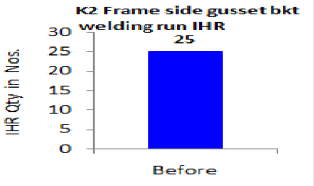
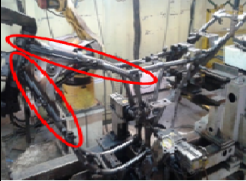
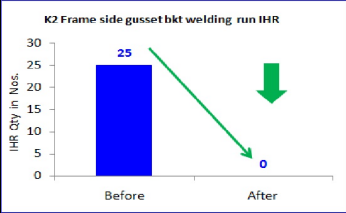


	Equipment :	F-145	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2476					
	Department :	Frame tool maint.	Result :	N	P	Q	C	D	S	M						
	Cell :	K2/K2 frame	Type :													
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Robotic Welding													
Kaizen Theme: To Reduce the IHR of K2 frame Side gusset bkt weld run shift.			Idea : To provide fixture U block for forward half frame assly on Fianl robotic stage.													
Problem / Present Status			Counter Measure			Benchmark :		25 Nos.								
Before on K2 final robotic stage side gusset bkt weld run shift. And no repeatability on final frame. Daily 25frame/day.			On Final robotic stage Fixture U block provided and suit the forward frame assly to sustained the side gusset bkt welding run repeatability.			Target :		Zero								
			BEFORE  AFTER 			Start :		16/10/2014		Finished :		16/10/2014				
						Note :										
						Team Members :										
						1. Mr.G.B.Dombe 2. Mr. R.L.Patil 3. Mr.R.R.Chaudhari 4. 5. 6.										
						Benefits										
						P productivity improved by 25 nos. OK frames. Nos 25.00										
						Q 'A' class area welding quality sustained. Nos 25.00										
						C cost of rework saved by eliminating 25 nos frame IHR Rs 125.00										
Why Why Analysis :			Result :			Kaizen Sustenance :										
W1 : Why Side gusset bkt weld run shift ? A1 : Final assly frame weld on robotic stage. W2 : Why Final assly frame weld on robotic stage. ? A2 : Difficult to half rame welding on fixture. W3 : Why Difficult to half rame welding on fixture. ? A3 : W4 : A4 :			To eliminate the IHR of K2 Frame side gusset bkt welding run shift & no repeatability 			What To Do : Weekly check the fixture U block wear out condition to check as per check sheet How To Do : By PM Plan Frequency : Weekly Cost Incurred For Making Kaizen : <table border="1" style="width: 100%;"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>250.00</td> <td>90.00</td> <td>340.00</td> </tr> </table>					Material Cost	Labour Cost	Total	250.00	90.00	340.00
Material Cost	Labour Cost	Total														
250.00	90.00	340.00														
Root Cause Difficult to half rame welding on fixture. Date : 14/10/2014 Registered By : Mr. D M Sonawane Manager's Sign : Mr. Arun Gawali						Scope & Plan For Horizontal Deployment : <table border="1" style="width: 100%;"> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> <tr> <td colspan="3" style="height: 100px;"></td> </tr> </table>					Equipmnet	Target	Status			
Equipmnet	Target	Status														
----- Bajaj Auto Ltd. (Fabrication) -----																