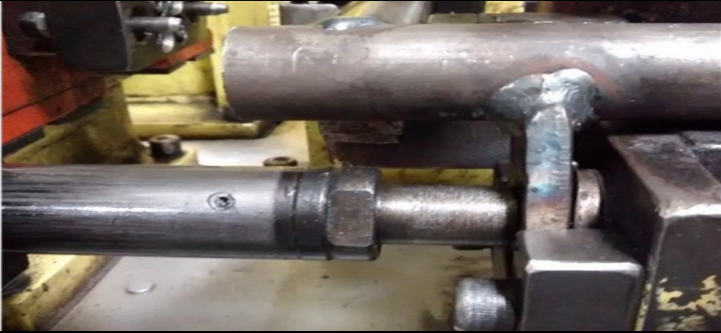


|                                                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
|----------------------------------------------------------------------------------|--------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|-------------|-------------------------------------------------------------------|---|-----------------|---|-----------------------|---|-------------------------------------------|
|  | Equipment :  | F40 STAGE                                                                                                                                                                | Loss Type :                                  | Defect Loss |                                                                   |   |                 |   |                       |   | KAIZEN IDEA SHEET<br><br>Kaizen ID : 2676 |
|                                                                                  | Department : | QUALITY                                                                                                                                                                  | Result :                                     | N           | P                                                                 | Q | C               | D | S                     | M |                                           |
|                                                                                  | Cell :       | B104D FRAME LINE                                                                                                                                                         | Type :                                       |             |                                                                   |   |                 |   |                       |   |                                           |
| Unit Name : 100121 - LUMAX AUTO TECHNOLOGIES LIMITED, Aurangabad                 |              |                                                                                                                                                                          | Operation : Forwad assly gusset full welding |             |                                                                   |   |                 |   |                       |   |                                           |
| Kaizen Theme: To Eliminate IHR defect of Part missing Stand assly Rivet          |              |                                                                                                                                                                          | Idea : To eliminate possibility part missing |             |                                                                   |   |                 |   |                       |   |                                           |
| Problem / Present Status                                                         |              | Counter Measure                                                                                                                                                          |                                              |             | Benchmark :                                                       |   | 1               |   |                       |   |                                           |
| Rivet missing stand assly accepted by Fixture.                                   |              | Fixture pin design modified and inter locking with robot working                                                                                                         |                                              |             | Target :                                                          |   | 0               |   |                       |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             | Start :                                                           |   | 12/08/2015      |   | Finished : 12/08/2015 |   |                                           |
|  |              | <br> |                                              |             | Rivet Present<br>Reed switch on<br>& Cycle will start             |   | Note :          |   |                       |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             | Rivet missing<br>reed switch not<br>on & Cycle will<br>not start. |   | Team Members :  |   |                       |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   | 1. Kishor Patil |   | 2. Raj                |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   | 3. Mahajan      |   | 4. Prayag             |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   | 5.              |   | 6.                    |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   | Benefits        |   |                       |   |                                           |
|                                                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
| Why Why Analysis :                                                               |              | Result :                                                                                                                                                                 |                                              |             | Kaizen Sustenance :                                               |   |                 |   |                       |   |                                           |
| W1 : U Pipe assly without rivet assemble on fixture                              |              | IHR Defect zero for Rivet missing                                                                                                                                        |                                              |             | What To Do : Daily Audit                                          |   |                 |   |                       |   |                                           |
| A1 : No provision to arrest rivet miss at u pipe assly                           |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
| W2 : Why No provision to arrest rivet miss at u pipe assly ?                     |              |                                                                                         |                                              |             | How To Do : Pokayoke Audit                                        |   |                 |   |                       |   |                                           |
| A2 : Poka                                                                        |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
| W3 : Why Poka ?                                                                  |              |                                                                                                                                                                          |                                              |             | Frequency : Daily                                                 |   |                 |   |                       |   |                                           |
| A3 :                                                                             |              |                                                                                                                                                                          |                                              |             | Cost Incurred For Making Kaizen :                                 |   |                 |   |                       |   |                                           |
| W4 :                                                                             |              |                                                                                                                                                                          |                                              |             | Material Cost                                                     |   | Labour Cost     |   | Total                 |   |                                           |
| A4 :                                                                             |              |                                                                                                                                                                          |                                              |             | 250.00                                                            |   | 50.00           |   | 300.00                |   |                                           |
| Root Cause                                                                       |              |                                                                                                                                                                          |                                              |             | Scope & Plan For Horizontal Deployment :                          |   |                 |   |                       |   |                                           |
| Poka                                                                             |              |                                                                                                                                                                          |                                              |             | Equipmnet                                                         |   | Target          |   | Status                |   |                                           |
| Date : 12/08/2015                                                                |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
| Registered By : Mr. Sachin Lahe                                                  |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
| Manager's Sign : Mr. Hemant Sriwastava                                           |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |
| ----- Bajaj Auto Ltd. (Fabrication) -----                                        |              |                                                                                                                                                                          |                                              |             |                                                                   |   |                 |   |                       |   |                                           |