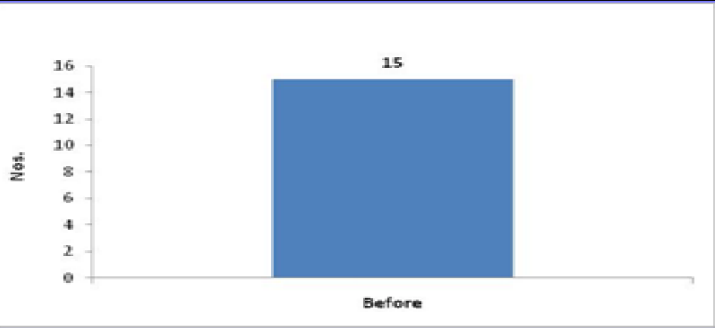
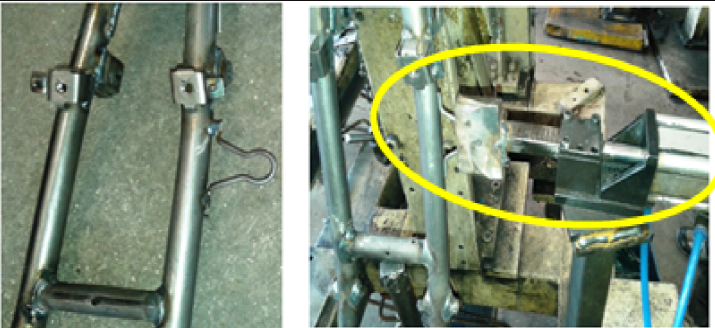
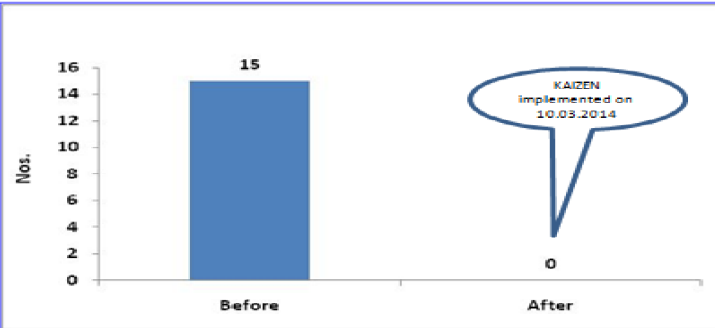
	Equipment :	F-76	Loss Type :	Defect Loss							<b>KAIZEN IDEA SHEET</b>  Kaizen ID : 2453					
	Department :	tool maint.	Result :	N	P	Q	C	D	S	M						
	Cell :	K1 frame	Type :													
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : CO2 welding													
Kaizen Theme: To Reduce the IHR of Clutch cable hook missing.			Idea : To lock the position of clutch cable hook by proviing the fixture location as per the dimension.													
<b>Problem / Present Status</b> At F- 76 stage, IHR of clutch cable hook missing and bend during manual welding. Daily qty.- 15 nos./day.			<b>Counter Measure</b> Providing pneumatic cylinder location for locking the position of clutch cable hook by shifting the welding operation from F- 76 to F-170 stage.			<b>Benchmark :</b> 15 Nos.		<b>Target :</b> Zero Nos.								
						<b>Start :</b> 06/03/2014		<b>Finished :</b> 10/03/2014								
						<b>Note :</b>										
						<b>Team Members :</b>										
<b>Why Why Analysis :</b> W1 : Why Clutch cable hook missing. ? A1 : Hook not correctly position weld. W2 : Why Hook not correctly position weld. ? A2 : Hook weld by manually. W3 : Why Hook weld by manually. ? A3 : No provision for the position of hook in locating fixture during welding. W4 : Why No provision for the position of hook in locating fixture during welding. ? A4 :			<b>Result :</b> IHR of part missing of stiffner pipe hook is eliminated 100 %			<b>Kaizen Sustenance :</b> What To Do : 1) Daily checking of wear out fixture parts. 2) Daily checking of cylinder working condition.										
						How To Do : Daily audit by supervisor during every shift and point added in PM checksheet.										
						Frequency : Daily										
<b>Root Cause</b> No provision for the position of hook in locating fixture during welding.						<b>Cost Incurred For Making Kaizen :</b>										
						<table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>3500.00</td> <td>500.00</td> <td>4000.00</td> </tr> </table>					Material Cost	Labour Cost	Total	3500.00	500.00	4000.00
						Material Cost	Labour Cost	Total								
3500.00	500.00	4000.00														
<b>Scope &amp; Plan For Horizontal Deployment :</b>																
Date : 26/02/2014			Equipment			Target		Status								
Registered By : Mr. D M Sonawane																
Manager's Sign : Mr. Arun Gawali																
----- Bajaj Auto Ltd. (Fabrication) -----																