

<div><div></div></div>	Equipment :	FF-30	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department :	Maintenance	Result :	N	P	Q	C	D	S	M	
	Cell :	Full Frame	Type :								
Unit Name : 113332 - Badve Engineering Ltd (CV Division), Aurangabad			Operation : Welding								
Kaizen Theme: TO eliminate blow hole defect MIG welding			Idea : Remove complete spatters from robot nozzle								
Problem / Present Status		Counter Measure			Benchmark :		Nozzel cleaning was not proper				
Blow hole defect during co2 welding due to improper nozzle cleaning by plane surface reamer		Nozzle cleaning reamer with Knurling on outer face which clean nozzle properly			Target :		Cleaning of nozzel should be proper				
					Start :		11/06/2015		Finished :		30/06/2015
<div><div></div></div>		<div><div></div></div>			Note :						
					Team Members :						
					1. Mr. Y.S. Rakhade				2. Mr. M.G. Ambhore		
					3. M. I.H. Sayyad				4. Mr. S.D. Mhaske		
					5.				6.		
					Benefits						
					P		Production increased due to elimination of minor stopages like wire stick errors. Rs 0.00				
					C		Eliminate I.H.R. due to blow holes Rs 0.00				
Why Why Analysis :		Result :			Kaizen Sustenance :						
W1 : Why 30/06/2015 ?		I.H.R. Reduced			What To Do : JH and PM						
A1 : Replaced reamer with Knurling on outer face											
W2 : Why Replaced reamer with Knurling on outer face ?											
A2 : blow hole defect during co2 welding		<div><div></div></div>			How To Do : By using check sheets						
W3 : Why blow hole defect during co2 welding ?					Frequency : Daily & Weekly respectively						
A3 : During nozzle cleaning operation nozzle not cleaning properly					Cost Incurred For Making Kaizen :						
W4 : Why During nozzle cleaning operation nozzle not cleaning properly ?					Material Cost		Labour Cost		Total		
A4 : Plane surface on outer of nozzle cleaning reamer					200.00		200.00		400.00		
Root Cause					Scope & Plan For Horizontal Deployment :						
Plane surface on outer of nozzle cleaning reamer					Equipmnet				Target		Status
Date : 11/06/2015											
Registered By : Mr. P P Videkar											
Manager's Sign : Mr. D T RANE											
----- Bajaj Auto Ltd. (Fabrication) -----											