

✖	Equipment :		Loss Type :	Defect loss							KAIZEN IDEA SHEET
	Department :	Press & Fab	Result :	N	P	Q	C	D	S	M	
	Cell :	frame	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Robotic welding								
Kaizen Theme: To reduced spatter of frame during robotic welding.			Idea : Shielding gas combination change to Ar 90% : CO2 10 %								
Problem / Present Status		Counter Measure			Benchmark :						
1. More spatter observed on frame during robotic welding. 2. Manpower required for chipping operation.		Ar 80 % : CO2 20 % gas combination replace with Ar 90 % : CO2 10 %.			Target :						
					Start :		10/12/2017		Finished :		15/12/2017
✖		✖			Note :						
					Team Members :						
					1. Dhananjay Shitole		2. Omkar Patinge				
					3.		4.				
					5.		6.				
					Benefits						
Why Why Analysis :		Result :			Kaizen Sustenance :						
W1 : Why More spatter observed on frame during robotic welding. ? A1 : Co2 % is more in shielding gas W2 : Why Co2 % is more in shielding gas ? A2 : Ar 80 % : CO2 20% shielding gas used. W3 : Why Ar 80 % : CO2 20% shielding gas used. ? A3 : W4 : A4 :		1. Spatter reduced up to 50 % on frame. 2. Reduction in glass beed. ✖			What To Do :						
					How To Do :						
					Frequency :						
					Cost Incurred For Making Kaizen :						
					Material Cost		Labour Cost		Total		
					0.00		0.00		0.00		
					Scope & Plan For Horizontal Deployment :						
					Equipmnet				Target		Status
Root Cause Ar 80 % : CO2 20% shielding gas used.											
Date : 21/12/2017											
Registered By : Mr Dhananjay Shitole											
Manager's Sign :											
----- BAL Prass and Fab Team -----											