
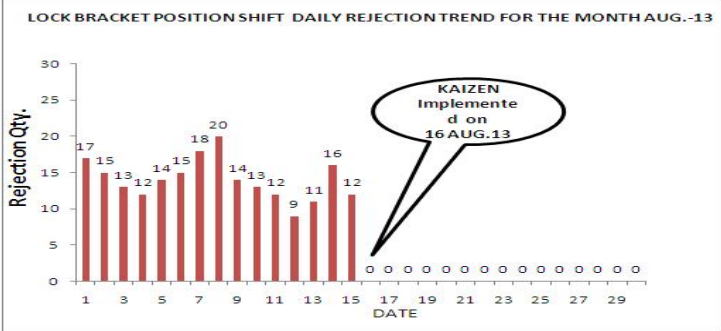


|   |             |  |   |  |   |  |   |            |   |            |                          |
|---|-------------|--|---|--|---|--|---|------------|---|------------|--------------------------|
|   | Equipment : | SPM F-10   | Loss Type :   | Defect Loss  |   |  |   |            |   |            | <b>KAIZEN IDEA SHEET</b> |
|   | Department  | Frame Production   | Result :  | N  | P | Q  | C | D          | S | M          |                          |
|   |             |  | Type :  |  |   |  |   |            |   |            |                          |
| Cell : K1 Frame Cell  |             |  | Operation : welding   |  |   |  |   |            |   |            |                          |
| Kaizen Theme: To eliminate rejection of lock bracket position shift   |             |  | Idea : To change the design of clamping from manual to pneumatic. |  |   |  |   |            |   |            |                          |
| Problem / Present Status  |             | Counter Measure  |   | Benchmark :  |   | 15 nos/day   |   |            |   |            |                          |
| Rejection of lock bracket position shift in " Y " axis at stage F-10. Daily rejection qty.- 15 nos.   |             | providing pneumatic clamping for locating the  |   | Target :   |   |  |   |            |   |            |                          |
|   |             |  |   | Start :  |   | 12/08/2013   |   | Finished : |   | 16/08/2013 |                          |
|   |             |  |   | Note :   |   |  |   |            |   |            |                          |
|   |             |  |   | Team Members :   |   |  |   |            |   |            |                          |
|   |             |  |   | 1. Mr. M M Bawkar  |   | 2. Mr. R M Shame   |   |            |   |            |                          |
|   |             |  |   | 3.   |   | 4.   |   |            |   |            |                          |
|   |             |  |   | 5.   |   | 6.   |   |            |   |            |                          |
|   |             |  |   | Benefits   |   |  |   |            |   |            |                          |
|   |             |  |   | P  |   | productivity is improved from 235 nos. to 250 nos./ shift. Nos 15.00 |   |            |   |            |                          |
|   |             |  |   | Q  |   | Elimination of daily rejection from 15 nos. to zero. Nos 15.00       |   |            |   |            |                          |
|   |             |  |   | C  |   | Cost of rejection is saved from Rs. 300/- to Rs. 0/- Nos 300.00      |   |            |   |            |                          |
| Why Why Analysis :  |             | Result :   |   | Kaizen Sustenance :  |   |  |   |            |   |            |                          |
| W1 : Why bracket position shift in " Y " axis ?<br>A1 : In correct location of lock bracket<br>W2 : Why In correct location of lock bracket ?<br>A2 : Locating pins getting loose<br>W3 : Why Locating pins getting loose ?<br>A3 : Clamping of locating pins manually.<br>W4 : Why Clamping of locating pins manually. ?<br>A4 : |             | Rejection of lock bracket position shift is eliminated 100%<br><br> |   | What To Do : Daily audit of pokayoke working at start of every shift.<br><br>How To Do : Monitoring through Pokayoke check sheet<br><br>Frequency : start of shift |   |  |   |            |   |            |                          |
| Root Cause<br>Clamping of locating pins manually.   |             |  |   | Cost Incurred For Making Kaizen :  |   |  |   |            |   |            |                          |
| Date : 12/08/2013   |             |  |   | Material Cost  |   | Labour Cost  |   | Total      |   |            |                          |
| Registered By : Mr. D M Sonawane  |             |  |   | 3000.00  |   | 200.00   |   | 3200.00    |   |            |                          |
| Manager's Sign : Mr. Arun Gawali  |             |  |   | Scope & Plan For Horizontal Deployment :   |   | Equipmnet  |   | Target     |   | Status     |                          |
| ----- Bajaj Auto Ltd. (Fabrication) -----   |             |  |   | no scope   |   | 28/10/2013   |   | PENDING    |   |            |                          |