<b>≱</b> BAJAJ	Equipment :	Relation gauge		Loss Type	e : Defec	t Lo	oss					KAIZEN IDEA SHEET			
	Department :	BPGCI Production		Result :	N	Г	P Q	С	D	S	М	1			
Unstructly Akead	Cell:	Gear change lever		Type:									Kaizen ID : 536		
Unit Name: 10042	28 - BADVE AUTOCOM	MPS PVT LTD, Pune		Operation: K1 Gear full welding											
Kaizen Theme: To Re	educe IHR of K1 gear n	ot qualify to relation gauge	by prevent part position shifit in fixture	dea: To	modify lo	cati	ing block (	fix block	c pad )	to prev	nt part po	sition shift in t	ixture		
Problem / Present Status			Counter Measure					Benchmark: 2000 No				os			
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				Target	Target: Zero							
			welding (SPM). Reduce locating block ID by 23 mm to 20.5 mm					<b>Start</b> : 16/09/2013		1	Finished: 21/09/2013		2013		
1			COLUMN TO THE PARTY OF THE PART				Note :								
							Team Members :								
200	- ALC: 1						1. Mr. D S Gurav					2. Mr. A R Akhare			
						3. Mr. A G Narkhede				4.					
- 8		block ID- 23 mm					5.					6.			
2	The same of	COLUMN CO						Benefits							
			block ID-				Q To eliminate IHR of K1 Gear not qulifying to relation gauge Rs 0.00								
Changable	le sating a sed		20.5 mm					C Fix. Cost save (inhouse made) Rs 5000.00							
200000000000000000000000000000000000000	locating pad		Fixed block												
Why Why Analysis: W1: Why K1 gear not qualify to relation gauge by preventing part position			Result:					Kaizen Sustenance :  What To Do : Monthly Fixture PM to be done for block dimension.							
shifit in fixture. ?  A1 : K1 gear blank loosly fit in fixture			Eliminate IHR of K1 gear from 100% rework					What to bo . Monthly Fixture Five to be done for block difficultion.							
W2 : Why K1 gear blank loosly fit in fixture ?								How To Do : Block ID 20.5 mm to be checked at time of PM.							
A2 : K1 gear blank not located in welding fixture.			K1 Gear IHR data SEP 13												
W3 : Why K1 gear blank not located in welding fixture. ?			3500 3000 2500 2500 2400240034003400 3400 2400 2400 2400 2400												
A3 : K1 Gear blank Locating block design wrong (Part posittion shift in								Frequency: monthly							
fixture block) W4: Why K1 Gear blank Locating block design wrong (Part posittion shift in fixture block)? A4:			2000 2000 kaisen implemented					Cost Incurred For Making Kaizen :							
			° 1000			SEP 1	Material Cost		Cost		Labour Cost		Total		
			0	0 0 0 0 0 0	0 0 0 0 0 0			5000.0	00		20	000.00 7000.00		0.00	
			1 2 4 5 6 7 8 9 11 12 14 15 16 18 19 20 21 22 23 24 15 26 27 28 29 30  Dates of SEP 13				Scope	Scope & Plan For Horizontal Deployment :							
Root Cause							Equipmnet				Target	Status			
K1 Gear blank Locating block design wrong (Part posittion shift in fixture block)							JC Gear SPM welding				08/11/2013 PROCESS				
Date : 16/09/	/2013														
Registered By: Mr. D	M Sonawane														
Manager's Sign: Mr. Ar															
Bajaj Auto Ltd. (	Fabrication)														