

<div></div>	Equipment :	Frame tack I st. F-60	Loss Type :	Defect Loss							KAIZEN IDEA SHEET												
	Department	QA	Result :	N	P	Q	C	D	S	M													
			Type :																				
Cell : CT100 frame line.				Operation : Frame tack I st - F-60																			
Kaizen Theme: To prevent customer complaint of spatter's on Eng.bkt top in CT100 frame.			Idea : To provide auto masking in fixture.																				
Problem / Present Status		Counter Measure			Benchmark :		12																
During full welding operation of F-60 spatter's falling on Eng. bkt top side. This area considered "A" class for Aesthetics, that's why CC happened.		Auto masking provided with link the side cover bkt mounting cylinder.			Target :		0																
					Start :		12/02/2015		Finished :		10/02/2015												
					Note :		Auto masking provided on frame tack fixture - Zero cost for kaizen (Kara kuri)																
<div></div>		<div></div>			Team Members :																		
					1. Mr.Salunke P.A				2. Mr. Mujawar A.I														
					3. Mr.Tayde S.N				4. Mr. Nikhade M.L														
					5. Mr. Pankaj kulkarni				6. Mr. Lade D.S														
					Benefits																		
					Q		IHR reduced from 25 frame/shift to "Zero". Rs 170000.00																
Why Why Analysis :		Result :			Kaizen Sustenance :																		
W1 : Why Spatter falling on Eng.Bkt top side in CT100 frame ? A1 : During welding of rear joint & side cover full spatter falling on eng.bkt W2 : Why During welding of rear joint & side cover full spatter falling on eng.bkt ? A2 : No provision for aviod spatter falling. W3 : Why No provision for aviod spatter falling. ? A3 : No masking provision in fixture W4 : Why No masking provision in fixture ? A4 :		Zero customer complaint of spatter falling on eng.bkt top from last 06 months <div></div>			What To Do : JH/PM , Kaizen check sheet. How To Do : By ME & Dedicated Kaizen Audit Engineer. Frequency : Daily / Weekly Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>0.00</td><td>1000.00</td><td>1000.00</td></tr></table> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td>Frame tack I st</td><td>02/04/2015</td><td>COMPLETE</td></tr></table>							Material Cost	Labour Cost	Total	0.00	1000.00	1000.00	Equipmnet	Target	Status	Frame tack I st	02/04/2015	COMPLETE
Material Cost	Labour Cost	Total																					
0.00	1000.00	1000.00																					
Equipmnet	Target	Status																					
Frame tack I st	02/04/2015	COMPLETE																					
Root Cause No masking provision in fixture																							
Date : 10/07/2015																							
Registered By : Mr. Lade D.S																							
Manager's Sign :																							
----- Bajaj Auto Ltd. (Fabrication) -----																							