



Equipment :	Welding Machine	Loss Type :	Defect Loss						
Department	Development	Result :	N	P	Q	C	D	S	M
		Type :							

KAIZEN IDEA SHEET

Cell : KTM Fabrication **Operation :** Muffler to Pipe B full welding

Kaizen Theme: To eliminate rejection in JU KTM muffler assembly - Ovality in pipe B ID (diameter 38.4) **Idea :** Automatic TIG welding.

Problem / Present Status **Counter Measure** **Benchmark :** 100%

When = Contineoue.
 Who = Muffler to pipe B welding operator.
 What = Pipe B ID oval.
 Where = Muffler Fabrication.
 Which = Pipe B welding.
 How - 10

Muffler Pipe B welding process changed manual welding to Robotic welding & TIG welding replaced with MIG welding.

Target : 0

Start : 21/01/2014 **Finished :** 21/01/2014

Note :

Team Members :

1. Mr. S K Kulkarni	2. Mr. D K Thorve
3. Mr. C S N Murty	4. Mr. K R Gadge
5.	6.

Benefits

Q	Rejection due to Pipe B ovality is zero. Nos 0.00
C	One TIG welding stage eliminated. Rs 15000.00
P	Sizing operation eliminated. Nos 1.00

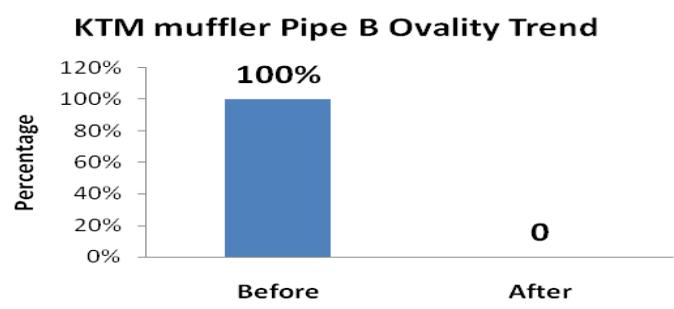


Why Why Analysis :

Y FAY @ AJ ^ OAD C A I E D c a E N
 A1 : Material get distorted in welding.
 W2 : Why Material get distorted in welding. ?
 A2 : High heat input in welding.
 W3 : Why High heat input in welding. ?
 A3 : Manual TIG welding
 W4 : Why Manual TIG welding ?
 A4 :

Result :

1. Rejection due to Pipe B ovality is zero.
2. Sizing operation eliminated.
3. Pipe B welding shabby rejection reduced.
4. One TIG welding stage el



Kaizen Sustenance :

What To Do : Irreversible kaizen.

How To Do : Irreversible kaizen.

Frequency :

Cost Incurred For Making Kaizen :

Material Cost	Labour Cost	Total
0.00	0.00	0.00

Scope & Plan For Horizontal Deployment :

Equipmnet	Target	Status

Root Cause
Manual TIG welding

Date : 18/08/2014

Registered By : Mr. D K Thorve

Manager's Sign : Mr Shivakumar