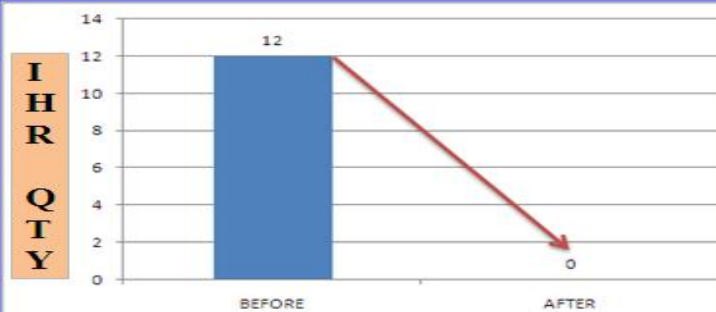


|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---|---------------------------------|---|--------------------|---|------------|-------------------|---------------|-------------|-------|---------|--------|---------|
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Equipment : | F-100                                                                                                                                              | Loss Type :                              | Defect Loss                                                                                                                                                                                                                                                                                                                                                      |   |                                 |   |                    |   |            | KAIZEN IDEA SHEET |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Department  | Frame production                                                                                                                                   | Result :                                 | N                                                                                                                                                                                                                                                                                                                                                                | P | Q                               | C | D                  | S | M          |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    | Type :                                   |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| Cell : K4 Frame                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    | Operation : welding                      |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| Kaizen Theme: To Reduce IHR of Pillion stay bkt on F-100 stage by preventing part position shift in fixture.                                                                                                                                                                                                                                                                                                                                                                                                                                                     |             |                                                                                                                                                    | Idea : No part position shift in fixture |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| Problem / Present Status                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |             | Counter Measure                                                                                                                                    |                                          | Benchmark :                                                                                                                                                                                                                                                                                                                                                      |   | 12 Nos                          |   |                    |   |            |                   |               |             |       |         |        |         |
| Pillion Stay bkt plane position vary                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |             | Pillion Stay Bkt provided the new resting block with cavity resting location to maintain the plane of pillion stay bkt wrt swing arm resting bush. |                                          | Target :                                                                                                                                                                                                                                                                                                                                                         |   | Zero                            |   |                    |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | Start :                                                                                                                                                                                                                                                                                                                                                          |   | 14/10/2013                      |   | Finished :         |   | 19/10/2013 |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | Note :                                                                                                                                                                                                                                                                                                                                                           |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | Team Members :                                                                                                                                                                                                                                                                                                                                                   |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | 1. Mr. N P Kharade                                                                                                                                                                                                                                                                                                                                               |   |                                 |   | 2. Mr. P S Kavhale |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | 3. Mr. P S Patil                                                                                                                                                                                                                                                                                                                                                 |   |                                 |   | 4.                 |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | 5.                                                                                                                                                                                                                                                                                                                                                               |   |                                 |   | 6.                 |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | Benefits                                                                                                                                                                                                                                                                                                                                                         |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | P                                                                                                                                                                                                                                                                                                                                                                |   | Maintain productivity Nos 12.00 |   |                    |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          | Q                                                                                                                                                                                                                                                                                                                                                                |   | To reduce IHR Nos 12.00         |   |                    |   |            |                   |               |             |       |         |        |         |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |             |                                                                                                                                                    |                                          |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| Why Why Analysis :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |             | Result :                                                                                                                                           |                                          | Kaizen Sustenance :                                                                                                                                                                                                                                                                                                                                              |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| W1 : Why Pillion Stay bkt plane position shift ?<br>A1 : Pillion Stay bkt plane position not maintain wrt swing arm bush<br>W2 : Why Pillion Stay bkt plane position not maintain wrt swing arm bush ?<br>A2 : No Resting Location on fixture to maintain the plane<br>W3 : Why No Resting Location on fixture to maintain the plane ?<br>A3 : Weak fixture design / No provision to maintain the bkt plane (Part position shift in fixture)<br>W4 : Why Weak fixture design / No provision to maintain the bkt plane (Part position shift in fixture) ?<br>A4 : |             | Reduce the IHR Qty 12 to 0.<br><br>                             |                                          | What To Do : Daily Clean the fixed cavity location.<br>Weekly PM to be done.<br><br>How To Do : By Daily JH & Weekly PM<br><br>Frequency : Daily, Weekly<br><br>Cost Incurred For Making Kaizen : <table border="1"> <tr> <td>Material Cost</td> <td>Labour Cost</td> <td>Total</td> </tr> <tr> <td>2215.00</td> <td>800.00</td> <td>3015.00</td> </tr> </table> |   |                                 |   |                    |   |            |                   | Material Cost | Labour Cost | Total | 2215.00 | 800.00 | 3015.00 |
| Material Cost                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Labour Cost | Total                                                                                                                                              |                                          |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| 2215.00                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 800.00      | 3015.00                                                                                                                                            |                                          |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| Root Cause<br>Weak fixture design / No provision to maintain the bkt plane (Part position shift in fixture)                                                                                                                                                                                                                                                                                                                                                                                                                                                      |             |                                                                                                                                                    |                                          | Scope & Plan For Horizontal Deployment :                                                                                                                                                                                                                                                                                                                         |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| Date : 14/10/2013                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |             |                                                                                                                                                    |                                          | Equipmnet                                                                                                                                                                                                                                                                                                                                                        |   |                                 |   | Target             |   | Status     |                   |               |             |       |         |        |         |
| Registered By : Mr. D M Sonawane                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |             |                                                                                                                                                    |                                          | No Scope                                                                                                                                                                                                                                                                                                                                                         |   |                                 |   | 30/10/2013         |   | PROCESS    |                   |               |             |       |         |        |         |
| Manager's Sign : Mr. Arun Gawali                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |             |                                                                                                                                                    |                                          |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |
| ----- Bajaj Auto Ltd. -----                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |             |                                                                                                                                                    |                                          |                                                                                                                                                                                                                                                                                                                                                                  |   |                                 |   |                    |   |            |                   |               |             |       |         |        |         |