	Equipment :	Boring Machine		Loss Type :	Defect Loss						**KAIZEN IDEA SHEET**
✖	Department	QA		Result :	N	P	Q	C	D	S	M
				Type :							

Cell :	KTM Powder coating		Operation :	Head pipe ID 52.00 & 48.00 boring.

Kaizen Theme:	To eliminate rejection in KTM frame (KT04) due to boring operation shift. (uneven wall thickness)	Idea :	ROBO welding overlap position away from boring fixture resting area.

Problem / Present Status	**Counter Measure**	**Benchmark :**	9

When = Continuous.
Who = Boring operation operator.
What = boring operation shift. (uneven wall thickness).
Where = KTM frame (KT04) boring.
Which

End point of ROBO welding shifted away from boring fixture resting area.

Target :	0
Start :	18/07/2014	**Finished :**	21/07/2014
Note :	

Gap between head pipe OD & resting pad due to excess weld bead near boring fixture resting area.

No Gap between head pipe OD & resting pad.

ROBO welding overlap position away from boring fixture resting area

Team Members :

1. Mr. S K Parhad	2. Mr. Aashis Sawant
3. Mr. Anna Surve	4. Mr. Vinod Theng
5.	6.

Benefits

P	Inspection operation for frame resting eliminated. Nos 1.00
Q	Rejection due to boring operation shift is zero. Nos 0.00
C	Rework for excess weld bead is zero. Nos 0.00

Why Why Analysis :

W1 : Why Boring operation shift. (uneven wall thickness). ?

A1 : Head pipe position shift in upward direction on boring fixture.

W2 : Why Head pipe position shift in upward direction on boring fixture. ?

A2 : Frame not rest on head pipe OD.

W3 : Why Frame not rest on head pipe OD. ?

A3 : Excess weld bead near resting area of head pipe OD.

W4 : Why Excess weld bead near resting area of head pipe OD. ?

A4 : ROBO welding overlap position near resting area.

Result :

Rejection due to boring operation shift is zero.

Boring operation shift rejection trend

Kaizen Sustenance :

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
Welding machine	21/07/2014	COMPLETE

Root Cause

ROBO welding overlap position near resting area.

Date :	18/08/2014
Registered By :	Mr. D K Thorve
Manager's Sign :	Mr Shivakumar

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