



|  | Equipment : | Full Welding | Loss Type : | | | | | Defect Loss | | | | | KAIZEN IDEA SHEET | | | | | | | | | | | |
|--|--------------------|--------------|--|--|---|---|---|--|------------|---------------|-------------------|------------|--------------------------|-------------|-------|--------|--------|--------|-----------|--------|--------|--|--|--|
| | Department | Quality | Result : | | N | P | Q | C | D | S | M | | | | | | | | | | | | | |
| | | | Type : | | | | | | | | | | | | | | | | | | | | | |
| Cell : (3W)Full frame | | | Operation : Full welding | | | | | | | | | | | | | | | | | | | | | |
| Kaizen Theme: To eliminate rejection for Welding lumps at main member ,lower part & lower reinforcement joining | | | Idea : No mannual error | | | | | | | | | | | | | | | | | | | | | |
| Problem / Present Status | | | Counter Measure | | | | | Benchmark : | | 1146/month | | | | | | | | | | | | | | |
| Welding lumps at at main member ,lower part & lower reinforcement joining due to heavy gap. | | | By providing copper plate at FF-30 main member,bottom reinforcement & lower part weld joint bottom side area. | | | | | Target : | | zero/month | | | | | | | | | | | | | | |
| | | | | | | | | Start : | 12/08/2013 | | Finished : | 17/08/2013 | | | | | | | | | | | | |
| | | | | | | | | Note : | | | | | | | | | | | | | | | | |
| | | | | | | | | Team Members : | | | | | | | | | | | | | | | | |
| | | | | | | | | 1. Mr.Chopade | | 2. Mr.Rakhade | | | | | | | | | | | | | | |
| | | | | | | | | 3. | | 4. | | | | | | | | | | | | | | |
| | | | | | | | | 5. | | 6. | | | | | | | | | | | | | | |
| | | | | | | | | Benefits | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | |
| Why Why Analysis : | | | Result : | | | | | Kaizen Sustenance : | | | | | | | | | | | | | | | | |
| W1 : Why To eliminate rejection for Welding lumps at main member ,lower part & lower reinforcement joining due to heavy gap. ? A1 : Co2 weld lumps at lower reinf & Y member weld joint W2 : Why Co2 weld lumps at lower reinf & Y member weld joint ? A2 : Gap observed at lower reinf & Y member. W3 : Why Gap observed at lower reinf & Y member. ? A3 : Create mannualy gap for main member assly insetion. W4 : Why Create mannualy gap for main member assly insetion. ? A4 : Mannualy error. | | | No Lumps at main member  | | | | | What To Do : Check copper plate bolting & top surface. How To Do : Point added in daily JH check sheet. Frequency : Daily 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>400.00</td> <td>180.00</td> <td>580.00</td> </tr> </table> Scope & Plan For Horizontal Deployment : <table border="1" style="width: 100%;"> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> <tr> <td colspan="3" style="height: 100px;"></td> </tr> </table> | | | | | Material Cost | Labour Cost | Total | 400.00 | 180.00 | 580.00 | Equipmnet | Target | Status | | | |
| Material Cost | Labour Cost | Total | | | | | | | | | | | | | | | | | | | | | | |
| 400.00 | 180.00 | 580.00 | | | | | | | | | | | | | | | | | | | | | | |
| Equipmnet | Target | Status | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause Mannually error. | | | | | | | | | | | | | | | | | | | | | | | | |
| Date : 12/08/2013 | | | | | | | | | | | | | | | | | | | | | | | | |
| Registered By : Mr. A S Pawar | | | | | | | | | | | | | | | | | | | | | | | | |
| Manager's Sign : Mr. D T RANE | | | | | | | | | | | | | | | | | | | | | | | | |
| ----- Bajaj Auto Ltd. ----- | | | | | | | | | | | | | | | | | | | | | | | | |