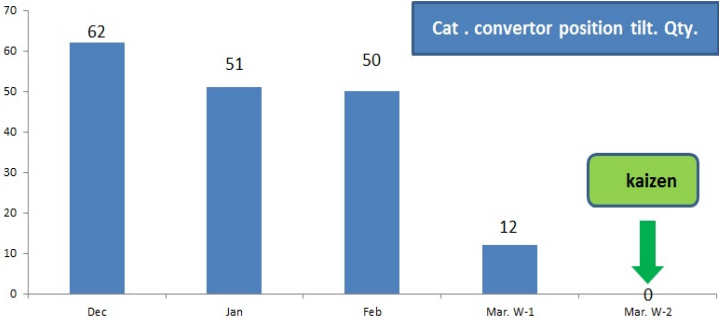


|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-------------------------------------------------------------------------------------|------------------------------------|-------------|-------------------------------------------|---|-----------------------|---|------------|---|-------------------------------------------|--|
|                                                                                                                                                                                                                                                                                                                                                                     | Equipment :  | FIXTURE                                                                             | Loss Type :                        | Defect Loss |                                           |   |                       |   |            |   | KAIZEN IDEA SHEET<br><br>Kaizen ID : 3010 |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Department : | SILENCER QUALITY                                                                    | Result :                           | N           | P                                         | Q | C                     | D | S          | M |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Cell :       | Silencer fabrication                                                                | Type :                             |             |                                           |   |                       |   |            |   |                                           |  |
| Unit Name : 110865 - METALMAN MICRO TURNERS,                                                                                                                                                                                                                                                                                                                                                                                                        |              |                                                                                     | Operation : Round welding          |             |                                           |   |                       |   |            |   |                                           |  |
| Kaizen Theme: To eliminate the in house defect Cat.convertor position tilt.                                                                                                                                                                                                                                                                                                                                                                         |              |                                                                                     | Idea : increase the mandrel length |             |                                           |   |                       |   |            |   |                                           |  |
| Problem / Present Status                                                                                                                                                                                                                                                                                                                                                                                                                            |              | Counter Measure                                                                     |                                    |             | Benchmark :                               |   | 0                     |   |            |   |                                           |  |
| Cat. convertor position tilt                                                                                                                                                                                                                                                                                                                                                                                                                        |              | Provide the New mandrel for part locating .                                         |                                    |             | Target :                                  |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                     |              |    |                                    |             | Start :                                   |   | 02/03/2017            |   | Finished : |   | 06/03/2017                                |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Note :                                    |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Team Members :                            |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | 1. MR. SARVESH KUMAR                      |   | 2. MR. SANJEEV KUMAR  |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | 3. MR. MUKESH KUMAR                       |   | 4. MR. JITENDRA JOSHI |   |            |   |                                           |  |
| 5. MR. ANURAG                                                                                                                                                                                                                                                                                                                                                                                                                                       |              | 6. MR. MAHESH PANT                                                                  |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| Benefits                                                                                                                                                                                                                                                                                                                                                                                                                                            |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| P                                                                                                                                                                                                                                                                                                                                                                                                                                                   |              | Increase Nos 5.00                                                                   |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| Q                                                                                                                                                                                                                                                                                                                                                                                                                                                   |              | Improve Nos 0.00                                                                    |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| M                                                                                                                                                                                                                                                                                                                                                                                                                                                   |              | high Days 0.00                                                                      |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| Why Why Analysis :                                                                                                                                                                                                                                                                                                                                                                                                                                  |              | Result :                                                                            |                                    |             | Kaizen Sustenance :                       |   |                       |   |            |   |                                           |  |
| W1 : Why Part tilt ?<br>A1 : Cat. Convertor shift on during clamping.<br>W2 : Why Cat. Convertor shift on during clamping. ?<br>A2 : locating clamp proper not detect the part.<br>W3 : Why locating clamp proper not detect the part. ?<br>A3 : Cat. Convertor locating clamp mandral length was less obs.5.0mm..<br>W4 : Why Cat. Convertor locating clamp mandral length was less obs.5.0mm.. ?<br>A4 : Locating mandrel design not As per part. |              | Achieve Zero part tilting                                                           |                                    |             | What To Do : Point Add to Ctq audit sheet |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |  |                                    |             | How To Do : Visual                        |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Frequency : Twice in a shift              |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Cost Incurred For Making Kaizen :         |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Material Cost                             |   | Labour Cost           |   | Total      |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | 250.00                                    |   | 250.00                |   | 500.00     |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Scope & Plan For Horizontal Deployment :  |   |                       |   |            |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Equipmnet                                 |   | Target                |   | Status     |   |                                           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                     |              |                                                                                     |                                    |             | Fixture                                   |   | 06/03/2017            |   | COMPLETE   |   |                                           |  |
| Root Cause<br>Mandrel design not as per part                                                                                                                                                                                                                                                                                                                                                                                                        |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| Date : 27/03/2017                                                                                                                                                                                                                                                                                                                                                                                                                                   |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| Registered By : Mr. Sanjeev Kumar                                                                                                                                                                                                                                                                                                                                                                                                                   |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| Manager's Sign : MR Ajendra Giri                                                                                                                                                                                                                                                                                                                                                                                                                    |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |
| ----- Bajaj Auto Ltd. (Fabrication) -----                                                                                                                                                                                                                                                                                                                                                                                                           |              |                                                                                     |                                    |             |                                           |   |                       |   |            |   |                                           |  |