Center pipe LH/RH clamping not done properly. ? A2 : Center pipe clamping force is less. W3 : Why Center pipe clamping force is less. ? A3 : Center pipe clamping block area is less. W4 : Why Center pipe clamping block area is less. ? A4 :		Eliminated IHR of Center pipe LH/RH to main pipe position shift. <div></div>			What To Do : 1) Daily Cleaning, Lubrication done of clamping & sliding blocks. 2) Daily checking looseness condi How To Do : 1) Daily audit by supervisor during every shift. Frequency : per shift Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>1500.00</td><td>300.00</td><td>1800.00</td></tr></table> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td>No Scope</td><td>07/10/2014</td><td>COMPLETE</td></tr></table>							Material Cost	Labour Cost	Total	1500.00	300.00	1800.00	Equipmnet	Target	Status	No Scope	07/10/2014	COMPLETE
Material Cost	Labour Cost	Total																					
1500.00	300.00	1800.00																					
Equipmnet	Target	Status																					
No Scope	07/10/2014	COMPLETE																					
Root Cause Center pipe clamping block area is less.																							
Date : 05/06/2014																							
Registered By : Mr. D M Sonawane																							
Manager's Sign : Mr. Arun Gawali																							
----- Bajaj Auto Ltd. (Fabrication) -----																							