

	Equipment :	Welding Machine	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department	Development	Result :	N	P	Q	C	D	S	M	
			Type :								
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 :			Result :			Kaizen Sustenance :					
Y A Y @ A J ^ O O 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 :			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			What To Do : Irreversible kiazen.					
						How To Do : Irreversible kiazen.					
						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											
----- Bajaj Auto Ltd. -----											