


	Equipment :	MKN 300 -1	Loss Type :	Setup & adjustment Loss							KAIZEN IDEA SHEET  Kaizen ID : 2757												
	Department :	Production	Result :	N	P	Q	C	D	S	M													
	Cell :	Forging	Type :																				
Unit Name : BILL FORGE PVT LTD., Banglore			Operation : Forging																				
Kaizen Theme: To reduce setting time			Idea : Replace the allen key by ratchet spaner for easy rotation of bolts																				
Problem / Present Status		Counter Measure		Benchmark :		10 Minutes																	
Operator takes 10 minutes to loosening and tightening the bolts to remove and fix the die while setting		Ratchet spanner given to operator to tighten and loosen.		Target :		5 Minutes																	
 05.01.2015 16:25		 05.01.2015 16:21		Start :		05/01/2016		Finished :		30/07/2015													
				Note :																			
				Team Members :																			
				1. Murali R		2. Senthil P																	
3. Raghupathy		4. Mohan J																					
5. Manikandan		6.																					
Benefits																							
M		Operator fatigue reduced Rs 0.00																					
Why Why Analysis :		Result :		Kaizen Sustenance :																			
W1 : Why Operator takes 10 minutes tighten and loosen the bolts to remove die ? A1 : Allen key has to be put and removed frequently to loosen and tighten W2 : Why Allen key has to be put and removed frequently to loosen and tighten ? A2 : Space constraint to turn and use the allen key W3 : Why Space constraint to turn and use the allen key ? A3 : Allen key not suitable for use in this place W4 : Why Allen key not suitable for use in this place ? A4 :		Time taken for tightening and loosening reduced from 10 minutes to 5 Minutes  		What To Do : Ratchet spanner to be used for at all machines during setting  How To Do : Ratchet spanner to be provided at machine to be kept in tool box  Frequency : every setting  Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>300.00</td><td>0.00</td><td>300.00</td></tr></table> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td>All Forging Machines</td><td>31/08/2015</td><td>PENDING</td></tr></table>								Material Cost	Labour Cost	Total	300.00	0.00	300.00	Equipmnet	Target	Status	All Forging Machines	31/08/2015	PENDING
Material Cost	Labour Cost	Total																					
300.00	0.00	300.00																					
Equipmnet	Target	Status																					
All Forging Machines	31/08/2015	PENDING																					
Root Cause Allen key not suitable for use in this place																							
Date : 02/07/2015																							
Registered By : Mr. Ajit N																							
Manager's Sign : Reginal Jacob																							
----- Bajaj Auto Ltd. (Forging and Machining) -----																							