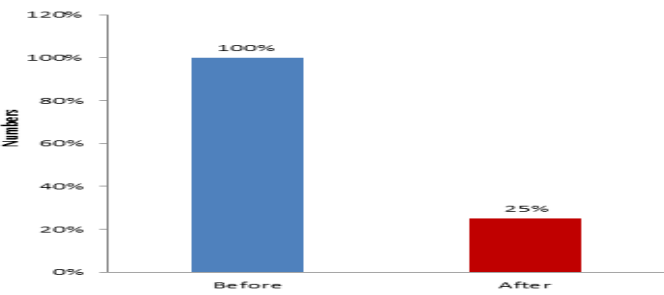
	Equipment :	Welding Robot	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2493					
	Department :	Fabrication	Result :	N	P	Q	C	D	S	M						
	Cell :	Swing Arm Assembly Boxer (DM)	Type :													
Unit Name : 105518 - INNOVENTIVE INDUSTRIES LIMITED, Pune			Operation : Robotic Welding													
Kaizen Theme: To reduce excessive spatter generated.			Idea : To reduce excessive spatters, reduce initial heating of component which is causing adherence of spatters.													
Problem / Present Status			Counter Measure			Benchmark :		100%								
Excessive spatters observed on swing arm assembly boxer.			Welding sequence changed so that even heat distribution is maintained.			Target :		0%								
						Start :	19/03/2015	Finished :	20/03/2015							
						Note :										
						Team Members :										
						1. Mr. Yuvraj Survase		2. Mr. Pramod Jadhav								
						3.		4.								
						5.		6.								
						Benefits										
						Q	Improved aesthetics and quality Rs 0.00									
Why Why Analysis :			Result :			Kaizen Sustenance :										
W1 : Why Excess spatters observed on resting side of axle bkt. ? A1 : Spatters getting trapped due to fixture geometry W2 : Why Spatters getting trapped due to fixture geometry ? A2 : No provision to escape the spatters and get stuck firmly on hot surface W3 : Why No provision to escape the spatters and get stuck firmly on hot surface ? A3 : Component getting hot due to upper side first weld run. Causing spatter adherence at the time of second weld run. W4 : Why Component getting hot due to upper side first weld run. Causing spatter adherence at the time of second weld run. ? A4 :			Less spatters observed with loose adherence. 			What To Do : Refer Master weld template. How To Do : Check the welding sequence and parameters with respect to Master Weld template. Frequency : Monthly										
Root Cause Component getting hot due to upper side first weld run. Causing spatter adherence at the time of second weld run.						Cost Incurred For Making Kaizen : <table border="1"> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> <tr> <td>0.00</td> <td>0.00</td> <td>0.00</td> </tr> </table>					Material Cost	Labour Cost	Total	0.00	0.00	0.00
Material Cost	Labour Cost	Total														
0.00	0.00	0.00														
Date : 27/03/2015 Registered By : Mr. Salim Shaikh Manager's Sign : Mr. Mhangore						Scope & Plan For Horizontal Deployment : <table border="1"> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> <tr> <td>Panasonic Welding Robot</td> <td>30/03/2015</td> <td>COMPLETE</td> </tr> </table>					Equipmnet	Target	Status	Panasonic Welding Robot	30/03/2015	COMPLETE
Equipmnet	Target	Status														
Panasonic Welding Robot	30/03/2015	COMPLETE														
----- Bajaj Auto Ltd. (Fabrication) -----																