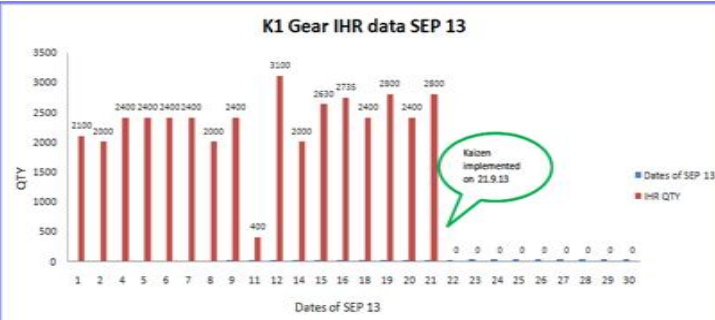
	Equipment :	Relation gauge	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 536
	Department :	BPGCI Production	Result :	N	P	Q	C	D	S	M	
	Cell :	Gear change lever	Type :								
Unit Name : 100428 - BADVE AUTOCOMPS PVT LTD, Pune			Operation : K1 Gear full welding								
Kaizen Theme: To Reduce IHR of K1 gear not qualify to relation gauge by prevent part position shift in fixture			Idea : To modify locating block (fix block pad) to prevnt part position shift in fixture								
Problem / Present Status			Counter Measure			Benchmark :		2000 Nos			
100% rework of k1 gear at gauging stage due to blank not qualify to relation gauge .			To provide fix block pad to locate (lock) the position of K1 gear while full welding (SPM). Reduce locating block ID by 23 mm to 20.5 mm			Target :		Zero			
						Start :	16/09/2013	Finished :	21/09/2013		
						Note :					
						Team Members :					
						1. Mr. D S Gurav		2. Mr. A R Akhare			
						3. Mr. A G Narkhede		4.			
						5.		6.			
						Benefits					
						Q	To eliminate IHR of K1 Gear not qulifying to relation gauge Rs 0.00				
						C	Fix. Cost save (inhouse made) Rs 5000.00				
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why K1 gear not qualify to relation gauge by preventing part position shift in fixture. ? A1 : K1 gear blank loosly fit in fixture W2 : Why K1 gear blank loosly fit in fixture ? A2 : K1 gear blank not located in welding fixture. W3 : Why K1 gear blank not located in welding fixture. ? A3 : K1 Gear blank Locating block design wrong (Part position shift in fixture block) W4 : Why K1 Gear blank Locating block design wrong (Part position shift in fixture block) ? A4 :			Eliminate IHR of K1 gear from 100% rework 			What To Do : Monthly Fixture PM to be done for block dimension. How To Do : Block ID 20.5 mm to be checked at time of PM. Frequency : monthly					
Root Cause						Cost Incurred For Making Kaizen :					
K1 Gear blank Locating block design wrong (Part position shift in fixture block)						Material Cost		Labour Cost		Total	
Date : 16/09/2013						5000.00		2000.00		7000.00	
Registered By : Mr. D M Sonawane						Scope & Plan For Horizontal Deployment :					
Manager's Sign : Mr. Arun Gawali						Equipmnet		Target	Status		
						JC Gear SPM welding		08/11/2013	PROCESS		
----- Bajaj Auto Ltd. (Fabrication) -----											