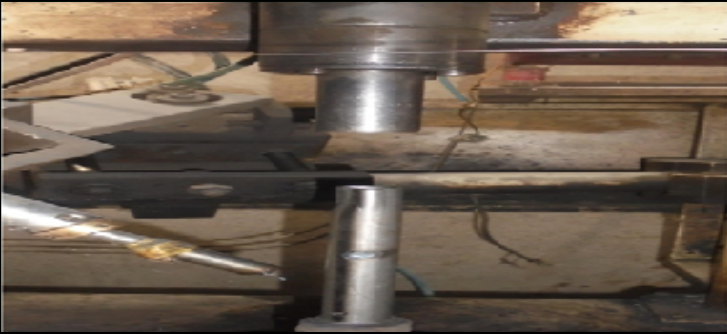
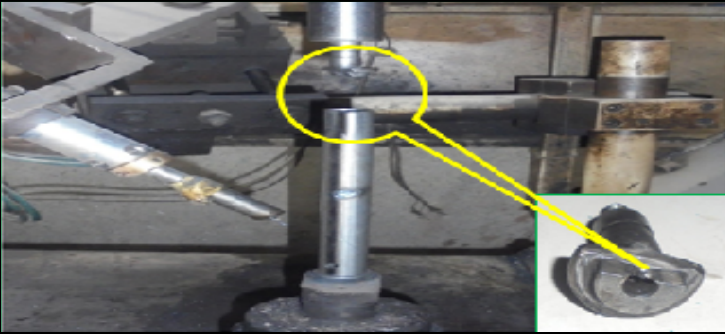
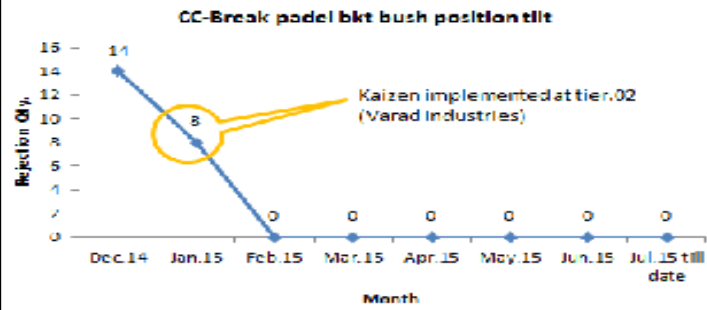


	Equipment :	SPM.02-Center stand assly. with bush full welding.	Loss Type : Defect Loss		KAIZEN IDEA SHEET Kaizen ID : 2643												
	Department :	QA	Result :	N								P	Q	C	D	S	M
	Cell :	D105-A	Type :														
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : SPM- Center stand bkt assly.														
Kaizen Theme: To prevent customer complaint of break padel bkt bush position tilt in D105 frame			Idea : Make a provision for full guide at inner side.														
Problem / Present Status			Counter Measure			Benchmark :		8									
During operation of center stand cross pipe & break padel bush welding on SPM, bush welded tilt on pipe.			While full welding on SPM of center stand bkt & break padel bush full guide clamping provided as same shape of pipe ID.			Target :		0									
						Start :		05/01/2015		Finished :		17/01/2015					
						Note :		Improvement at tier.02 (Varad Industries)									
						Team Members :											
						1. Mr. Ghorpade S.		2. Mr. Lade D.S									
						3. Mr. Bhadke B.R		4. Mr. Nikhade M.L									
						5. Mr. Kulkarni P.		6. Mr. Gaikawad									
						Benefits											
						Q		Rework cost saved Rs. 1500/month Rs 90000.00									
Why Why Analysis :			Result :			Kaizen Sustenance :											
W1 : Why Break padel fitment difficult. ?			Customer complaint & IHR zero form last 06 months.			What To Do : JH of SPM											
A1 : break padel bkt welded tilt																	
W2 : Why break padel bkt welded tilt ?						How To Do : JH Audit by fixture maint incharge											
A2 : bkt welded on SPM in tilt position																	
W3 : Why bkt welded on SPM in tilt position ?						Frequency : Weekly / Monthly											
A3 : no provision for arrest position tilt						Cost Incurred For Making Kaizen :											
W4 : Why no provision for arrest position tilt ?						Material Cost		Labour Cost		Total							
A4 :						800.00		250.00		1050.00							
Root Cause						Scope & Plan For Horizontal Deployment :											
no provision for arrest position tilt						Equipmnet		Target		Status							
Date : 20/07/2015						1.Bkt full welding. 2. Sub.ass		27/02/2015		COMPLETE							
Registered By : Mr. Lade D.S																	
Manager's Sign :																	
----- Bajaj Auto Ltd. (Fabrication) -----																	