DA IA	Equipment :	F-126stages		Los	s Type :	Defect	t Los	SS						KAIZEN IDEA SHEET				
№ BYTYT	Department :	Frame shop			Result :		F	P Q C		D	D S M		М					
Distinctly Ahead	Cell :	K2 -K3 FRAME			Type :					Kaizen ID			izen ID : 2779)				
Unit Name : 1004	28 - BADVE AUTOCO	MPS PVT LTD, Pune		N	Manual Welding													
Kaizen Theme: To reduce the IHR of Seat Cowl bkt due to wrong fitment. Idea: POKA-YOKE																		
Problem / Present Statu	s		Counter Measure					Benchr	Benchmark: 8 NOS									
On K2/K3 line F-126 Reverse welding fixture stage, there is possibility of reverse ffitment of Seat Cowl bkt due to which Daily= 08 nos of jobs wer			Modifying the seat cowl bkt block into cavity block so that the bkt reverse fitment possibility is eliminated totally the seat cowl bkt is located as				Э	Target	Target : zero)					
leverse miment of Seat C	owi bki due to willoit t	Daily= 00 flos of Jobs Wei	interior possibility is similated totally the seat sew six is located as					Start : 08/04/2016					Finished :	06/04/20	016			
D			x					Note :										
#								Team Members :										
	Second .							1. Mr.R.L.Patil					2. Mr.R.R.Choudary					
	600							3. Mr.G. B. Dombe					4.					
								5.					6.					
1 11	100							Benefits										
								P PR	P PRODUCTION INCREASED BY 8 NOS Nos 0.00									
	Possibali reverse fi							C RE	C REWORK COST SAVE (Rs 2 /Frame) Rs 0.00									
	The state of the s																	
Why Why Analysis: W1: Why To reduce the IHR of Seat Cowl bkt due to wrong fitment.?			Result:						Kaizen Sustenance : What To Do : poka -yoke condition check									
		•	Eliminated Reverse fitment of seat cowl bkt.						what 10 00 . poka -yoke condition check									
A1 : Seat Cowl bkt. Rejection for wrong position job welding																		
W2: Why Seat Cowl bkt. Rejection for wrong position job welding? A2: Possibility of seat cowl reverse fittment								How To	How To Do : JH/PM CHECK SHEET									
			9 8 8 8 IHR Reverse fittment of seat cowl bkt.															
W3: Why Possibility of seat cowl reverse fittment? A3: No provision on fixture to identify reverese fitment of job			7 6						5 BAHA									
1	-		5 - 4 - 3 - 4 - 3 - 4 - 3 - 4 - 3 - 4 - 3 - 4 - 3 - 4 - 3 - 4 - 4					Frequency : DAILY										
W4 : Why No provision or	•	•						Cost Incurred For Making Kaizen :										
A4 : POKA - Man can locate job in reveres condition			2 - 1 - 1					N	1aterial	Cost	ost Labo		_abour	Cost	Total			
			**************************************	2 2 2 2 2 2 5 5 5 5 5 5 5 5 5 5 5 5 5 5	1	1 2 2 2 2 0 0 0	1 H	2250		.00 69		650.	50.00		0.00			
			Sep. 1-04. 2-04. 2-04. 2-04. 3-30. 3	2000 2000 2000 2000 2000 2000	24.04 25.04 25.04	20 ct	31-0ct	Scope	Scope & Plan For Horizontal Deployment :									
Root Cause						0 11 11 21 21		Equipmnet							Target	Status		
POKA - Man can locate job in reveres condition																		
Date : 05/1	1/2015																	
	M Sonawane																	
Manager's Sign: Mr. A																		
Bajaj Auto Ltd.	(Fabrication)																	