

	Equipment :	Frame Assembly	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2471
	Department :	Production	Result :	N	P	Q	C	D	S	M	
	Cell :	K-1 line	Type :								
Unit Name : 112236 - BADVE ENGINEERING LIMITED. (2 Wh Waluj), Aurangabad			Operation : Welding								
Kaizen Theme: To eliminate the engine bush tapping incomplete issue in frame assembly			Idea : All SPM welding parameter locked at specified								
Problem / Present Status		Counter Measure		Benchmark :		31/month					
welding parameters on higher side causing weld penetration inside bush.		All SPM welding parameter locked at specified (Below 150 amps)parameter. (welding machine for SPM replaced with Inverter base Mogra m/c).		Target :		0					
				Start :		21/08/2014		Finished :		01/09/2014	
				Note :							
				Team Members :							
				1. K.M.Badgujar				2. A.S.Satpute			
				3. S.V.Gaikwad				4. K.M.Ghayal			
				5. P.B.Gahiwade				6. V.P.Neel			
				Benefits							
				C		Cost of rework reduce Rs 0.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Engine Bush tapping Incomplete ? A1 : welding parameters on higher side causing weld penetration inside bush. W2 : Why welding parameters on higher side causing weld penetration inside bush. ? A2 : unlocking of welding parameters W3 : Why unlocking of welding parameters ? A3 : W4 : A4 :		To reduce the CC about frame assembly		What To Do : To Maintain check sheet							
				How To Do : Add point in supervisor check sheet							
				Frequency : Daily							
				Cost Incurred For Making Kaizen :							
				Material Cost		Labour Cost		Total			
				0.00		0.00		0.00			
				Scope & Plan For Horizontal Deployment :							
				Equipmnet				Target		Status	
				frame assembly				10/11/2014		COMPLETE	
Root Cause unlocking of welding parameters											
Date : 15/01/2015											
Registered By : Mr. A S Pawar											
Manager's Sign : Mr. D T RANE											
----- Bajaj Auto Ltd. (Fabrication) -----											

