

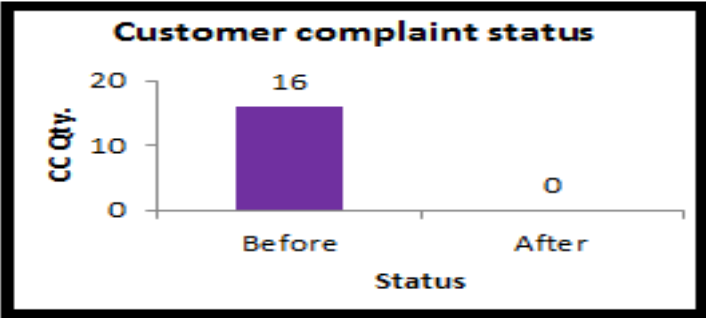
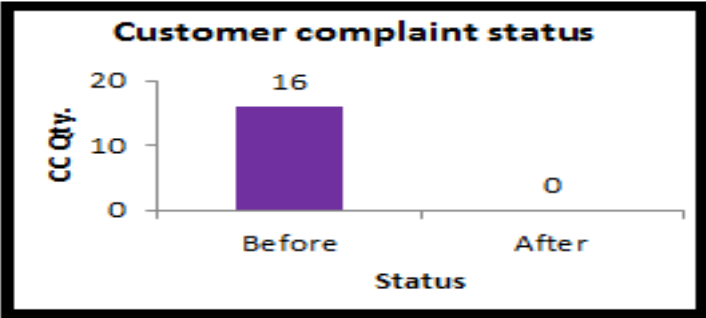
	Equipment :	Box assly. 2nd Stage	Loss Type :		Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 3141			
	Department :	QA	Result :		N	P	Q	C	D	S	M				
	Cell :	CT125	Type :												
Unit Name :			112933 - Metalman Auto Pvt Ltd., Aurangabad			Operation :							Box assly. 2nd robotic welding stage		
Kaizen Theme:			To Prevent Customer complaint of seat cowl bkt shift in CT125 frame.			Idea :							Part location & operation split		
Problem / Present Status			Counter Measure					Benchmark :		16					
Seat cowl bkt LH/RH shift by 10 mm towards rear side.			1. To Provide LH/RH locating block in ladder fixture. 2. To Provide single piece fixed block & operation inetrlocked by reed.					Target :		0					
								Start :		06/07/2017		Finished :		20/09/2017	
								Note :							
								Team Members :							
								1. Tambe B.G		2. Nikhade M.L					
		3. Salunke P.A		4.				5.		6.					
Why Why Analysis :			Result :					Kaizen Sustenance :							
W1 : Why To Prevent Customer complaint of seat cowl bkt shift in CT125 frame. ? A1 : Seat cowl bkt shift in frame. W2 : Why Seat cowl bkt shift in frame. ? A2 : During setup change block fitment wrong LH to RH. W3 : Why During setup change block fitment wrong LH to RH. ? A3 : Required 03 to 04 time block changes for setup change. W4 : Why Required 03 to 04 time block changes for setup change. ? A4 : Combine operation in fixture			IHR and Customer complaint zero. 					What To Do : 1) LH / RH Locating block provided on fixture. 2) Dimension Parameter Monitoring How To Do : 1) Daily JH Points. 2) CMM 3) QA - Process Audit sheet. Frequency : Daily/Weekly							
Root Cause								Cost Incurred For Making Kaizen :							
Combine operation in fixture								Material Cost		Labour Cost		Total			
Date :								5000.00		2000.00		7000.00			
Registered By :															
Manager's Sign :			Scope & Plan For Horizontal Deployment :												
----- Bajaj Auto Ltd. (Fabrication) -----			Equipmnet		Target		Status								