

	Equipment :	F 135 robot welding stage.	Loss Type :	DIE / JIG / TOOL Loss							KAIZEN IDEA SHEET
	Department :	Component Development	Result :	N	P	Q	C	D	S	M	
	Cell :	CD-QA	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : F 135 Robot weldCenter pipe LH/RH to Rear pipe LH/RH welding								
Kaizen Theme: To increase Robotic welding percentage in pulsar Frame (K1) assembly			Idea : Change the head pipe angular position to 90 degree to creat welding approach								
Problem / Present Status		Counter Measure		Benchmark :		85%					
Centre pipe LH/Rh welding to Rear pipe LH/RH welding at bottom side done manually				Target :		100%					
				Start :		19/09/2017		Finished :		22/05/2017	
			Note :								
			Team Members :								
			1. A.S.Satpute				2.				
			3. S V Gaikwad				4.				
			5. A B Pujari				6.				
			Benefits								
Q		No manual welding, No shabby welding Rs 0.00									
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why center pipe LH/RH to Rear pipe LH/RH Bottom side welding done manually A1 : W2 : No Robot approach A2 : W3 : Head pipe angular position on fixture is kept 28 degree A3 : W4 : As per design A4 :		100% welding done by robot		What To Do :							
				How To Do :							
				Frequency :							
				Cost Incurred For Making Kaizen :							
				Material Cost		Labour Cost		Total			
0.00		0.00		0.00							
Scope & Plan For Horizontal Deployment :											
Equipment		Target		Status							
Root Cause											
Date : 19/09/2017											
Registered By : Mr Ashok Pujari											
Manager's Sign :											
----- BAL Prass and Fab Team -----											