Department   Press & Fab   Cell   Result   Res	×	Equipment :	Welding machine				Los	ss Type :	Setup	& a	djustment	Loss				KAIZEN IDEA SHEET			
Unit Name : Pross and Fab - Quality, Pure    Countrel stands delect of stack height variation (oversize) in welding m/c   Countrel stands delect of stack height variation (oversize) in welding m/c   Countrel stands delect of stack height variation (oversize) in welding operation							Res	Result:		F	Q	С	D		М				
Unit Name : Press and Fab - Quality, Purie    Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality, Purie   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab - Quality   Purie And School (America)     Press and Fab	Cell: Welding cell at starways v				aluj			e :								١,	61		
Kalzen Theme: To eliminate defect of stack height variation (oversize / undersize) in welding mic    Counter Measure   Status   Counter Measure   Season   S	, , ,				1.36.5.					V								<u>-</u>	
Problem / Present Status  Country Measure To provide control on stack height yet stopper - Stopper bush provided Sear shifting hard ordered in PV- 1. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 2. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 2. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 2. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 2. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 3. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 4. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 5. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 5. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 5. Stack height 26 - 0.25 mm undersize by 0.5-1 mm 5. Stack height 26 - 0.25 mm 5. Stack height 26 - 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 26 - 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 27 - 0.25 mm undersize by 0.25 mm 5. Stack height 27 -		·		ındorciz	(a) in wolding m/c		ldoa :	To co	otrol etc					ration	`				
To provide control on stack height by stopper - Stopper bush provided   Target   Zero Defect of stack height variation   Start : 12:06/2017   Finished : 20:002-017		minate defect of stack i					iuea .	10 00	ILIOI SL	ICK	_		ung ope	HallOI					
1. Sinck height 25 - 0.25 mm oversize by 0.5-1 mm  Before: Stack height variation in welding operation  Why Why Analysis:  Why	Problem / Present Status			Counter Measure						Benchmark : Zero				Zero de	ro defect generation				
2. Stack height 25 - 0.25 mm undersize by 0.5-1 mm  Before: - Stack height oversize and undersize  ##IGHT O'S  ##IGHT U'S  ##IGHT US  ##IGHT US	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			To provide control on stack height by stopperStopper bush provided instead of the reed switch controller to control Height Variation in welding .					Target : Zero D				Zero De	Defect of stack height variation					
##GHT OS  ##GHT OS  ##HGHT US  ##									g .	<b>Start</b> : 12/06/2017				Finished: 29/09/2017					
Team Members:  1. Miss. Pritt Sakhare 2. Mr. Gaurikar (Ms S 3 3 4.5 5 6.5 6.5 6.5 6.5 6.5 6.5 6.5 6.5 6.5	Before:- Stack height	t oversize and und	lersize	Aft	ter :- Stack heig	ht - control on	welding	g m/c			Note :					•			
Miny Why Analysis:  Withy Why Analysis:  Withy Why Analysis:  Withy Stack height oversize / undersized?  Af: During welding operation - short slightly rest on weld spatter / Shaft rest down in serration block  Withy During welding operation - short slightly rest on weld spatter / Shaft rest down in serration block  Withy Why During Welding operation or short slightly rest on weld spatter / Shaft rest down in serration block  Withy During Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block  Withy During Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block  Withy During Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block  Withy During Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block  Withy During Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block?  Als : No control of height during welding operation ?  At : Union Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block?  At : No control of height during welding operation ?  At : Union Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block ?  At : No control of height during welding operation ?  At : Union Welding operation - short slightly rest on weld spatter / Shaft rest down in serration block ?  At : On							E. 9		-	-	Team M	ember	s :						
Why Why Analysis: William Stack height oversize / undersized? At : During welding operation - shaft slightly rest on weld spatter / Shaft rest down in serration block? At 2: During welding - welding spot stuck in serration flock? At 2: During welding - welding spot stuck in serration flock? At 3: Who During welding operation - shaft slightly rest on weld spatter / Shaft rest down in serration block? At 3: Who During welding - welding spot stuck in serration flock? At 3: Who Control of height during welding operation W4 : Why No control of height during welding operation W4 : Why No control of height during welding operation  At :  Root Cause No control of height during welding operation Date: 29/09/2017 Registered By: Ms Priti Sakhare Manager's Sign:	<b>/</b> \		5		1		20000	12222			1. Miss.	Priti Sa	khare			2. Mr. Gau	rikar ( M/s S		
Why Why Analysis: Will: Why Stack height oversize / undersized? At : During welding operation - shaft slightly rest on weld spatter / Shaft rest down in serration block? At 2: During Welding - welding spot stuck in serration flock? At 2: During Welding - welding spot stuck in serration flock? At 3: No control of height during welding operation Will * Why No control of height during welding operation Will * Why No control of height during welding operation  At :  Root Cause No control of height during welding operation Date: 29/09/2017 Registered By: Mis Priti Sakhare Manager's Sign:	3					1		1			3.						,		
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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  Date: 29/09/2017 Registered By: Ms Pritt Sakhare  Manager's Sign:  2. 100 % inspection by gauge  Frequency: Daily Basis  Cost Incurred For Making Kaizen:  Material Cost			on weld spatter / Shaft	to Zero	1														
A2 : During Welding - welding spot stuck in serration ring gauge / Shaft rest down in serration block?  A3 : No control of height during welding operation?  A4 : Why No control of height during welding operation?  A4 : Root Cause No control of height during welding operation  Date : 29/09/2017  Registered By: Ms Priti Sakhare  Manager's Sign :  Stack height of your stack in serration ring gauge / Shaft rest down in serration block?  Frequency : Daily Basis  Cost Incurred For Making Kaizen :  Material Cost	W2 : Why During welding operation - shaft slightly rest on weld spatter / 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 ? A4 :  Before (Jun-17)  Before (Jun-17)  Begistered By: Ms Priti Sakhare  Manager's Sign:  Frequency: Daily Basis  Cost Incurred For Making Kaizen:  Cost Incurred For Making Kaizen:  Material Cost																			
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  Date : 29/09/2017 Registered By : Ms Priti Sakhare  Manager's Sign :  Cost Incurred For Making Kaizen :  Material Cost	W3 : Why During Welding - welding spot stuck in serration ring gauge /										Frequency : Daily Basis								
W4 : Why No control of height during welding operation ? A4 :  Root Cause No control of height during welding operation  Date : 29/09/2017  Registered By: Ms Priti Sakhare  Manager's Sign :  Material Cost Labour Cost Total  0.00 0.00 0.00 0.00  Scope & Plan For Horizontal Deployment :  Equipmet Target Status											Cost Incurred For Making Kaizen								
A4:  Before (Jun-17)  Root Cause No control of height during welding operation  Date: 29/09/2017 Registered By: Ms Priti Sakhare Manager's Sign:				30												<del></del>			
Root Cause No control of height during welding operation  Date: 29/09/2017 Registered By: Ms Priti Sakhare Manager's Sign:  0.00 0.00 0.00  Scope & Plan For Horizontal Deployment:  Target Status    Coulon   Cou	W4: Why No control of heig	ght during welding ope	ration ?								M	aterial (	Cost		Labo	our Cost	Т	otal	
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