

	Equipment :	Projection welding machine.	Loss Type :	Material loss							KAIZEN IDEA SHEET
	Department :	Press & Fab	Result :	N	P	Q	C	D	S	M	
	Cell :	Projection welding cell at M/S- Rahul Engineering	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Projection welding								
Kaizen Theme: To eliminate Co2 tack welding operation to M8 Nut of Hugger mtg bkt (JL122013) of K4 Swing Arm.			Idea : Standardised source for M8 Hex weld nut								
Problem / Present Status		Counter Measure			Benchmark :		Projection welding				
Two Co2 tacks to M8 Projection welded nut of Hugger mtg bkt.		Nut source standardized as M/s. LEO Fastners for M8 HEX Projection weld nut and Co2 tacks deleted.			Target :		Projection welding				
					Start :		01/11/2017		Finished :		20/11/2017
					Note :						
					Team Members :						
					1. Mr Sachin Fargade				2. Mr Omkar Patinge		
					3. Mr Nidhin M. k. (Lum				4.		
					5.				6.		
					Benefits						
Why Why Analysis :		Result :			Kaizen Sustenance :						
W1 : Why Need of Two Co2 tacks to M8 Projection welded nut of Hugger mtg bkt. ? A1 : Chances of weak projection welding. W2 : Why Chances of weak projection welding. ? A2 : Inconsistent torque W3 : Why Inconsistent torque ? A3 : Variation in dimple size W4 : Why Variation in dimple size ? A4 : Non standard nut supplier		1. By elimination of Tack cost saved - Rs.96,000/- 2. Manpower cost saved - Rs. 1,44,000/-  Total - Rs. 2,40,000/- saved per year.			What To Do : Process Audit						
					How To Do : BAL & Vendor Process Audit						
					Frequency : Monthly						
					Cost Incurred For Making Kaizen :						
					Material Cost		Labour Cost		Total		
					96000.00		144000.00		240000.00		
					Scope & Plan For Horizontal Deployment :						
					Equipmnet				Target		Status
Root Cause Standardisation not done											
Date : 08/12/2017											
Registered By : Mr Sachin Fargade											
Manager's Sign :											
----- BAL Prass and Fab Team -----											