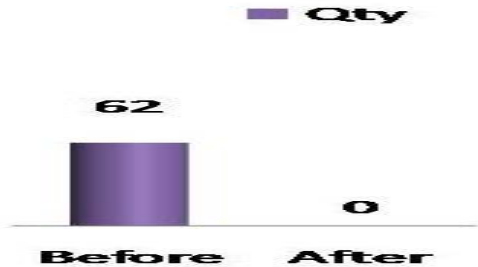
	Equipment :	CO2 WELDING M/C	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2681
	Department :	PRODUCTION	Result :	N	P	Q	C	D	S	M	
	Cell :	BENDING	Type :								
Unit Name : 100189 - BADVE ENGINEERING LIMITED,			Operation : Spacer Round Welding.								
Kaizen Theme: Welding burn & shabby welding			Idea : Step provided on locator for tight fitment of outer pipe.								
Problem / Present Status		Counter Measure		Benchmark :		62 nos					
Welding burn and Shabby welding		step provided on locator for tight fitment of outer pipe.		Target :		0					
				Start :		04/07/2015		Finished :		09/07/2015	
				Note :							
				Team Members :							
				1. Mr. G.R.Magar				2. Mr.V.K. Talay			
				3. Mr. S.P. Shinde				4. Mr.B.R.Kangre			
				5. Mr. V. T. Pande				6. Ms. S. J. Pande			
				Benefits							
				Q		Reduced IHR up to Nos 62.00					
				C		save cost up to Rs 3720.00					
				P		Increase in production. Nos 62.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Welding burnt & shabby welding ? A1 : Welding undercut and shabby welding during Outer and Inlet spacer round welding. W2 : Why Welding undercut and shabby welding during Outer and Inlet spacer round welding. ? A2 : During round welding locator is rotating but the outer pipe not rotating.... W3 : Why During round welding locator is rotating but the outer pipe not rotating.... ? A3 : Outer slip out in locator during rotation. W4 : Why Outer slip out in locator during rotation. ? A4 : Loose fitment between locator and outer pipe.		In house rejection reduced. 		What To Do : Point Added in pm check sheet. How To Do : Weekly pm audit. Frequency : weekly.							
Root Cause				Cost Incurred For Making Kaizen :							
No step provided on locator for tight fitment of outer pipe.				Material Cost		Labour Cost		Total			
				250.00		100.00		350.00			
Date : 25/08/2015				Scope & Plan For Horizontal Deployment :							
Registered By : Mr. B. R. Kangre				Equipmnet				Target		Status	
Manager's Sign : Mr. D T RANE				Round welding m/c				30/07/2015		COMPLETE	
----- Bajaj Auto Ltd. (Fabrication) -----											