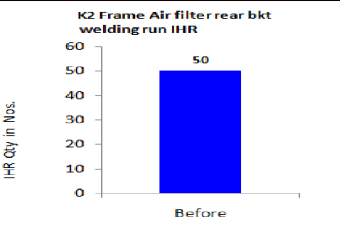
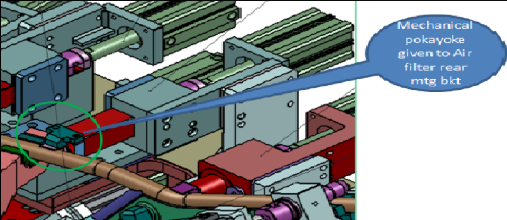
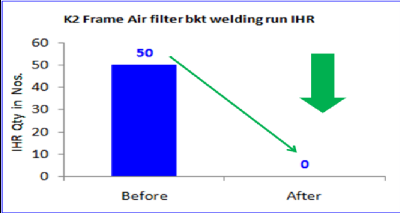


	Equipment :	F-70/90 A	Loss Type :	Defect Loss							KAIZEN IDEA SHEET												
	Department	Frame tool maint.	Result :	N	P	Q	C	D	S	M													
			Type :																				
Cell : K2/K2 frame			Operation :			Robotic Welding																	
Kaizen Theme: To reduce IHR of Air filter rear bkt shift			Idea : Air Filter rear bkt provided mechanical pokayoke																				
Problem / Present Status			Counter Measure			Benchmark :		50 nos/ shift															
On K2/ F-90 A stage Air filter rear bkt not qualify to add on gauge and Air filter bkt position shift. Daily 50 nos qty / shift.			Providing Air filter rear bkt mechanical pokayoke block to avoid the shifting the bkt and reverse fitting in fixture block.			Target :		Zero															
						Start :		13/11/2014		Finished :		13/11/2014											
						Note :																	
						Team Members :																	
						1. Mr.Sawake S.M.				2. Mr.Narkhede S.P.													
						3. Mr.Tajane R.D.				4.													
5.		6.																					
						Benefits																	
						P	RFT level increase by 11% Nos 50.00																
						Q	Quality improved and sustain Nos 50.00																
Why Why Analysis :			Result :			Kaizen Sustenance :																	
W1 : Why Air filter rear bkt shift ? A1 : Air filter rear bkt position shift in fixture W2 : Why Air filter rear bkt position shift in fixture ? A2 : Air filter rear bkt tilt and reverse fitting W3 : Why Air filter rear bkt tilt and reverse fitting ? A3 : POKA W4 : Why POKA ? A4 :			Eliminate the tilting and reverse fitting of Air filter rear bkt position. 			What To Do : 1) Daily check the block loosenss condition. 2) Weekly check th block wear out condition How To Do : By JH, PM activity Frequency : Dially, Weekly Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>250.00</td> <td>100.00</td> <td>350.00</td> </tr> </table> Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td colspan="3" style="height: 100px;"></td> </tr> </table>						Material Cost	Labour Cost	Total	250.00	100.00	350.00	Equipmnet	Target	Status			
Material Cost	Labour Cost	Total																					
250.00	100.00	350.00																					
Equipmnet	Target	Status																					
Root Cause POKA																							
Date : 11/11/2014																							
Registered By : Mr. D M Sonawane																							
Manager's Sign : Mr. Arun Gawali																							
----- Bajaj Auto Ltd. (Fabrication) -----																							