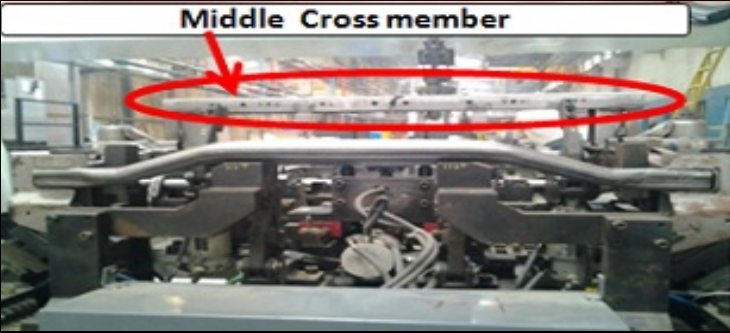


	Equipment :	RE-16(MIG Machine)	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 499						
	Department :	RE Chassis	Result :	N	P	Q	C	D	S	M							
	Cell :	RE Chassis	Type :														
Unit Name : 100264 - RUCHA ENGINEERING PVT LTD., Aurangabad			Operation : Co 2 Welding														
Kaizen Theme: To eliminate In-House Rejection			Idea : Pokayoke														
Problem / Present Status			Counter Measure			Benchmark :		12									
Middle Cross Member revers side assly			Provided Machenical Stopper wrt to MCM Tooling Hole also Interlock with welding cycle			Target :		0									
						Start :		05/01/2013		Finished : 08/01/2013							
						Note :											
						Team Members :											
						1. Mr. RD Jadhav			2. Mr.ST Pawer								
						3. Mr.PT Suradkar			4.								
						5.			6.								
						Benefits											
						Q		IHR Zero Rs 0.00									
						C		Rs 43200 per month cost save Rs 0.00									
						D		100% Rs 0.00									
Why Why Analysis :			Result :			Kaizen Sustenance :											
W1 : Why Middle Cross Member reverse side assly ? A1 : Provsision on fixture W2 : Why Provsision on fixture ? A2 : New negligible no provision for POKA-YOKE W3 : Why New negligible no provision for POKA-YOKE ? A3 : W4 : A4 :			Total IHR Before -12 chassis /Month Total IHR After - 0 chassis /Month Before Improvement  no any provision on fixture will be MCM wrong side assly After Improvement  Provide Mechanical stopper guide pin & sensor on MCM tooling hole			What To Do : Fixture JH Check Sheet Updated How To Do : Interlock with Welding Cycle Frequency : - Cost Incurred For Making Kaizen : <table border="1" style="width: 100%;"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>1620.00</td> <td>275.00</td> <td>1895.00</td> </tr> </table>						Material Cost	Labour Cost	Total	1620.00	275.00	1895.00
Material Cost	Labour Cost	Total															
1620.00	275.00	1895.00															
Root Cause Poka			Before Improvement  no any provision on fixture will be MCM wrong side assly After Improvement  Provide Mechanical stopper guide pin & sensor on MCM tooling hole			Scope & Plan For Horizontal Deployment :											
Date : 05/01/2013						Equipmnet			Target		Status						
Registered By : Mr. A A Girme						A Line			06/01/2013		COMPLETE						
Manager's Sign : Mr.R S Makasare						B Line			06/01/2013		COMPLETE						
----- Bajaj Auto Ltd. (Fabrication) -----																	