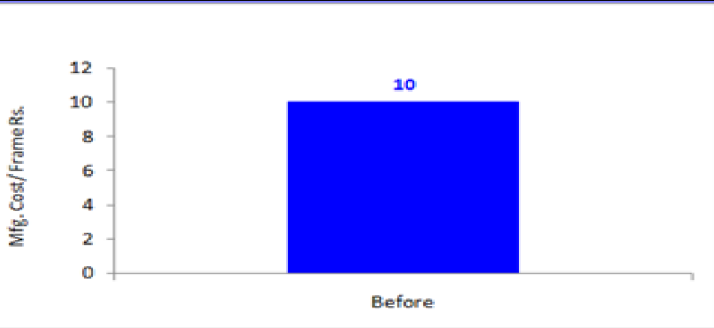
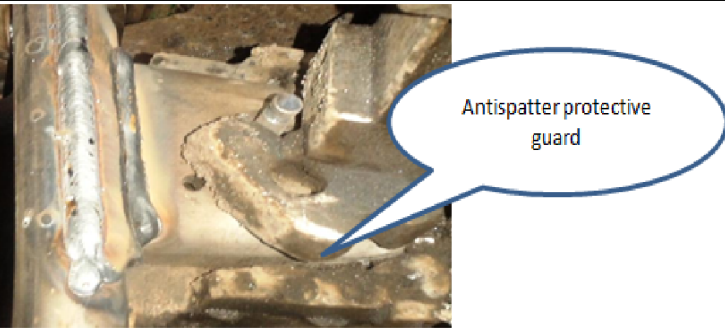
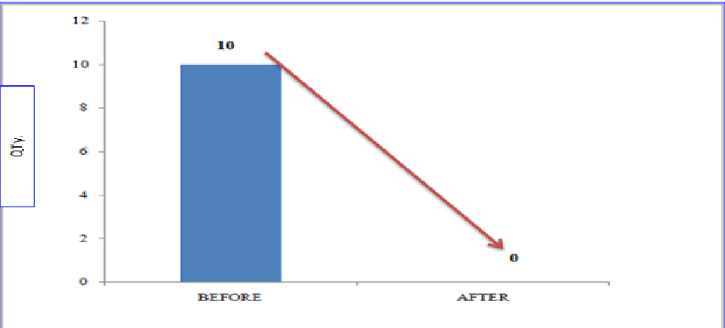


	Equipment :	F-170 LH	Loss Type :	Defect Loss							KAIZEN IDEA SHEET					
	Department	Tool Maint.	Result :	N	P	Q	C	D	S	M						
			Type :													
Cell : K2/K3 frame			Operation : Robotic welding													
Kaizen Theme: To Eliminate IHR of Side Stand bkt fitment hard due to spatters in side stand bkt. hole			Idea : Antispatter protective guards provided for side stand bkt on F-170 stage.													
Problem / Present Status			Counter Measure			Benchmark :		10 Nos.								
Spatter enter in the side stand bkt hole at the time of welding on F-170 stage.			On F-170 stage antispatter protective guard provided on side stand bkt to avoid the spatter enter in the hole of Side stand bkt.			Target :		Zero Nos.								
						Start :		19/06/2014		Finished : 22/06/2014						
						Note :										
						Team Members :										
			1. Mr.G.B.Dombe			2. Mr.A.S. Shitale										
			3. Mr.K.D.Bhrambe			4.										
			5.			6.										
			Benefits													
			Q			IHR of side stand bkt fitment hard eliminated 100 % Nos 10.00										
			C			Cost of rework saved.(15Rs.) Rs 15.00										
Why Why Analysis :			Result :			Kaizen Sustenance :										
W1 : Why Stand bkt fitment hard. ? A1 : patter enters in the hole of side stand bkt W2 : Why patter enters in the hole of side stand bkt ? A2 : No protective guards on theside stand bkt hole at the time of welding. W3 : Why No protective guards on theside stand bkt hole at the time of welding. ? A3 : W4 : A4 :			Reduce the IHR Qty 10 frame to 0. 			What To Do : 1) Daily checking the clamping guard condition. 2) Wear out parts change on weekly. How To Do : 1) By JH PM activity. Frequency : Daily & Weekly Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>80.00</td> <td>230.00</td> <td>310.00</td> </tr> </table>					Material Cost	Labour Cost	Total	80.00	230.00	310.00
Material Cost	Labour Cost	Total														
80.00	230.00	310.00														
Root Cause No protective guards on theside stand bkt hole at the time of welding. Date : 10/06/2014 Registered By : Mr. D M Sonawane Manager's Sign : Mr. Arun Gawali						Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td>F-170 RH</td> <td>23/06/2014</td> <td>COMPLETE</td> </tr> </table>					Equipmnet	Target	Status	F-170 RH	23/06/2014	COMPLETE
Equipmnet	Target	Status														
F-170 RH	23/06/2014	COMPLETE														
----- Bajaj Auto Ltd. -----																