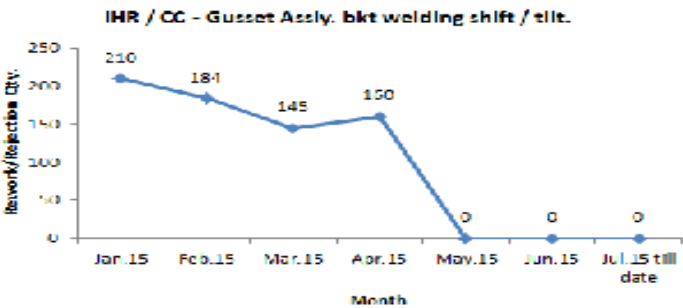


	Equipment :	Forward Tack Stage	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2635												
	Department :	QA	Result :	N	P	Q	C	D	S	M													
	Cell :	Boxer's frame line.	Type :																				
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Horn mtg & cable hook welding to gusset assly.pipe - Tier.02																				
Kaizen Theme: To prevent defect of horn mtg & cable hook bkt joint welding shift in Boxer's frame.			Idea : Combine operation																				
Problem / Present Status		Counter Measure		Benchmark :		160 / month																	
During tack & full welding operation of gusset assly, welding shift defect generated so IHR increased & CC happens frequently.		Both bkts implemented combine in press & Horn mtg & clutch cable hook bkts welding position set as per required plane.		Target :		0																	
				Start :		09/05/2015		Finished :		17/05/2015													
				Note :		Combine operation implemented for welding shift defect - Cause side action.																	
				Team Members :																			
				1. Mr. Bhadke B.R		2. Mr. Nikhade M.L																	
		3. Mr. Pimpale		4. Ms. Kulkarni Pankaj																			
		5. Mr. Lade D.S		6. Mr. Gaikawad																			
		Benefits																					
		Q IHR rework & rejection cost reduced by 20 % , cost save / month Rs. 40000 Rs 80500.00																					
Why Why Analysis :		Result :		Kaizen Sustenance :																			
W1 : Why Welding defects ? A1 : Due to welding shift W2 : Why Due to welding shift ? A2 : multiple bkt welding on SPM W3 : Why multiple bkt welding on SPM ? A3 : No provision for combine welding operation. W4 : Why No provision for combine welding operation. ? A4 : each part separate		IHR & CC reduced from 160 nos. to "Zero". 		What To Do : JH/PM of SPM How To Do : Operator & Maint person Frequency : Daily / Monthly Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>7600.00</td><td>1500.00</td><td>9100.00</td></tr></table> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td>Gusset assly full welding</td><td>22/05/2015</td><td>COMPLETE</td></tr></table>								Material Cost	Labour Cost	Total	7600.00	1500.00	9100.00	Equipmnet	Target	Status	Gusset assly full welding	22/05/2015	COMPLETE
Material Cost	Labour Cost	Total																					
7600.00	1500.00	9100.00																					
Equipmnet	Target	Status																					
Gusset assly full welding	22/05/2015	COMPLETE																					
Root Cause Combine part for welding																							
Date : 19/07/2015																							
Registered By : Mr. Lade D.S																							
Manager's Sign :																							
----- Bajaj Auto Ltd. (Fabrication) -----																							