


	Equipment :	Robotic frame full welding.	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2672
	Department :	QA-Fabrication	Result :	N	P	Q	C	D	S	M	
	Cell :	CT100 frame line.	Type :								
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Robotic full welding .								
Kaizen Theme: To prevent customer complaint of blow holes in CT100 frame.			Idea : Interlocking provision by poka.								
Problem / Present Status		Counter Measure		Benchmark :		23					
While robotic full welding on CT100 frame , Nozzle cleaning unit not working , so cleaning activity bypass. blow holes defect create during welding.		Nozzle cleaning unit interlocked with process by PLC.		Target :		0					
				Start :		12/05/2015		Finished :		19/05/2015	
				Note :		Poka implemented for prevent CC of blow holes on robotic stage .					
				Team Members :							
				1. Mr.Bidhan B.I				2. Mr. Rathod R.B			
				3. Mr.Nikhade M.L				4. Mr. Shinde A.R			
				5. Mr.Walzade P.D				6. Mr. Satote V.S			
				Benefits							
				Q		Inhouse rework cost reduced by 17 % Rs 44500.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Customer complaint increased. ? A1 : Due to blow holes W2 : Why Due to blow holes ? A2 : Nozzle not cleaning W3 : Why Nozzle not cleaning ? A3 : Nozzle cleaning unit bypass W4 : Why Nozzle cleaning unit bypass ? A4 : Unit not working		Customer complaint zero from implementation. 		What To Do : JH/ PM of robots.							
				How To Do : By robot maintenance.							
				Frequency : Weekly / Monthly							
				Cost Incurred For Making Kaizen :							
				Material Cost		Labour Cost		Total			
				8700.00		1500.00		10200.00			
				Scope & Plan For Horizontal Deployment :							
				Equipmnet				Target		Status	
				All Robots				29/05/2015		COMPLETE	
Root Cause No interlocking/poka											
Date : 04/08/2015											
Registered By : Mr. Lade D.S											
Manager's Sign :											
----- Bajaj Auto Ltd. (Fabrication) -----											