KAIZEN IDEA SHEET

Equipment :	FF-30	**Loss Type :**	Defect Loss								**Kaizen ID : 2662**
Department :	Maintenance	**Result :**	N	P	Q	C	D	S	M		
Cell :	Full Frame	**Type :**									

Unit Name : 113332 - Badve Engieering Ltd (CV Division), Aurangabad

Operation : Welding

Kaizen Theme: To eliminate IHR due to welding shift,Burn,Shabby weld of Y member

Idea : To avoid variation in location of Half frame

Problem / Present Status

Welding shift,Burn,Shabby weld due to Half frame shift during full frame assembly

Counter Measure

Modified the block of half frame tooling pin and also provided the UTS packing

Benchmark :	5 Occurance/Month		
Target :	0		
Start :	15/05/2015	**Finished :**	29/05/2015
Note :			

Team Members :

1. Mr. Y.S. Rakhade	2. Mr. M.G. Ambhore
3. Mr. A.B. Bangar	4. Mr. S.D. Mhaske
5.	6.

Benefits

P	Production increased due to elimination of minor stoppages due to locating pin disturb. Rs 0.00
Q	Eliminated I.H.R. due to weld shift,weld burn,shabby weld Rs 0.00
C	Rework cost saved Rs 0.00

Why Why Analysis :

W1 : Why 29/05/2015 ?

A1 : Modified the block of half frame tooling pin and also provided the UTS packing

W2 : Why Modified the block of half frame tooling pin and also provided the UTS packing ?

A2 : welding shift,Burn,Shabby weld at 'Y' member welding run

W3 : Why welding shift,Burn,Shabby weld at 'Y' member welding run ?

A3 : Half frame shift during full frame assembly

W4 : Why Half frame shift during full frame assembly ?

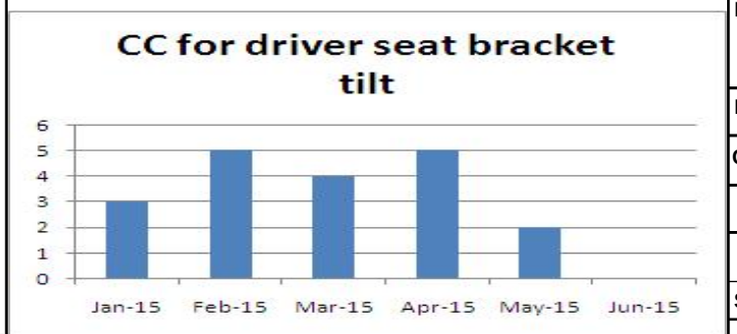
A4 : Weak design of HF locating pin block

Root Cause

Pin locating block support not sufficient to locate pin

Result :

Eliminate IHR due to weld shift,weld burn,shabby weld at 'y' member



Kaizen Sustenance :

What To Do : Checking & Cleaning

How To Do : Through JH & PM

Frequency : Daily & Weekly respectively

Cost Incurred For Making Kaizen :

Material Cost	Labour Cost	Total
8000.00	500.00	8500.00

Scope & Plan For Horizontal Deployment :

Equipmnet	Target	Status

Date :	**15/05/2015**
Registered By :	Mr. P P Videkar
Manager's Sign :	Mr. D T RANE