

	Equipment :	Fixture	Loss Type :	Defect Loss							<b>KAIZEN IDEA SHEET</b>  Kaizen ID : 2726					
	Department :	Production	Result :	N	P	Q	C	D	S	M						
	Cell :	RE Chasis	Type :													
Unit Name : 100264 - RUCHA ENGINEERING PVT LTD., Aurangabad			Operation : Clamping													
Kaizen Theme: To Prevent In-House Rejection			Idea : 3 Points Relation set in single stage													
Problem / Present Status			Counter Measure				Benchmark :		100							
There is a problem of 3 points relation not OK			Three point relation Set in one Stage, hence operator easy to detect Auto clamp Provide in fixture . Provide red switch & Interlock with Welding Ma				Target :		0							
							Start :		02/10/2015							
							Finished :		10/03/2015							
							Note :									
							Team Members :									
							1. Mr Rathod		2.							
							3. Mr Tupe		4.							
							5.		6.							
							Benefits									
							P		output/man out/shift Nos 200.00							
							Q		IHR avg 77 nos Nos 0.00							
							C		Bkt cost & rework labour cost Rs 3339.00							
Why Why Analysis :			Result :				Kaizen Sustenance :									
W1 : Why IHR is more of Battery support Bkt 3 points relation not ok ?			Loss due judgement error is zero.				What To Do : Interlocked welding cycle with clamp tooling pin full guide in battery bracket tooling hole. Ens									
A1 : Operator judgment error							How To Do : point added in JH Check Sheet.									
W2 : Why Operator judgment error ?							Frequency : Daily									
A2 : Relation set in two stages on fixture							Cost Incurred For Making Kaizen :									
W3 : Why Relation set in two stages on fixture ?							<table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>5600.00</td> <td>0.00</td> <td>5600.00</td> </tr> </table>				Material Cost	Labour Cost	Total	5600.00	0.00	5600.00
Material Cost	Labour Cost	Total														
5600.00	0.00	5600.00														
A3 :							Scope & Plan For Horizontal Deployment :									
W4 :							<table border="1"> <tr> <td>Equipmnet</td> <td>Target</td> <td>Status</td> </tr> <tr> <td>Max Line Assembly Fixture</td> <td>20/03/2015</td> <td>COMPLETE</td> </tr> </table>				Equipmnet	Target	Status	Max Line Assembly Fixture	20/03/2015	COMPLETE
Equipmnet	Target	Status														
Max Line Assembly Fixture	20/03/2015	COMPLETE														
A4 :																
Root Cause																
Relation set in two stages on fixture																
Date : 02/10/2015																
Registered By : Mr. Amol Girme																
Manager's Sign : Mr.R S Makasare																
----- Bajaj Auto Ltd. (Fabrication) -----																

