×	Equipment :	Welding Fixture	Loss Type : Failure Lo									KAIZE	KAIZEN IDEA SHEET		
	Department :	Press & Fab		Result :	N	Γ	P Q	С	D	S	N	1			
	Cell :	Rider step CT125		Type :								ĸ	aizen ID : 3155		
Unit Name : Pres	Operation : Robotic welding														
Kaizen Theme: To prevent failure due to less weld penetration in CT125 Rider step LH weld joints. Idea : Clamp design change.															
Problem / Present Status			Counter Measure				Bench	Benchmark : 1							
Penetration found less in pipe to plate joints due to wrong torch position in robotic welding. Nozzle foul to clamp less approach			Torch angle get corrected by changing clamp design			Target : 0				0					
								Start : 20/09/2017				Finished :	23/09/2017		
							Note :								
Less approach to welding due to famo faul to nozzle							Team M	Team Members :							
19							1. Mr Dhananjay Shitole					2. Mr Omka	2. Mr Omkar Patinge		
A RES							3.					4.	4.		
							5.					6.	6.		
						Benefits									
			Ctype clamp												
Why Why Analysis :			Result :					Kaizen Sustenance :							
W1 : Why Less weld penetration in CT125 Rider step LH weld joints. ? A1 : Torch angle not proper			Weld penetration achieve more than 50 %					What To Do :							
W2 : Why Torch angle not proper ?								How To Do :							
A2 : Less approach to take proper angle			60%												
W3 : Why Less approach to take proper angle ?			50% 40%												
A3 : Torch body foul to clamp								Frequency :							
W4 : Why Torch body foul to clamp ?			30%				Cost In	Cost Incurred For Making Kaizen :							
A4 : Y type clamp design.			20% 10% 0%			Ν	Material Cost Labo			La	abour Cost	ur Cost Total			
								0.00				0.00	0.00		
			Before After			Scope	Scope & Plan For Horizontal Deployment :								
Root Cause			5 s				Equipmnet						Target Status		
Y type clamp design.															
Date : 23/09)/2017														
Registered By : Mr D	hananjay Shitole														
Manager's Sign :															
BAL Prass and	Fab Team		BAL Prass and Fab Team												