



# 13th KAIZEN CONFERENCE

## KAIZEN IDEA - SHEET - OPERATOR LEVEL KAIZEN



Mahindra & Mahindra

Plant : 1, Nashik

Machine : Spot Welding Gun (Framing Respot Stations)

Kaizen theme :To eliminate defects of spot damages

Idea : Provide locator

Problem/present status : ( In words )  
The beads on window opening are getting damaged due to spots taken on bead (Average 39 defective bodies per month)

### Pictorial representation

BEFORE



AFTER



#### Analysis :

Bead on window getting damaged  
↓  
Spots are taken on bead instead of flange  
↓  
Gun goes inside  
↓  
No locator

#### Operators feedback after Kaizen Implementation:

Fear of failure eliminated  
Working Speed Increased  
Very proud to use own implemented kaizen  
Boost in operator confidence

#### Team members

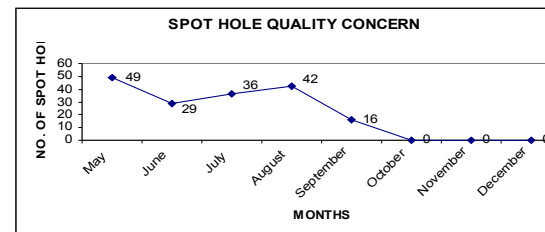
B V Jadhav, A P Hire, B R Khairnar

#### Results :

Rework cost per year =  $39 \times 116 \times 12$   
= 54288 Rs

Scrap cost per year (2 Bodies)  
=  $2 \times 35890$  = 71780 Rs

Total Cost Saving = 126068 Rs



Root cause"  
No Locator