BA IA I	Equipment :	Manul full welding			oss Type :	Defect	Loss										
Dativetta Akead	Department	Quality		R	esult :	N	Р	Q	С	D	S	М	KAIZEN IDEA SHEET				
a contraction of the second						ype :											
ell: BM	100 robotic		Operation : M						Ma	Nanual full welding - Pivot pipe to main pipe							
aizen Theme: To re	educe variation in v	veld penetration at manual weld	ling			Idea :	Provi	ision fo	r orier	ntation							
Problem / Present Status			Counter Measure							Benchmark :			20%	20% to 70%			
	Arrangement done with match mark on manual welding stand for orientation , Orientation number linked with SOP							Target : 5			50-70	50-70 %					
								Start : 12/09/2013				Finished : 20/09/2		9/2013			
								AUTO TECH		Note :							
				10	EM 100	WELDING SEQU	-			Team Me	mbors						
						1×	1. Mr.Rahul Kumavat				2. Mr. Amit Gour						
Salar V					26/0			3. Mr.Raosaheb Bansode				4.					
Ser le		 The second second				$ \frac{1}{ A } \frac{1}{ A } = \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } = \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } = \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } = \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } = \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } \frac{1}{ A } = \frac{1}{ A } = \frac{1}{ A } \frac{1}{ A }$						6.					
Sector Cara	a make sign and balls and a set. The set of						5. Benefits										
			50 8	Ma	atch mark		veriging										
No fixed orienta	tion - arrang	ement for manual full			Position n		acition		r ->								
welding fixture				FI	ixed Indic	ator											
/hy Why Analysis :	Result :							Kaizen Sustenance :									
V1 : Why Weld penetration	Weld penetration at Main pipe to Pivot joint							What To Do : Check match mark marking and weld sequence while welding									
1 : No fixed orientation of	luring welding																
/2 : Why No fixed orienta								How To Do : Visual inspection while welding - Check point added in Supervisor check sheet									
2 : No provision for orier	Weld Fenetration - Min and Max																
/3 : Why No provision fo	Weldjoint- Pivot to Main Pipe																
3 :	80 70	After	After 70 70				Frequency : Every 2 hrs										
/4 :	70							Cost Incurred For Making Kaizen				. :					
4 :			50 40			45		∎Min ∎Mas	Ma	aterial C	ost	La	bour Cost		Total		
			30 20 26 20	25							0.00			0.00		0.00	
			30					Scope & Plan For Horizontal Dep				ployment :					
oot Cause	© 3d-13 Aug-13 Sep-13 Cct-13 Nev-13							Equipmnet					Target	Status			
o provision for orientation								Full welding stand - 6 nos				04/10/2013 COMPLET					
			_														
	9/2013		_														
	Sachin Lahe									1							
Registered By: Mr. S Manager's Sign: Mr. H			_														