
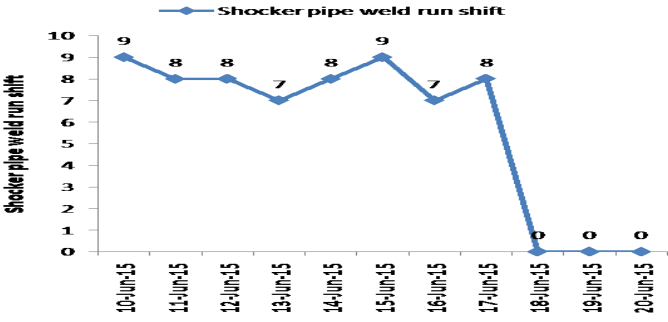
	Equipment :	F 120 stage	Loss Type :	Defect Loss							KAIZEN IDEA SHEET				
	Department :	Quality	Result :	N	P	Q	C	D	S	M					
	Cell :	K4 fabrication line	Type :									Kaizen ID : 2616			
Unit Name : 112610 - BADVE ENGINEERING LIMITED-Khalumbre, Pune			Operation : Shocker cross pipe and rear upper pipe welding												
Kaizen Theme: To eliminate defect phenomenon of weld run shift			Idea : To provide fixed support to block so that die block will not become loose												
Problem / Present Status			Counter Measure			Benchmark :		8							
Pipe c/s shocker mounting & rear upper pipe weld run found shift			Fixed stopper is provided at block to give support.			Target :		0							
						Start :		15/06/2015		Finished :		17/06/2015			
						Note :									
						Team Members :									
Why Why Analysis : W1 : Why Shocker mounting top side weld run shift ? A1 : Gap between C/S shocker pipe and upper pipe W2 : Why Gap between C/S shocker pipe and upper pipe ? A2 : variation found in notching W3 : Why variation found in notching ? A3 : Shocker pipe shifts during die operation W4 : Why Shocker pipe shifts during die operation ? A4 : During operation Die block becomes loose			Result : After implementation of this kaizen shocker pipe weld run shift defect eliminated 			1. P.G.Shelke				2. Amol thakre					
						3. S.T.Kapse				4.					
						5.				6.					
						Benefits									
Root Cause During operation Die block becomes loose			Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>500.00</td><td>0.00</td><td>500.00</td></tr></table>			Material Cost	Labour Cost	Total	500.00	0.00	500.00	Kaizen Sustenance : What To Do : Ensure stopper provided at block is in OK condition			
Material Cost	Labour Cost	Total													
500.00	0.00	500.00													
How To Do : Point added in Die PM check sheet															
Frequency : Daily															
Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr></table>				Equipmnet	Target	Status									
Equipmnet	Target	Status													
Date : 09/07/2015															
Registered By : Mr. Sachin Bhore															
Manager's Sign : Mr. N N Joshi															
----- Bajaj Auto Ltd. (Fabrication) -----															