S BAJAJ	Equipment :	FF-30 Fix'A'			Loss Type : Defect Loss KAIZEN IDEA									EN IDEA SHEET	
	Department :	Maintenance		R	Result :			P Q	С	D	S	М			
Ustwelly Ahead	Cell :	Full Frame	т	ype :				Kaizen ID : 26					(aizen ID : 2663		
Unit Name : 113	3332 - Badve Engieering	Ltd (CV Division), Aurangab	pad		Opera	peration : Welding									
Kaizen Theme: To	reduce I.H.R. of welding	shift,Burn,Shabby weld ,740) dimension problem	ldea :											
Problem / Present Status			Counter Measure					Benchmark : 5 Occur				5 Occ	irance/Month		
Welding shift,Burn,Shabby weld ,740 dimension problem due to variation in location of main member			By replacement with high capacity cylinder 740 dimension achieved				Target : 0				0				
			consistently and also were shirt, burn, shabby problem eliminated					Start : 10/06/2015				Finished :	26/06/2015		
			×					Note :							
		low capacity cylinder for						Team Members :							
		MM clamping						1. Mr. Y.S. Rakhade					2. Mr. M.G	2. Mr. M.G. Ambhore	
							3. M. I.H. Sayyad					4. Mr. A.B. Bangar			
V VA	No. IN						5. Mr. A.B. Bangar					6.			
	- Internet							Benefits							
								P Production increased due to elimination of minor stoppages due to robot errors Rs 0.00							
								Q Eliminate I.H.R. due to weld shift,weld burn,shabby weld Rs 0.00							
								C Rework cost reduced for particular phenomenon Rs 0.00							
Why Why Analysis :			Result :					Kaizen Sustenance :							
W1 : Why 26/06/2015 ?			Eliminated IHR due to weld shift, weld burn, shabby weld and 740 dimension problem .						n What To Do :						
A1 : Replaced low capacity cylinder to high capacity cylinder															
W2 : Why Replaced low capacity cylinder to high capacity cylinder ?									How To Do :						
A2:740 dimension not achieved			IHR trends due to welding shift.Burn.Shabby weld												
W3 : Why 740 dimension not achieved ?															
A3 : less clamping force for main member clamping			,740 dimension problem						Frequency :						
W4 : Why less clamping force for main member clamping ?			40 -						Cost Incurred For Making Kaizen :						
A4 : Low capacity cylinder used for main member clamping		30						Material	Cost		La	oour Cost	Total		
			10 Jan-15 Feb-15 Mar-15 Apr-15 May-15 Jun-15 Ju				-		8000.	00			500.00	8500.00	
						Jul-15		Scope	Scope & Plan For Horizontal Deployment :						
Root Cause									Equipmnet					Target Status	
Low capacity cylinder used for main member clamping															
Date : 10/	06/2015														
Registered By : Mr.	P P Videkar														
Manager's Sign : Mr.	D T RANE														