
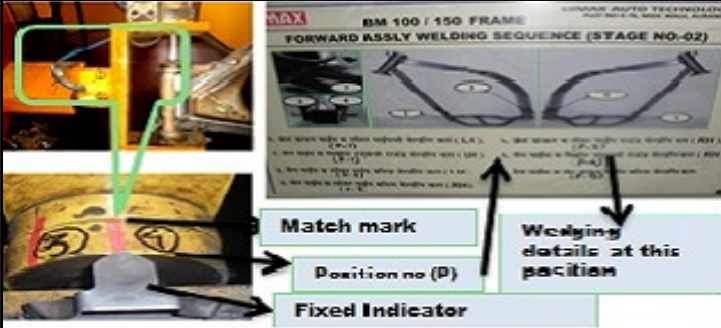
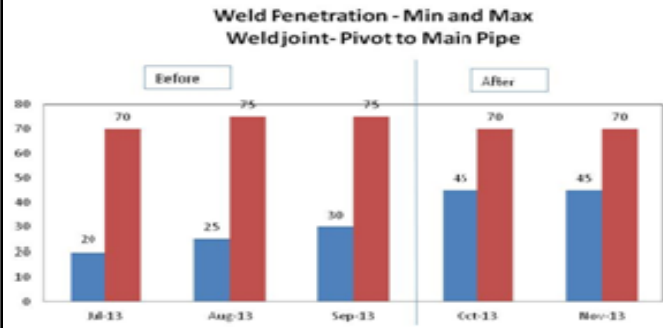
	Equipment :	Manul full welding	Loss Type :	Defect Loss							KAIZEN IDEA SHEET			
	Department	Quality	Result :	N	P	Q	C	D	S	M				
			Type :											
Cell : BM 100 robotic			Operation : Manual full welding - Pivot pipe to main pipe											
Kaizen Theme: To reduce variation in weld penetration at manual welding			Idea : Provision for orientation											
Problem / Present Status			Counter Measure				Benchmark :		20% to 70%					
Variation in weld penetration at Pivot Pipe to main pipe joint (From -20 to 70 %)			Arrangement done with match mark on manual welding stand for orientation , Orientation number linked with SOP				Target :		50-70 %					
							Start :		12/09/2013		Finished :		20/09/2013	
							Note :							
							Team Members :							
			1. Mr.Rahul Kumavat				2. Mr. Amit Gour							
			3. Mr.Raosahab Bansode				4.							
			5.				6.							
			Benefits											
Why Why Analysis :			Result :				Kaizen Sustenance :							
W1 : Why Weld penetration variation at main pipe to pivot pipe joint ? A1 : No fixed orientation during welding W2 : Why No fixed orientation during welding ? A2 : No provision for orientation W3 : Why No provision for orientation ? A3 : W4 : A4 :			Weld penetration at Main pipe to Pivot joint 				What To Do : Check match mark marking and weld sequence while welding How To Do : Visual inspection while welding - Check point added in Supervisor check sheet Frequency : Every 2 hrs							
Root Cause No provision for orientation							Cost Incurred For Making Kaizen :							
Date : 12/09/2013							Material Cost				Labour Cost		Total	
Registered By : Mr. Sachin Lahe							0.00				0.00		0.00	
Manager's Sign : Mr. Hemant Sriwastava							Scope & Plan For Horizontal Deployment :							
							Equipmnet				Target		Status	
							Full welding stand - 6 nos				04/10/2013		COMPLETE	
----- Bajaj Auto Ltd. -----														