

<div></div>	Equipment :	Welding machine	Loss Type :	Defect loss							KAIZEN IDEA SHEET
	Department :	QA - P&F Materials	Result :	N	P	Q	C	D	S	M	
	Cell :	Assembly cell at starways waluj	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Welding								
Kaizen Theme: To Eliminate defect of perpendicularity more than 0.3 mm			Idea : During welding - Job clamping should be nore than 80 %								
Problem / Present Status		Counter Measure		Benchmark :		0 Rejection					
Gear Shifting hard defect (PV) - Lever perpendicularity more than 0.3 mm		To provide job clamping during welding operation to avoid welding distortion.		Target :		0 Rejection					
				Start :		18/12/2017		Finished :		18/12/2017	
<div></div>		<div></div>		Note :							
				Team Members :							
				1. Priti Sakhare				2. Mr. Gaurikar (M/s S			
				3. Mr. Kiran				4.			
				5.				6.			
				Benefits							
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Lever perpendicularity more than 0.3 mm ?		Lever perpendicularity phenomena rejection reduced from 2.6 to 0.06 %		What To Do : Verification of wear of jaw							
A1 : Distortion during welding operation											
W2 : Why Distortion during welding operation ?											
A2 : Job clamping was not 100 %		<div></div>									
W3 : Why Job clamping was not 100 % ?											
A3 : 2 Jaw used for job clamping											
W4 : Why 2 Jaw used for job clamping ?											
A4 :											
Root Cause											
2 Jaw used for job clamping											
Date : 18/12/2017											
Registered By : Ms Priti Sakhare											
Manager's Sign :											
----- BAL Prass and Fab Team -----											