

	Equipment :	Projection welding machine.	Loss Type :	Defect loss							KAIZEN IDEA SHEET																
	Department :	Press & Fab	Result :	N	P	Q	C	D	S	M																	
	Cell :	Projection welding cell at M/S- Shree Ganesh	Type :									Kaizen ID : 3227															
Unit Name : Press and Fab - Quality, Pune			Operation : Nut Projection welding																								
Kaizen Theme: To eliminate nut broken complaint in hand start bkt of compact model			Idea : Provide 110mm length height top electrode & Provide insulation for top electrode holder																								
Problem / Present Status		Counter Measure			Benchmark :		No Shunting																				
Frequent nut broken complaint in hand start bkt of Compact model		Use of 110mm height top electrode & provide insulation to top electrode holder			Target :		No Shunting																				
					Start :		07/12/2017		Finished :		07/12/2017																
					Note :																						
					Team Members :																						
					1. Mr Sachin Fargade				2. Mr Omkar Patinge																		
					3. Mr Ravindra Muluk				4.																		
					5.				6.																		
					Benefits																						
Why Why Analysis :		Result :			Kaizen Sustenance :																						
W1 : Why Hand start bkt nut broken ? A1 : Current shunting W2 : Why Current shunting ? A2 : Top electrode holder touch to bkt profile W3 : Why Top electrode holder touch to bkt profile ? A3 : Using incorrect height of top electrode W4 : Why Using incorrect height of top electrode ? A4 :		Shunting possibility eliminated resulted into no weak projection welding. Nut Broken complaint <table><tr><td>Before</td><td>79</td></tr><tr><td>After</td><td>0</td></tr></table>			Before	79	After	0	What To Do : How To Do : Frequency : Cost Incurred For Making Kaizen : <table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>0.00</td><td>0.00</td><td>0.00</td></tr></table> Scope & Plan For Horizontal Deployment : <table><tr><td>Equipmnet</td><td>Target</td><td>Status</td></tr><tr><td colspan="3"></td></tr></table>							Material Cost	Labour Cost	Total	0.00	0.00	0.00	Equipmnet	Target	Status			
Before	79																										
After	0																										
Material Cost	Labour Cost	Total																									
0.00	0.00	0.00																									
Equipmnet	Target	Status																									
Root Cause Using incorrect height of top electrode																											
Date : 07/12/2017																											
Registered By : Mr Sachin Fargade																											
Manager's Sign :																											
----- BAL Prass and Fab Team -----																											