

	Equipment :	Gantry Fixtures	Loss Type :	Defect loss							KAIZEN IDEA SHEET
	Department :	Materials -QA	Result :	N	P	Q	C	D	S	M	
	Cell :	Robotic	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Spot welding								
Kaizen Theme: To eliminate inhouse rejection in windshield spot weld process			Idea : Pokayoke provided for positive clamping								
Problem / Present Status		Counter Measure		Benchmark :		50 No's/Month					
Spot Shift/Spot on edge - Reinforcement LH/RH & Outer Draw				Target :		Zero					
Start :				02/10/2017		Finished :		20/07/2017			
Note :											
Team Members :											
1. Mr. Nitin Shinde				2. Mr.AA Gutte							
3. Mr. SB Limbale		4.									
5.		6.									
Benefits											
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Spot on edge/spot shift ? A1 : W2 : Mating part position shift A2 : W3 : Clamping not done on part A3 : W4 : Missed by operator due to manual clamping A4 :		IHR reduced to Zero and rework cost saving up to 32000/month 		What To Do : JH and Pokayoke audit							
Root Cause				How To Do : Visual inspection & daily JH activity							
Frequency : Start of shift											
Cost Incurred For Making Kaizen :											
Material Cost				Labour Cost		Total					
0.00				0.00		0.00					
Scope & Plan For Horizontal Deployment :											
Equipment		Target		Status							
Date : 02/10/2017											
Registered By : Mr Nitin Shinde											
Manager's Sign :											
----- BAL Prass and Fab Team -----											