S 104 14 1	Equipment :	Fixture	Lo	ss Type :	Defect	t Los	SS				KAIZEN IDEA SHEET					
S BAJAJ	Department :	Qa			sult :	N	F	D Q	С	D			s	М		
Untinetly Ahead	Cell :	Fabrication	abrication										Kaizen ID : 2581			
Unit Name : 1108	365 - METALMAN MI	CRO TURNERS,		•	Opera	ation :	N	Manual								
Kaizen Theme: To e	liminate customer cor	mplaint Rear fender offset		Idea :	Provid	le U-typ	pe b	lock to ho	ld bkt a	at full	welding					
Problem / Present Status			Counter Measure					Benchmark :								
Rear fender offset			U-type block provided to avoid welding distortion					Target :			0	0				
								Start : 08/07/20		07/2014		Finished :	09/07/2014			
								Note :								
1-3X-2		- TEN	- And	-	-	-		Team M	ember	rs :						
							1. Ashish Kumar			ar			2. Nakul Panwar			
	A Desident		- C - O	-				3. Ashish Shukla					4. Harish			
No.	Total States								5.				6.			
1 dine 1								Benefits	5							
	A DEC	The second second					Q Quality Improved Rs 0.00									
	N PER	MV.														
Why Why Analysis :			Result :					Kaizen Sustenance :								
W1 : Why Rear fender offset ?			Customer complaint Reduced					What To Do : Presence of block								
A1 : Bkt expand during ful	ll welding															
W2 : Why Bkt expand during full welding ?									How To Do : Ctq audit							
A2 : Welding distortion aft	er full welding		ano ano													
W3 : Why Welding distorti	on after full welding ?)	.100				_									
A3 : Tack welding on Robo stage and full welding on maunal fixture			250 333					Frequency : Daily								
W4 : Why Tack welding on Robo stage and full welding on maunal fixture ?			200				_	Cost Inc	curred	For	Making I					
A4 :			180					М	aterial	Cost		Lab	our Cost	Total		
			50	56	-	ь			50.00	0			0.00	50.00		
			0	ul 14	Aug 14			Scope &	For	or Horizontal Deployr		ment :				
Root Cause						_		1	Equipmnet					Target Status		
Tack welding on Robo sta	age and full welding o	n maunal fixture														
Date : 10/07	7/2014															
	Ajit Singh															
Manager's Sign : MR																
Bajaj Auto Ltd.	(Fabrication)															