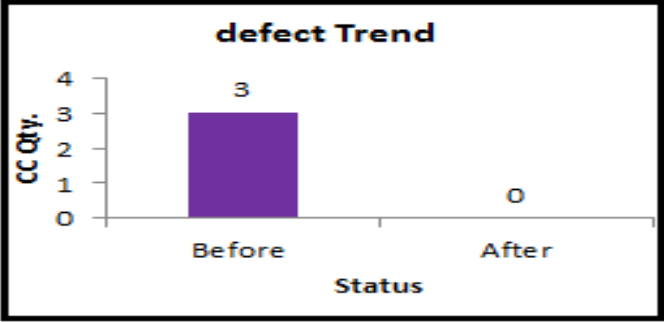


	Equipment :	F-130 Joinery Fixture	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 3140
	Department :	QA	Result :	N	P	Q	C	D	S	M	
	Cell :	CT125	Type :								
Unit Name : 112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation : Shocker Bkt. welding Stage (Frame Joinery)								
Kaizen Theme: To prevent customer complaint of wrong side shocker bkt fitment in CT125 frame.			Idea : Operation Interlocking with machine								
Problem / Present Status		Counter Measure			Benchmark :		3				
Possibility of wrong fitment (interchange) of shocker bkt. LH to RH during welding at joinery fixture.		1. To provide step pin for bush location. 2. To provide cylinder with reed. 3 To Interlock opearation if wrong bkt lacate with welding machine.			Target :		0				
					Start :		10/08/2017		Finished :		15/08/2017
					Note :						
					Team Members :						
					1. Jamdhade B.U				2. Salunke P.A		
					3. Nikhade M.L				4.		
					5.				6.		
Why Why Analysis :		Result :			Kaizen Sustenance :						
W1 : Shocker fitment difficult. A1 : Wrong side bkt LH to RH fitted in frame. (Interchanged) W2 : Why Wrong side bkt LH to RH fitted in frame. (Interchanged)? A2 : No interlocking poka provision in fixture W3 : Why No interlocking poka provision in fixture ? A3 : W4 : A4 :		Possibility of wrong shocker bkt. fitment become zero. 			What To Do : 1) Step pin dia. checking. 2) Interlocking Audit. 3) Poka yoke Monitoring - Audit						
					How To Do : 1) Daily JH Points. 2) PM check sheet. 3) QA process Audit sheet						
					Frequency : Daily						
					Cost Incurred For Making Kaizen :						
Root Cause					Material Cost		Labour Cost		Total		
No interlocking poka provision in fixture					800.00		400.00		1200.00		
Date : 20/09/2017					Scope & Plan For Horizontal Deployment :						
Registered By : Mr. D S Lade					Equipmnet		Target		Status		
Manager's Sign :					NA		20/09/2017		COMPLETE		
----- Bajaj Auto Ltd. (Fabrication) -----											