BAJAJ Dep	ipment :	F-23	Loss Typ	e : Defe	ct I	oss					KAIZE	KAIZEN IDEA SHEET					
alla 4 A1 A6 A	artment :	Tool Maint.		Result :	N	T	Р	<u> </u>	T 5	s	М	_	IN IDEA SHEET				
Distinctly Akead Cell		Frame shop						Q C	D		IV	_	Kaizen ID : 2725				
Unit Name: 100428 - BADVE AUTOCOMPS PVT LTD, Pune				Type :	eration :		Pound	welding	DM.			"	alzeli ID . 2725				
		•															
Kaizen Theme: To improve	the welding qua	ity of Engine hanger bush r	ound welding.	: To	provide \$	SPN	∕l for Er	gine Hai	ger bus	n round	weldin	g.					
Problem / Present Status On K2/K3 line Engine hanger bush welding shabby, undercut and centre position shift on F-150 stage.			Counter Measure				Ben	Benchmark :				25 nos					
			To provide SPM for engine hanger bush round welding. So that we are eliminate the hanger bush shabby welding, undercut and centre position shift prob			Tar	Target :			zero	zero						
						Sta	Start : 14/03/2015		/2015		Finished: 16/03/2015		2015				
			×				Not	Note :									
								Team Members :									
							1. N	1. Mr.N.P.Kharade				2. Mr.S.M.Sawake					
							3. N	r.G.B.Do	mbe			4.	4.				
							5.	5.				6.					
								Benefits									
Hnager Bush	Hnage	r Bush shabby					Q	Q Welding quality and aesthetical appearance increase. Rs 0.00									
position shift		welding					Р	P production rate and standard increase by using automation(SPM) Rs 0.00									
								C Cost of rework save Rs.2.6/frame Rs 0.00									
Why Why Analysis :								Kaizen Sustenance :									
W1 : Why To improve the welding quality of Engine hanger bush round welding. ?			To improve the welding quality of Engine hanger bush through round welding SPM.					What To Do: Daily check the locating pin loosenes condition and should be spatter free.									
A1 : Engine hanger bush welding shabby, undercut and Centre position shift								2) Daily check the torc									
W2 : Why Engine hanger bush welding shabby, undercut and Centre position shift ?			30 Rework trend of eng. Hanger bush welding shabby, undercut & position shift 25 - 24 23 29 29 29 20 18 19 18 19 19 19 19 19 19 10 10 10 10 10 10 10 10 10 10 10 10 10					- How To Do : By JH & PM activity									
A2 : Manual welding for engine hanger bush.																	
W3 : Why Manual welding for engine hanger bush. ?								Frequency : daily									
W3 . Willy Maridal Welding for en			5 -					Cost Incurred For Making Kaizen :									
A3 :			0										Total				
A3 : W4 : Manual welding for engine	hanger bush.		2 3 4 5 6 7 9 10 11 12 13	14 16 17	18 19			Materi	l Cost		La	abour Cost	Tc Tc	ital			
A3 :	hanger bush.		2 3 4 5 6 7 9 10 11 12 13	14 16 17	18 19			Materi 640			La	abour Cost 500.00	114				
A3 : W4 : Manual welding for engine	hanger bush.		2 3 4 5 6 7 9 10 11 12 13	14 16 17	7 18 19		Sco	640	.00	orizont							
A3: W4: Manual welding for engine A4:	hanger bush.		2 3 4 5 6 7 9 10 11 12 13	14 16 17	7 18 19		Sco	640	.00 n For H	orizont quipmn	al Depl	500.00					
A3 : W4 : Manual welding for engine			2 3 4 5 6 7 9 10 11 12 13	14 16 17	7 18 19		Sco	640	.00 n For H		al Depl	500.00	114	0.00			
A3: W4: Manual welding for engine A4: Root Cause Manual welding for engine hang	er bush.		2 3 4 5 6 7 9 10 11 12 13	14 16 17	18 19		Scc	640	.00 n For H		al Depl	500.00	114	0.00			
A3: W4: Manual welding for engine A4: Root Cause Manual welding for engine hang Date: 18/03/2015 Registered By: Mr. D M So	er bush. Inawane		2 3 4 5 6 7 9 10 11 12 13	14 16 17	18 19		Scc	640	.00 n For H		al Depl	500.00	114	0.00			
A3: W4: Manual welding for engine A4: Root Cause Manual welding for engine hang Date: 18/03/2015	er bush. Inawane awali		2 3 4 5 6 7 9 10 11 12 13	14 16 17	18 19		Scc	640	.00 n For H		al Depl	500.00	114	0.00			