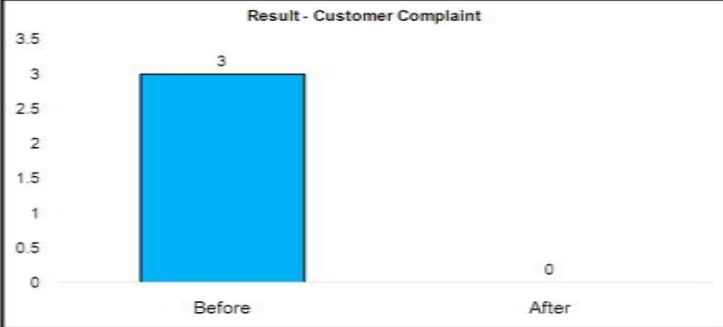


	Equipment :	FF-40 (Swing Fixture)	Loss Type : Defect Loss		KAIZEN IDEA SHEET Kaizen ID : 2623												
	Department :	3 Wheeler	Result :	N								P	Q	C	D	S	M
	Cell :	Full Frame	Type :														
Unit Name : 113332 - Badve Engineering Ltd (CV Division), Aurangabad			Operation : MIG Wekding														
Kaizen Theme: To prevent customer complaint of cup bracket weld run shift			Idea : Adequate Locking after fixture rotation														
Problem / Present Status			Counter Measure			Benchmark :		3/month									
Cup bracket & TA bracket to cross tube robotic welding run shift.			Provided additional locking with pneumatic cylinder which locks the fixture after rotation			Target :		0									
						Start :		15/05/2015		Finished :		01/06/2015					
						Note :											
						Team Members :											
						1. Mr. M.G. Ambhore		2. Mr. I.H. Sayyad									
						3. Mr. U.M. Madne		4. Mr. S.D. Mhaske									
5.		6.															
Why Why Analysis :			Result :			Kaizen Sustenance :											
W1 : Why 01/06/2015 ? A1 : High CC due to cup bracket run shift W2 : Why High CC due to cup bracket run shift ? A2 : Welding point repeatability is not ok W3 : Why Welding point repeatability is not ok ? A3 : Fixture position repeatability is not ok W4 : Why Fixture position repeatability is not ok ? A4 : No adequate locking after fixture rotation			Achieved Zero Customer Complaint for this phenomenon 			What To Do : How To Do : Frequency : Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>8000.00</td> <td>750.00</td> <td>8750.00</td> </tr> </table>						Material Cost	Labour Cost	Total	8000.00	750.00	8750.00
Material Cost	Labour Cost	Total															
8000.00	750.00	8750.00															
Root Cause						Scope & Plan For Horizontal Deployment :											
No adequate locking after fixture rotation						Equipmnet		Target		Status							
Date : 15/06/2015																	
Registered By : Mr. P P Videkar																	
Manager's Sign : Mr. D T RANE																	
----- Bajaj Auto Ltd. (Fabrication) -----																	