

<div></div>	Equipment :	Petrol Tank	Loss Type :	Defect loss							KAIZEN IDEA SHEET
	Department :	QA P&F	Result :	N	P	Q	C	D	S	M	
	Cell :	Welding cell at NAPL	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Welding operation								
Kaizen Theme: To eliminate defect of canister bracket shift			Idea : Standardize welding sequence for canister bracket								
Problem / Present Status		Counter Measure		Benchmark :		Zero defect generation					
To Eliminate defect of canister brakcet shift		To standardize welding sequence of the canister bracket to avoid welding distortion .		Target :		Zero Defect of stack height variation					
				Start :		18/12/2017		Finished :		18/12/2017	
<div></div>		<div></div>		Note :							
				Team Members :							
				1. Miss. Priti Sakhare			2. Mr. Unde				
				3. Mr. Prakash Wayal			4.				
				5.			6.				
				Benefits							
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Canister mounting bracket shift in Z axis -3 ~4 mm ?		Canister bracket shift defect reduced to zero		What To Do : To confirm sequence of welding during canister bracket welding							
A1 : Canister bracket welding variation wrt rear bracket											
W2 : Why Canister bracket welding variation wrt rear bracket ?				How To Do : SOP monitoring / Process audit							
A2 : Bracket welding sequence not defined		<div></div>									
W3 : Why Bracket welding sequence not defined ?				Frequency : Daily Basis							
A3 :				Cost Incurred For Making Kaizen :							
W4 :				Material Cost		Labour Cost		Total			
A4 :				0.00		0.00		0.00			
Root Cause				Scope & Plan For Horizontal Deployment :							
Bracket welding sequence not defined				Equipmnet				Target		Status	
Date : 18/12/2017											
Registered By : Ms Priti Sakhare											
Manager's Sign :											
----- BAL Prass and Fab Team -----											