×	Equipment :	MA1400 & Motoweld EL35	50	Los	Loss Type : Defect loss									KAIZEN IDEA SHEET				
	Department :	Press & Fabrication			Result :		P	> Q	С	D	S	1	м					
	Cell :	Robotic Welding		Type :										Kaizen ID : 3242				
Unit Name : Press and Fab - Quality, Pune (Robotic Mig welding operation.										
Kaizen Theme: To in	crease leakage % RFT	for K4 Silencer @ SMAuto_	_Mhalunge plant.	Idea : To implement welding wire having more fluidity / wettability.														
Problem / Present Status	5		Counter Measure						Benchmark : > 95% F				5% RFT	۲. FT				
1) 30 to 40% RFT of muffle	er peripheral welding ru	in at leakage testing.	Implement 308L Welding wire which is having more wettability compare to BALVM246 wire.					Target : > 95% R				5% RFT	FT					
2) Bead size is 6 to 6.5 mr	n and interrupted.							Start : 01/11/2017			Fin	Finished : 10/11/2017						
×			×				Note :	Note :										
							Team Members :											
								1. Mr. Omkar Patinge				2. N	2. Mr. D R Shitole					
								3. Mr. Mansing Shingare				4. N	4. Mr. Pravin					
								5.				6.	6.					
									Benefits									
								Q 1)	Q 1) Leakage RFT increased to > 95%.									
Why Why Analysis -			Pacult - Kaizan Sustanana															
W1 : Why Very low % RFT of K4 Silencer Muffler peripheral weld joint ?			1) Leakage RFT Increase to > 95%						What To Do : Monitoring leakage RFT at leak test stage for monitoring wire									
A1 : Weld bead size less a	nd interrupted weld rur	ı	2) Welding speed increased from 0.6Mtr/Min to 1.4 Mtr/min. 3) Weld head size increased from 6 mm to 7 5mm						performance.									
W2 : Why Weld bead size less and interrupted weld run ?					Llow To Day Draces and increase in													
A2 : Poor weetability of BAL VM 246 Weld wire			×		How TO DO . Process audit and inspection.													
W3 : Why Poor weetability of BAL VM 246 Weld wire ?																		
A3 :								Freque	ncy : Da	uly.								
W4 :								Cost In	curred	For Ma	king K	Kaizen	ו:					
A4 :								N	laterial	al Cost Labo			_abour Co	ur Cost Total				
									0.00				0.00		0.00			
								Scope & Plan For Horizontal Deployment :										
Poot Cause									Equipmnet					Т	arget St	tatus		
Poor weetability of BAL VM 246 Weld wire																		
Date : 19/12	/2017																	
Registered By : Mr O	mkar Patinge																	
Manager's Sign :																		
BAL Prass and	Fab Team																	