
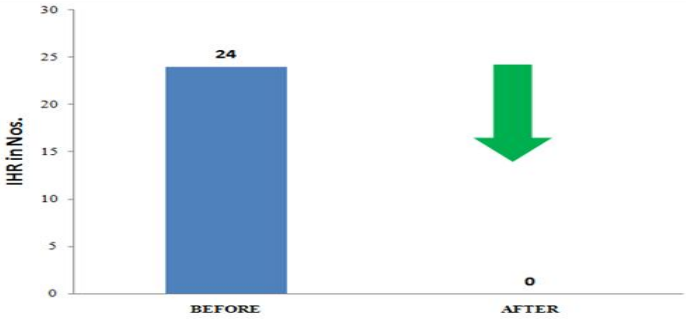
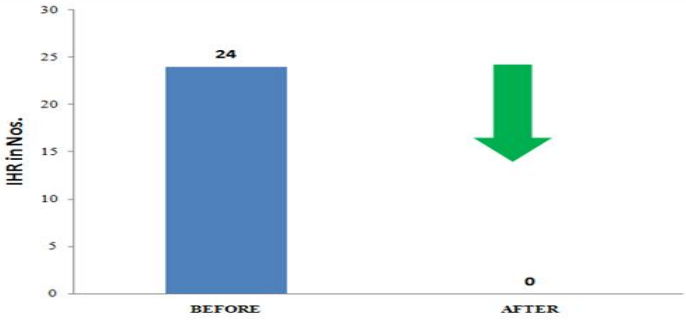
	Equipment :	Mnual Welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2764		
	Department :	Silencer shop	Result :	N	P	Q	C	D	S	M			
	Cell :	K1 Silencer shop	Type :										
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Mnual Welding										
Kaizen Theme: To reduce the inprocess defect of K1 silencer damper mtg bkt			Idea : To provide acess on welding fixture.										
Problem / Present Status			Counter Measure			Benchmark :		24 NOS					
On K1 line D-60 fixture Damper bkt shabby welding & leakage through welding joint. Daily Rework Qty- 24 Nos/day			To provide the welding access on fixture for full welding. We modify the damper bkt position by resting block provision with pneumatic clamping.			Target :		ZREO					
						Start :		13/11/2015		Finished : 11/02/2016			
						Note :							
						Team Members :							
						1. Mr.S.K.Satav		2. Mr.D.S.Hanawate					
						3. Mr.R.G.Panchal		4.					
5.		6.											
Why Why Analysis :			Result :			Kaizen Sustenance :							
W1 : Why To reduce the inprocess defect of K1 silencer damper mtg bkt ? A1 : Leakage thorough welding joint on damper bkt W2 : Why Leakage thorough welding joint on damper bkt ? A2 : Difficult to tack welding on fixture W3 : Why Difficult to tack welding on fixture ? A3 : No acess for welding on fixture W4 : Why No acess for welding on fixture ? A4 :			To Eliminate the IHR of k1 silencer Damper bkt shabby welding.			What To Do : 1) Daily check the pin & clamp looseness condition. 2) Daily check the Pneumatic cylinder working c							
Root Cause						How To Do : By JH/ PM							
No acess for welding on fixture						Frequency : dAILY & WEEKLY							
Date : 11/02/2016						Cost Incurred For Making Kaizen :							
Registered By : Mr. D M Sonawane						<table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>550.00</td> <td>200.00</td> <td>750.00</td> </tr> </table>					Material Cost	Labour Cost	Total
Material Cost	Labour Cost	Total											
550.00	200.00	750.00											
Manager's Sign : Mr. Arun Gawali			Scope & Plan For Horizontal Deployment :										
----- Bajaj Auto Ltd. (Fabrication) -----			Equipmnet		Target		Status						