

|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---|--------------------------------|---|-------------------|---|-------------------------------------------|---------------|-------------|-------|------|------|------|-----------|--------|--------|--|--|--|
|                                                                                                                                                                                                             | Equipment :  | S.S.Pating                                                                                                                                            | Loss Type :                                                    | Defect Loss |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   | KAIZEN IDEA SHEET<br><br>Kaizen ID : 2943 |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             | Department : | quality                                                                                                                                               | Result :                                                       | N           | P                                                                                                                                                                                                                                                                                                                                                                                                                                         | Q | C                              | D | S                 | M |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             | Cell :       | s.s.Plating                                                                                                                                           | Type :                                                         |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune                                                                                                                                                                                                                                          |              |                                                                                                                                                       | Operation : S.S.Plating                                        |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Kaizen Theme: To Reduce IHR                                                                                                                                                                                                                                                                 |              |                                                                                                                                                       | Idea : To provide additional cooling system with auto control. |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Problem / Present Status                                                                                                                                                                                                                                                                    |              | Counter Measure                                                                                                                                       |                                                                |             | Benchmark :                                                                                                                                                                                                                                                                                                                                                                                                                               |   | 38 nos                         |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| The chrome tank temp. remain high even after cooling tower water cooling system.                                                                                                                                                                                                            |              | Separate air coil with air solenoid valve installed. Air solenoid supply given in such way that when there is no load in tank air supply will be ON & |                                                                |             | Target :                                                                                                                                                                                                                                                                                                                                                                                                                                  |   | Zero                           |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | Start :                                                                                                                                                                                                                                                                                                                                                                                                                                   |   | 20/10/2016                     |   | Finished :        |   | 25/08/2016                                |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                              |              |                                                                      |                                                                |             | Note :                                                                                                                                                                                                                                                                                                                                                                                                                                    |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | Team Members :                                                                                                                                                                                                                                                                                                                                                                                                                            |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | 1. Shivaraj B. K                                                                                                                                                                                                                                                                                                                                                                                                                          |   |                                |   | 2. Narkhede B. H. |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | 3. Ade O. Z.                                                                                                                                                                                                                                                                                                                                                                                                                              |   |                                |   | 4.                |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | 5.                                                                                                                                                                                                                                                                                                                                                                                                                                        |   |                                |   | 6.                |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | Benefits                                                                                                                                                                                                                                                                                                                                                                                                                                  |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | C                                                                                                                                                                                                                                                                                                                                                                                                                                         |   | rework cost save Rs 988.00     |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             | P                                                                                                                                                                                                                                                                                                                                                                                                                                         |   | production increased Nos 38.00 |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Why Why Analysis :                                                                                                                                                                                                                                                                          |              | Result :                                                                                                                                              |                                                                |             | Kaizen Sustenance :                                                                                                                                                                                                                                                                                                                                                                                                                       |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| W1 : Why The chrome tank temp. remain high even after cooling tower water cooling system. ?<br>A1 : Chrome temp.high<br>W2 : Why Chrome temp.high ?<br>A2 : Insufficient cooling<br>W3 : Why Insufficient cooling ?<br>A3 : Poor basic condition<br>W4 : Why Poor basic condition ?<br>A4 : |              | IHR reduce from 38 nos to zero<br><br>                             |                                                                |             | What To Do : as per PM check sheet<br><br>How To Do : to check valve working periodically<br><br>Frequency :<br><br>Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>0.00</td><td>0.00</td><td>0.00</td></tr></table><br>Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td colspan="3"></td></tr></table> |   |                                |   |                   |   |                                           | Material Cost | Labour Cost | Total | 0.00 | 0.00 | 0.00 | Equipmnet | Target | Status |  |  |  |
| Material Cost                                                                                                                                                                                                                                                                               | Labour Cost  | Total                                                                                                                                                 |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| 0.00                                                                                                                                                                                                                                                                                        | 0.00         | 0.00                                                                                                                                                  |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Equipmnet                                                                                                                                                                                                                                                                                   | Target       | Status                                                                                                                                                |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
|                                                                                                                                                                                                                                                                                             |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Root Cause<br>Poor basic condition                                                                                                                                                                                                                                                          |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Date : 20/10/2016                                                                                                                                                                                                                                                                           |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Registered By : Mr. D M Sonawane                                                                                                                                                                                                                                                            |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| Manager's Sign : Mr. Arun Gawali                                                                                                                                                                                                                                                            |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |
| ----- Bajaj Auto Ltd. (Fabrication) -----                                                                                                                                                                                                                                                   |              |                                                                                                                                                       |                                                                |             |                                                                                                                                                                                                                                                                                                                                                                                                                                           |   |                                |   |                   |   |                                           |               |             |       |      |      |      |           |        |        |  |  |  |