

	Equipment :	Frame tack I st F-60	Loss Type :		Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2641			
	Department :	QA	Result :		N	P	Q	C	D	S	M				
	Cell :	Boxer's - B line	Type :												
Unit Name :			112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation :							Frame tack I st - F-60 (Tack & full)		
Kaizen Theme:			To prevent customer complaints of spatters on eng.mtg bkt top in boxer's frame.			Idea :							Auto masking for aviod spatter falling.		
Problem / Present Status			Counter Measure					Benchmark :		12					
During frame tack & full welding spatters falling on Eng. bkt top side in boxer's frame.			Auto masking provided with kara-kuri on frame tack I st F-60 stage.					Target :		0					
								Start :		22/01/2015		Finished :		20/07/2015	
								Note :		Kara-kuri by auto masking for spatters.					
								Team Members :							
								1. Mr. Shaikh K.S		2. Mr. Jagtap K.V					
								3. Mr. Nikhade M.L		4. Ms. Pooja patil					
								5. Mr. Mujawar A.I		6. Mr. Shinde A.R					
								Benefits							
								Q		Inhouse chipping operation removed for eng.bkt top side spatter's, CC zero Rs 53000.00					
Why Why Analysis :			Result :					Kaizen Sustenance :							
W1 : Why Aesthetic area damaged . ?			Customer complaint zero from last 6 months.					What To Do : JH of fixture / Kaizen Audit.							
A1 : due to spatters falling on eng.bkt top															
W2 : Why due to spatters falling on eng.bkt top ?								How To Do : Fixture maint incharge / Dedicated auditor							
A2 : during tack & full welding on other parts															
W3 : Why during tack & full welding on other parts ?								Frequency : Weekly / Monthly							
A3 : No masking provision between parts & eng. bkt top area.								Cost Incurred For Making Kaizen :							
W4 : Why No masking provision between parts & eng. bkt top area. ?								Material Cost		Labour Cost		Total			
A4 : No provision								450.00		200.00		650.00			
								Scope & Plan For Horizontal Deployment :							
								Equipmnet		Target		Status			
								Frame tack I st F-60.		29/01/2015		COMPLETE			
Root Cause															
No provision															
Date :			20/07/2015												
Registered By :			Mr. Lade D.S												
Manager's Sign :															
----- Bajaj Auto Ltd. (Fabrication) -----															