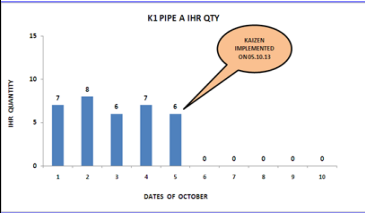


	Equipment :	Spacer round welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department	Tool Fix. maint.	Result :	N	P	Q	C	D	S	M	
			Type :								
Cell : K1 Pre - I			Operation : Leakage Testing								
Kaizen Theme: To eliminate IHR of K1 pipe A welding tilt on spacer round welding stage by preventing of part orie			Idea : Part Orientation OK								
Problem / Present Status			Counter Measure			Benchmark :		6 Nos.			
Daily 6-7 nos IHR of K1 Pipe A as spacer welding tilt at Pipe A + Spacer round welding stage due to improper locating of spacer.			To modify locating block profile of spacer from half Profile to full round profile Block ID = 43 mm to get required part orientation			Target :		Zero			
						Start :	09/09/2013	Finished :	05/10/2013		
						Note :					
						Team Members :					
						1. Mr. S B Dhore		2. Mr. P P Kulkarni			
						3. Mr. S K Shinde		4. Mr. K B Dhondge			
						5.		6.			
						Benefits					
						P	Cycle time reduced by 3 sec by eliminating clamping operation Nos 1.00				
						Q	eliminate IHR Nos 0.00				
Why Why Analysis :			Result :			Kaizen Sustenance :					
W1 : Why Spacer welding tilt ? A1 : Improper locating of spacer W2 : Why Improper locating of spacer ? A2 : Spacer locating clamp not as per spacer profile(Part Orientation Not OK) W3 : Why Spacer locating clamp not as per spacer profile(Part Orientation Not OK) ? A3 : W4 : A4 :			1) Eliminate IHR of K1 Pipe A from 6-7 to zero qty 2)Clamping operation eliminated. 			What To Do : Monthly Fixture PM to be done for block ID How To Do : Block ID 43 mm to be checked at time of PM. Frequency : Monthly					
Root Cause						Cost Incurred For Making Kaizen :					
Spacer locating clamp not as per spacer profile(Part Orientation Not OK)						Material Cost		Labour Cost		Total	
						400.00		100.00		500.00	
Date : 09/09/2013						Scope & Plan For Horizontal Deployment :					
Registered By : Mr. D M Sonawane						Equipmnet		Target		Status	
Manager's Sign : Mr. Arun Gawali						spacer welding		06/10/2014		COMPLETE	
----- Bajaj Auto Ltd. -----											