×	Equipment :	Frame tack I st. F-60	Loss Type :	Defect	Loss										
-		QA			N	Р	Τ,	Q C	D	S	М	KAIZEN IDEA SHEET			
	Department	QA		Result :	IN	-	+	Q C		3	IVI	KAIZEN	I IDEA SI	1EE I	
Cell: CT100	frame line.			Type :	lone	ration :		Frame tack	Lot E	60					
Kaizen Theme: To pre	vent customer com	plaint of spatter's on Eng.bkt t	op in CT100 frame.	Idea :	Тор	provide a	auto	masking in	fixture.						
Problem / Present Status			Counter Measure					Benchm	Benchmark: 12			2			
During full welding operation of F-60 spatter's falling on Eng. bkt top side. This area considered "A" class for Aesthetics, that's why CC happened.			Auto masking provided with link the side cover bkt mounting cylinder.					Target :	Target: 0			0			
									Start : 12/02/2015			Finished: 10/02/2015		/2015	
			×						Note : Auto masking pro- kaizen (Kara kuri)			rovided on frame tack fixture - Zero cost for ri)			
								Team M	embers	:					
								1. Mr.Salunke P.A				2. Mr. Mujawar A.I			
								3. Mr.Tayde S.N				4. Mr. Nikhade M.L			
								5. Mr. Pankaj kulkarni				6. Mr. Lade D.S			
								Benefits	Benefits						
									Q IHR reduced from 25 frame/shift to "Zero". Rs 170000.00						
Why Why Analysis :			Result:					Kaizen Sustenance :							
								Kaizen S	Sustena	ınce :					
W1 : Why Spatter falling on			Zero customer complaint of spatter falling	g on eng.bkt top	from la	ast 06				ince : I/PM , Kaize	en check s	heet.			
W1 : Why Spatter falling on A1 : During welding of rear j	oint & side cover fu	ll spatter falling on eng.bkt		g on eng.bkt top	o from la	ast 06					en check s	heet.			
W1 : Why Spatter falling on	oint & side cover fu	ll spatter falling on eng.bkt	Zero customer complaint of spatter falling	g on eng.bkt top) from la	ast 06		What To	Do : Jŀ	H/PM , Kaiz€		heet. en Audit Engin	еег.		
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt?	oint & side cover furear joint & side co	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To	Do : Jł	H/PM , Kaize			eer.		
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s	oint & side cover furear joint & side conspatter falling.	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To	Do : Jł	H/PM , Kaiz€			эег.		
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s W3: Why No provision for a	oint & side cover furear joint & side conspatter falling. Inviod spatter falling. In fixture	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To	Do : Jl Do : By	H/PM , Kaize	cated Kaiz		eer.		
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s W3: Why No provision for a A3: No masking provision in	oint & side cover furear joint & side conspatter falling. Inviod spatter falling. In fixture	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To How To Frequen Cost Inc	Do : Jl Do : By	ME & Dedic	cated Kaiz			otal	
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s W3: Why No provision for a A3: No masking provision ir W4: Why No masking provi	oint & side cover furear joint & side conspatter falling. Inviod spatter falling. In fixture	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To How To Frequen Cost Inc	Do : JH Do : By cy : Dai	ME & Dedic	cated Kaiz Kaizen : Labo	en Audit Engin	Т	otal	
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s W3: Why No provision for a A3: No masking provision ir W4: Why No masking provi	oint & side cover furear joint & side conspatter falling. Inviod spatter falling. In fixture	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To How To Frequen Cost Inc	Do : Jh Do : By cy : Dai curred F aterial C	ME & Dedic	cated Kaiz Kaizen : Labo	en Audit Engin our Cost	Т		
W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s W3: Why No provision for a A3: No masking provision ir W4: Why No masking provi A4:	oint & side cover furear joint & side conspatter falling. Inviod spatter falling. In fixture	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To How To Frequen Cost Inc	Do : Jh Do : By cy : Dai curred F aterial C	ME & Dedic	Kaizen : Labo tal Deploy	en Audit Engin our Cost	Т		
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W1: Why Spatter falling on A1: During welding of rear j W2: Why During welding of eng.bkt? A2: No provision for aviod s W3: Why No provision for a A3: No masking provision in W4: Why No masking provi A4: Root Cause No masking provision in fixt Date: 10/07/2	oint & side cover furear joint & side conspatter falling. Inviod spatter falling. In fixture In fixture ?	Il spatter falling on eng.bkt	Zero customer complaint of spatter fallin months	g on eng.bkt top	o from la	ast 06		What To How To Frequen Cost Inc	Do: JH Do: By cy: Dai curred f aterial C 0.00 Plan f	ME & Dediction MF & Dediction MF or Making Cost For Horizon	Kaizen : Labo tal Deploy	en Audit Engin our Cost 000.00 yment :	T 100	00.00 Status	
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