

<div></div>	Equipment :	SPM -Head pipe stopper welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department :	QA	Result :	N	P	Q	C	D	S	M	
	Cell :	Frame fabrication D105	Type :								
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Head pipe stopper welding - SPM.								
Kaizen Theme: To prevent defect of head pipe stopper bkt missing in D105 frame.			Idea : Provision for interlocking.								
Problem / Present Status		Counter Measure			Benchmark :		5				
Head pipe stopper welding operation on SPM so one side welding missing during welding & customer complaint happen frequently.		Head pipe stopper both side welding interlocked with operation by PLC.			Target :		0				
					Start :		10/04/2015		Finished :		22/04/2015
<div></div>		<div></div>			Note :		Interlocking poka for bkt missing.				
					Team Members :						
					1. Mr.Salunke P.A				2. Mr.Nikhade M.L		
					3. Mr.Lade D.S				4. Mr.Rathod R.B		
					5. Mr.Khairnar R.V				6.		
					Benefits						
					Q		1. Customer complaint PPM reduced from 250 PPM to "Zero" . 2. IHR reduced 1240 PPM to "Zero". Rs 27000.00				
Why Why Analysis :		Result :			Kaizen Sustenance :						
W1 : Why Stg.lock difficult in D105 vehicle. ? A1 : Head pipe stopper bkt missing. W2 : Why Head pipe stopper bkt missing. ? A2 : Tack welding & full welding operation on SPM but not interlocked. W3 : Why Tack welding & full welding operation on SPM but not interlocked. ? A3 : Interlocking provision missed during manufacturing of SPM. W4 : Why Interlocking provision missed during manufacturing of SPM. ? A4 : No provision		1. Customer complaint reduced from 250 PPM to "Zero" PPM. 2. Rejection qty. reduced from 05 frame to "Zero". <div></div>			What To Do : By JH/PM of SPM / Kaizen & Poka yoke check sheet.						
					How To Do : By Audit						
					Frequency : Daily / Weekly						
					Cost Incurred For Making Kaizen :						
					Material Cost		Labour Cost		Total		
					8000.00		6500.00		14500.00		
					Scope & Plan For Horizontal Deployment :						
					Equipmnet				Target		Status
					Head Pipe Stopper Welding- SPM				29/04/2015		COMPLETE
Root Cause No provision											
Date : 10/07/2015											
Registered By : Mr. Lade D.S											
Manager's Sign :											
----- Bajaj Auto Ltd. (Fabrication) -----											