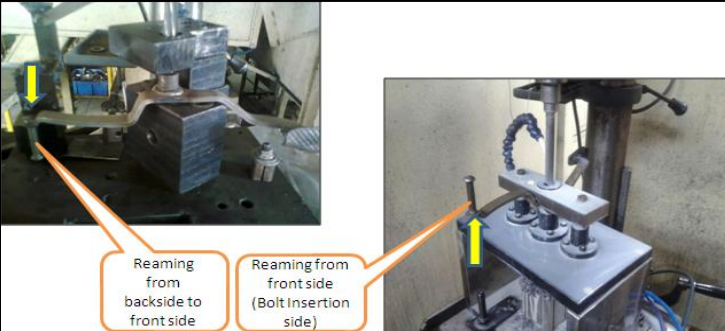


	Equipment :	Discover Gear Reaming M/C	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 522
	Department :	BP&GCL	Result :	N	P	Q	C	D	S	M	
	Cell :	GCL	Type :								
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : Reaming								
Kaizen Theme: To Eliminate IHR of bolt insertion hard in boss due to part position shift			Idea : To Change of fixture Orientation to prevent of part position shift								
Problem / Present Status		Counter Measure		Benchmark :		150 Nos					
Daily 100% IHR for bolt insertion hard due to Bur in front side of Discover gear at assly stage while bolt insertion .		Changing Fixture orientation along with location of boss for ream from front side to back side.		Target :		Zero					
				Start :		05/09/2013		Finished :		12/09/2013	
				Note :							
				Team Members :		1. Mr.S M Kamble 2. Mr. A G Naekkhede 3. Mr. D G Chape 4. 5. 6.					
				Benefits							
				Q	Eliminate IHR of Bolt insertion hard Nos 0.00						
				C	Save rework cost of manpower 120 Rs./Day Rs 120.00						
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Daily 100% IHR for bolt insertion hard due to Bur in front side of Discover gear at assly stage while bolt insertion . ? A1 : Burr in boss at front side W2 : Why Burr in boss at front side ? A2 : Reaming can not done from front side W3 : Why Reaming can not done from front side ? A3 : Fixture orientation not matching to job profile W4 : Why Fixture orientation not matching to job profile ? A4 :		Eliminate IHR from 150 Nos. to Zero 		What To Do : Tool & fixture maint PM to be done. How To Do : Pneumatic clamping with sensor for reaming Frequency : Weekly							
Root Cause				Cost Incurred For Making Kaizen :							
Fixture orientation not matching to job profile						Material Cost		Labour Cost		Total	
						2253.00		150.00		2403.00	
Date : 05/09/2013				Scope & Plan For Horizontal Deployment :							
Registered By : Mr. D M Sonawane				Equipmnet		Target		Status			
Manager's Sign : Mr. Arun Gawali				K4 Gear reaming		22/09/2013		COMPLETE			
----- Bajaj Auto Ltd. (Fabrication) -----											