

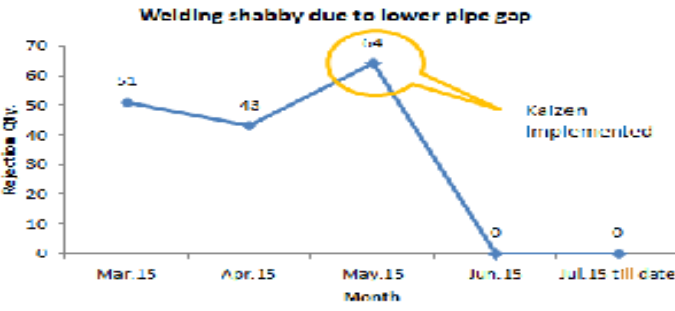
	Equipment :	Forward Tack Stage	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2648						
	Department :	QA	Result :	N	P	Q	C	D	S	M							
	Cell :	CT100 frame line.	Type :														
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Forward F-50 assly tack.														
Kaizen Theme: To prevent shabby welding defect on lower pipe joint in CT100 frame (CC- III rd party inspection).			Idea : Round to elliptical.														
Problem / Present Status		Counter Measure		Benchmark :		50											
During lower pipe welding in fixture, more gap observed & No scope for adjustment in forward tack welding fixture. (Round shape to tooling hole at LP		Fixture guidepin & lower pipe tooling hole provided elliptical against round.		Target :		0											
				Start :		28/05/2015		Finished :		30/05/2015							
				Note :		Kaizen on quality improvement , Implemented after approval from BAL - RND & Design.											
				Team Members :													
				1. Mr. Bhadke B.R				2. Mr. Nikhade M.L									
				3. Mr. Khairnar R.V				4. Mr. Salunke P.A									
				5. Mr. Lade D.S				6. Mr. Kulkarni Pankaj									
				Benefits													
				Q Customer complaint zero, IHR reduced by 80 %. Rs 78000.00													
																	
Why Why Analysis :		Result :		Kaizen Sustenance :													
W1 : Why Shabby welding at lower pipe joint. ? A1 : Heavy gap between main pipe & lower pipe joint. W2 : Why Heavy gap between main pipe & lower pipe joint. ? A2 : No scope for adjust & minimize gap in fixture. W3 : Why No scope for adjust & minimize gap in fixture. ? A3 : Round shape of tooling hole W4 : Why Round shape of tooling hole ? A4 :		Customer complaint zero & III rd party inspection stage rework zero after implementation. 		What To Do : JH of fixture. How To Do : By Fix.maint auditor Frequency : Weekly / Monthly Cost Incurred For Making Kaizen : <table border="1"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>23000.00</td> <td>3500.00</td> <td>26500.00</td> </tr> </table>								Material Cost	Labour Cost	Total	23000.00	3500.00	26500.00
Material Cost	Labour Cost	Total															
23000.00	3500.00	26500.00															
Root Cause Round shape of tooling hole				Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> <tr> <td>Forward tack assly</td> <td>10/06/2015</td> <td>COMPLETE</td> </tr> </table>								Equipmnet	Target	Status	Forward tack assly	10/06/2015	COMPLETE
Equipmnet	Target	Status															
Forward tack assly	10/06/2015	COMPLETE															
Date : 21/07/2015																	
Registered By : Mr. Lade D.S																	
Manager's Sign :																	
----- Bajaj Auto Ltd. (Fabrication) -----																	