V	Equipment :	Robo 1 welding fixture.	Loss Type: DIE / JIG /						220				KAIZEN IDEA SHEET				
	Department :	Press and Fab - Quality		<del>                                     </del>				1				<del></del>	- KAIZEN IDEA SHEET				
	Cell:	K1 Silencer cell, Badve Sh	nivrai	Result :	N	+	Р	Q	С	D	S	М	-	Kaizen ID : 3249			
			liviai	Type :			1/4	. 7			<i></i>			Kaizen ID	: 3249		
Unit Name : Press	and Fab - Quality, Pu	ne 		0	peration :		K1 8	silencer	weldin	g opera	tion or	robo 1.					
Kaizen Theme: To red	duce Fixture JH time.		Idea	: То	o provide r	ma	sking	to LM	guide.								
Problem / Present Status			Counter Measure					Benchmark: 5n				5minute	5minutes/shift.				
Presently LM guide ways are open . so spatters accumalated on guideways. So JH time increased.			Bellows provided to restrict the spatter to fall on LM guide rail. This reduces JH time.					Target :			2minutes/shift.						
			orrune.						<b>Start</b> : 25/12/2017		2017		Finished: 27/12/201		7/12/2017	,	
×			×				$\neg$	lote :						<u> </u>			
								Team Members :									
								1. Mr. S. U. Deshpande					2. Mr. K. B Varpe				
								3. Mr. Pradeep S Patil					4. Mr. S. S. Kulkarni				
								5.					6.				
							E	Benefits	<u> </u>				-				
Why Why Analysis :			Result:					Kaizen Sustenance :									
W1 : Why More Fixture JH time ?			Welding fixture JH time reduces From 5minutes/shift to 2minutes/shift.					What To Do : To check the bellow for damage									
			Welding fixture JH time reduces From 5minutes/shi	t to 2minu	ıtes/shift.		٧	What To	Do : T	o check	the be	ellow for	damage				
A1 : Spatter accumalated o	n LM guide		Welding fixture JH time reduces From 5minutes/shi Hence productivity increased. Also spare cost redu	t to 2minu ed.	ıtes/shift.		٧	What To	Do : T	o check	the be	ellow for	damage				
	n LM guide		Welding fixture JH time reduces From 5minutes/shi Hence productivity increased. Also spare cost redu	t to 2minu ed.	ites/shift.								damage				
A1 : Spatter accumalated o	n LM guide ated on LM guide?		Welding fixture JH time reduces From 5minutes/shi Hence productivity increased. Also spare cost reduces	t to 2minu ed.	utes/shift.							ellow for o	damage				
A1 : Spatter accumalated o	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu eed.	utes/shift.								damage				
A1 : Spatter accumalated o W2 : Why Spatter accumala A2 : No masking provided to	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu æd.	utes/shift.		F		Do : Tł	nrough 、	JH che		damage				
A1 : Spatter accumalated on W2 : Why Spatter accumals A2 : No masking provided to W3 : Why No masking prov	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu ed.	utes/shift.		H F	How To Frequen	Do : Th	nrough waily & We	JH che eekly.		damage				
A1 : Spatter accumalated on W2 : Why Spatter accumalated A2 : No masking provided to W3 : Why No masking prov A3 :	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu eed.	utes/shift.		H F	How To Frequen	Do : Th	nrough waily & We	JH che eekly.	ck sheet	damage our Cost		Total		
A1: Spatter accumalated of W2: Why Spatter accumals A2: No masking provided to W3: Why No masking prov A3: W4:	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu ced.	utes/shift.		H F	How To Frequen Cost Inc	Do : Th	nrough willy & Wo	JH che eekly.	ck sheet aizen :			Total 2700.00		
A1: Spatter accumalated of W2: Why Spatter accumals A2: No masking provided to W3: Why No masking prov A3: W4:	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu ed.	utes/shift.		F	How To Frequen Cost Inc	Do : The cy : Date curred aterial (2500.0	nrough waily & Wo	JH che	ck sheet aizen : Labo	our Cost				
A1 : Spatter accumalated of W2 : Why Spatter accumalated A2 : No masking provided to W3 : Why No masking prov A3 : W4 :	n LM guide ated on LM guide ? o LM guide		Hence productivity increased. Also spare cost redu	t to 2minu ced.	utes/shift.		F	How To Frequen Cost Inc	Do : The cy : Date curred aterial (2500.0	For Hol	JH cheekly.	ck sheet  (aizen : Labo 20 al Deploy	our Cost	Target	2700.00		
A1: Spatter accumalated of W2: Why Spatter accumals A2: No masking provided to W3: Why No masking prov A3: W4:	n LM guide ated on LM guide ? o LM guide rided to LM guide ?		Hence productivity increased. Also spare cost redu	t to 2minu ed.	utes/shift.		F	How To Frequen Cost Inc	Do : The cy : Date curred aterial (2500.0	For Hol	JH che	ck sheet  (aizen : Labo 20 al Deploy	our Cost	Target	2700.00	Status	
A1 : Spatter accumalated of W2 : Why Spatter accumalated A2 : No masking provided to W3 : Why No masking provided A3 : W4 : A4 :	n LM guide ated on LM guide ? o LM guide rided to LM guide ?		Hence productivity increased. Also spare cost redu	t to 2minu eed.	utes/shift.		F	How To Frequen Cost Inc	Do : The cy : Date curred aterial (2500.0	For Hol	JH cheekly.	ck sheet  (aizen : Labo 20 al Deploy	our Cost	Target	2700.00		
A1 : Spatter accumalated of W2 : Why Spatter accumalated A2 : No masking provided to W3 : Why No masking provided to W4 :  A4 :  Root Cause No masking provided to LM  Date : 02/01/	n LM guide ated on LM guide ? o LM guide rided to LM guide ?		Hence productivity increased. Also spare cost redu	t to 2minu eed.	utes/shift.		F	How To Frequen Cost Inc	Do : The cy : Date curred aterial (2500.0	For Hol	JH cheekly.	ck sheet  (aizen : Labo 20 al Deploy	our Cost	Target	2700.00		
A1 : Spatter accumalated of W2 : Why Spatter accumalated A2 : No masking provided to W3 : Why No masking provided to W4 :  A4 :  Root Cause No masking provided to LM  Date : 02/01/	n LM guide ated on LM guide ? o LM guide rided to LM guide ?  I guide 2018 adeepkumar Patil		Hence productivity increased. Also spare cost redu	t to 2minu ced.	utes/shift.		F	How To Frequen Cost Inc	Do : The cy : Date curred aterial (2500.0	For Hol	JH cheekly.	ck sheet  (aizen : Labo 20 al Deploy	our Cost	Target	2700.00		