

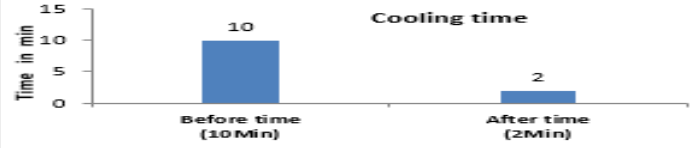
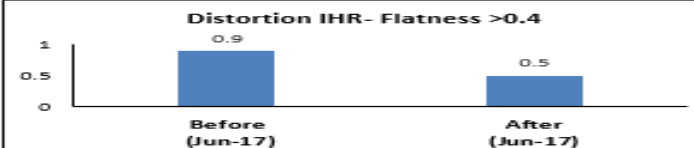
	Equipment :	Welding machine	Loss Type :		Failure Loss							KAIZEN IDEA SHEET Kaizen ID : 3159		
	Department :	Press and Fab - Quality	Result :		N	P	Q	C	D	S	M			
	Cell :	Welding cell at starways chakan	Type :											
Unit Name :			Press and Fab - Quality, Pune		Operation :								Welding	
Kaizen Theme:			To avoid distortion during inter-cell material handling cooling system		Idea :								To provide forced cooling system	
Problem / Present Status			Counter Measure				Benchmark :							
1. Distortion during intercell material handling . 2. LCGS not getting fast cool after welding			Additional Cooling provided by providing arrangement of Fan on trolley after welding operation				Target :							
							Start :		15/05/2017		Finished :		28/09/2017	
							Note :							
							Team Members :							
							1. Mr. Bala (M/s Starw				2. Mr. Naveen (M/s Star			
							3. Mr. Sanap (M/s Starw				4.			
							5.				6.			
							Benefits							
 Before:- Natural cooling			 After:- Cooling through Force fan											
Why Why Analysis :			Result :				Kaizen Sustenance :							
W1 : Why Possibility of distortion during inter-cell material handling ? A1 : After welding hot LCGS directly kept on trolley and take for next operation (Time - less than 6 min) W2 : Why After welding hot LCGS directly kept on trolley and take for next operation (Time - less than 6 min) ? A2 : No complete cooling of parts before taking for next operation W3 : Why No complete cooling of parts before taking for next operation ? A3 : Natural cooling tooks more time (more than 10 min) to cool job W4 : Why Natural cooling tooks more time (more than 10 min) to cool job ? A4 : No provision of forced cooling			1.LCGS weld lever colling time reduced from 10 mins to 3 mins 2. Possibility of distortion is reduced 3. Operator fatigue reduced .  				What To Do : Fan on condition How To Do : Fan working point added in JH Frequency : Daily basis							
Root Cause							Cost Incurred For Making Kaizen :							
No provision of forced cooling							Material Cost		Labour Cost		Total			
							12000.00		1500.00		13500.00			
Date :			28/09/2017				Scope & Plan For Horizontal Deployment :							
Registered By :			Ms Priti Sakhare				Equipmnet		Target		Status			
Manager's Sign :														
----- BAL Prass and Fab Team -----														