KAIZEN IDEA SHEET

Equipment :	Welding machine	**Loss Type :**	Setup & adjustment Loss							**Kaizen ID : 3161**
Department :	Press & Fab	**Result :**	N	P	Q	C	D	S	M	
Cell :	Welding cell at starways waluj	**Type :**								

Unit Name : Press and Fab - Quality, Pune

Operation : Welding operation

Kaizen Theme: To eliminate defect of stack height variation (oversize / undersize) in welding m/c

Idea : To control stack height during welding operation

Problem / Present Status

Gear shifting hard defect in PV -
1. Stack height 25 -0.25 mm oversize by 0.5~1 mm
2. Stack height 25 -0.25 mm undersize by 0.5~1 mm

Before:- Stack height oversize and undersize

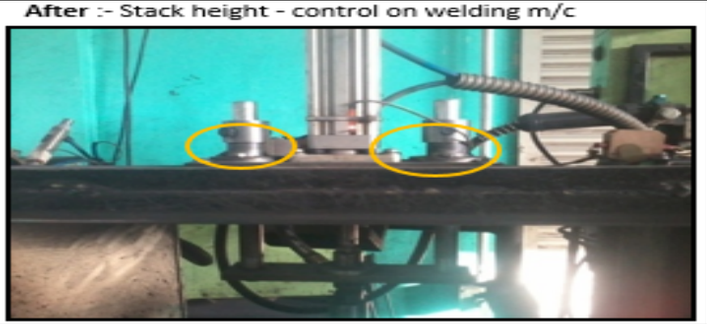
HIGHT O/S

HIGHT U/S

Counter Measure

To provide control on stack height by stopper .-Stopper bush provided instead of the reed switch controller to control Height Variation in welding .

After :- Stack height - control on welding m/c



Benchmark :	Zero defect generation		
Target :	Zero Defect of stack height variation		
Start :	12/06/2017	**Finished :**	29/09/2017
Note :			

Team Members :

1. Miss. Priti Sakhare	2. Mr. Gaurikar (M/s S
3.	4.
5.	6.

Benefits

Why Why Analysis :

W1 : Why Stack height oversize / undersized ?

A1 : During welding operation - shaft slightly rest on weld spatter / Shaft rest down in serration block

W2 : Why During welding operation - shaft slightly rest on weld spatter / Shaft rest down in serration block ?

A2 : During Welding - welding spot stuck in serration ring gauge / Shaft rest down in serration block

W3 : Why During Welding - welding spot stuck in serration ring gauge / Shaft rest down in serration block ?

A3 : No control of height during welding operation

W4 : Why No control of height during welding operation ?

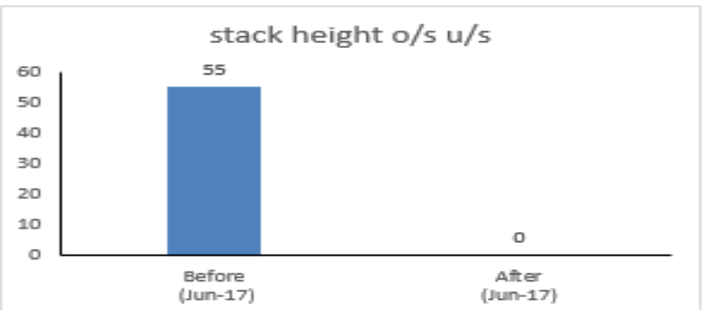
A4 :

Root Cause

No control of height during welding operation

Result :

Stack height variation (undersize / oversize) phenomena rejection reduced to Zero



Kaizen Sustenance :

What To Do : To confirm stack height 25 -0.2 mm

How To Do : 1. Process pokayoke monitoring
2. 100 % inspection by gauge

Frequency : Daily Basis

Cost Incurred For Making Kaizen :

Material Cost	Labour Cost	Total
0.00	0.00	0.00

Scope & Plan For Horizontal Deployment :

Equipmnet	Target	Status

Date : 29/09/2017

Registered By : Ms Priti Sakhare

Manager's Sign :

---------- BAL Prass and Fab Team ----------