

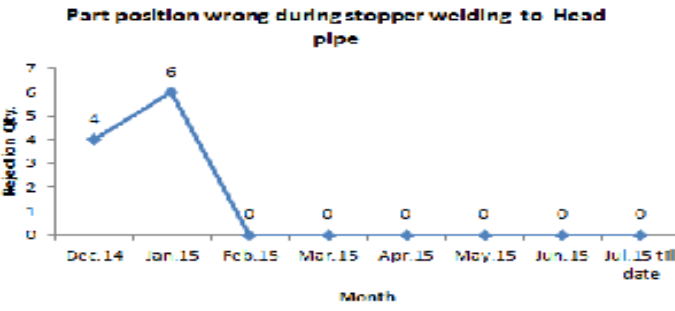
	Equipment :	Head pipe stopper welding.	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2638					
	Department :	QA	Result :	N	P	Q	C	D	S	M						
	Cell :	Boxer's frame line.	Type :													
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Forward F-40 I st tack..													
Kaizen Theme: To prevent defect of head pipe stopper position wrong fitment in boxer's frame.			Idea : Make a provision by poka													
Problem / Present Status		Counter Measure		Benchmark :		06										
WRONG SIDE FITTMENT DEFECT.STOPPER IS WELDED ON THE OPPOSITE SIDE OF THE HEAD PIPE.		Poka implemented by providing sensor , operation interlocked with machine.		Target :		0										
				Start :	04/01/2015		Finished :	12/01/2015								
				Note :		Poka implemented for part position wrong at tier.02 end										
				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. Salunke V.V										
				Benefits												
				Q Wrong part fitment defect zero from last 06 months. Rs 45000.00												
Why Why Analysis :		Result :		Kaizen Sustenance :												
W1 : Why Fork fitment difficult in boxer's vehicle ? A1 : Head pipe with stopper wrong fitment W2 : Why Head pipe with stopper wrong fitment ? A2 : during stopper welding wrong side stopper welded W3 : Why during stopper welding wrong side stopper welded ? A3 : No arresting poka in fixture W4 : Why No arresting poka in fixture ? A4 : No provision		Customer complaint & IHR reduced from 6 Nos. to "Zero" from last 06 months. 		What To Do : JH of fixture / PM of machine. How To Do : By Audit of ME Person / Kaizen Audit. Frequency : Daily / Monthly Cost Incurred For Making Kaizen : <table border="1"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>2800.00</td> <td>1200.00</td> <td>4000.00</td> </tr> </table>							Material Cost	Labour Cost	Total	2800.00	1200.00	4000.00
Material Cost	Labour Cost	Total														
2800.00	1200.00	4000.00														
Root Cause No provision				Scope & Plan For Horizontal Deployment :												
Date : 19/07/2015				Equipmnet		Target		Status								
Registered By : Mr. Lade D.S				SPM.03		10/02/2015		COMPLETE								
Manager's Sign :																
----- Bajaj Auto Ltd. (Fabrication) -----																