

	Equipment :	Projection welding m/c	Loss Type :	Defect loss							KAIZEN IDEA SHEET
	Department :	Press & Fab	Result :	N	P	Q	C	D	S	M	
	Cell :	All projection welding cell	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Projection welding								
Kaizen Theme: To eliminate weak bolt projection welding defect phenomena.			Idea : To provide insulation bush inside bottom electrode to avoid current shunting.								
Problem / Present Status		Counter Measure				Benchmark :					
Projection welded bolt broken on BAL assembly line.		To provide insulation bush inside bottom electrode to avoid current shunting.				Target :		0			
						Start :		04/09/2017		Finished : 10/09/2017	
						Note :					
						Team Members :					
						1. Mr Sachin Fargade				2. Mr Omkar Patinge	
						3.				4.	
						5.				6.	
						Benefits					
Why Why Analysis :		Result :				Kaizen Sustenance :					
W1 : Why Projection Welded nut broken ? A1 : Weak projection welding W2 : Why Weak projection welding ? A2 : Current shunting through bolt threaded length to bottom electrode. W3 : Why Current shunting through bolt threaded length to bottom electrode. ? A3 : No insulation inside bottom electrode W4 : Why No insulation inside bottom electrode ? A4 :		Projection weak due to current shunting zero.				What To Do : Checking of wear condition of insulating bush.					
						How To Do : By visual					
						Frequency : Daily					
						Cost Incurred For Making Kaizen :					
						Material Cost		Labour Cost		Total	
						0.00		0.00		0.00	
						Scope & Plan For Horizontal Deployment :					
						Equipmnet		Target		Status	
Root Cause No insulation inside bottom electrode											
Date : 15/09/2017											
Registered By : Mr Sachin Fargade											
Manager's Sign :											
----- BAL Prass and Fab Team -----											