

	Equipment :	Rear box tack stage-III rd	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2647
	Department :	Fixture Maint / QA	Result :	N	P	Q	C	D	S	M	
	Cell :	Boxer's - B line	Type :								
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Rear box 3 rd tack welding.								
Kaizen Theme: To prevent customer complaint of grab.mtg bkt part position tilt in boxer's frame.			Idea : Make a provision for reduce the clearance.								
Problem / Present Status			Counter Measure			Benchmark :		9			
Bkt getting tilt during fitment on F-60 frame tack welding stage, so fitment problem occurred at customer end.			On both side arresting the tilting of grab.mtg , guide block provided with reduce the clearance .			Target :		0			
						Start :	28/12/2015	Finished :	10/01/2015		
						Note :	Kaizen on quality fitment issue in BAL.				
						Team Members :					
						1. Mr. Salunke P.A		2. Mr. Shinde V.V			
						3. Mr. Mujawar A.I		4. Mr. Nikhade M.L			
						5. Mr. Baviskar P.V		6. Mr. Khairnar R.V			
						Benefits					
						Q	1) Customer complaint zero. 06 Nos.x 1500 Rs.= 9000 Rs./month=Rs.1,08,000 / annum. (Rejection + R Rs 60000.00				
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why grab.mtg fitment difficult in boxer's vehicle. ?			Customer complaint zero from last 06 months , IHR zero.			What To Do : JH of fixture/ Kaizen audit.					
A1 : due to grab mtg. bkt tilt.											
W2 : Why due to grab mtg. bkt tilt. ?						How To Do : by fixture maint team.					
A2 : More clearance between bkt & locating block.											
W3 : Why More clearance between bkt & locating block. ?						Frequency : Weekly / Monthly					
A3 : Initial design of fixture						Cost Incurred For Making Kaizen :					
W4 : Why Initial design of fixture ?						Material Cost		Labour Cost		Total	
A4 : No provion for arresting tilting						9000.00		1800.00		10800.00	
Root Cause						Scope & Plan For Horizontal Deployment :					
No provion for arresting tilting						Equipmnet		Target		Status	
						Box. assly tack-3 rd		24/02/2015		COMPLETE	
Date : 20/07/2015											
Registered By : Mr. Lade D.S											
Manager's Sign :											
----- Bajaj Auto Ltd. (Fabrication) -----											

