

<div><div></div></div>	Equipment :	Robo 1 welding fixture.	Loss Type :	DIE / JIG / TOOL Loss							KAIZEN IDEA SHEET			
	Department :	Press and Fab - Quality	Result :	N	P	Q	C	D	S	M				
	Cell :	K1 Silencer cell, Badve Shivrai	Type :									Kaizen ID : 3249		
Unit Name : Press and Fab - Quality, Pune			Operation : K1 silencer welding operation on robo 1.											
Kaizen Theme: To reduce Fixture JH time.			Idea : To provide masking to LM guide.											
Problem / Present Status		Counter Measure			Benchmark :		5minutes/shift.							
Presently LM guide ways are open . so spatters accumulated 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.							
<div><div></div></div>		<div><div></div></div>			Start :		25/12/2017		Finished :		27/12/2017			
					Note :									
					Team Members :									
					1. Mr. S. U. Deshpande					2. Mr. K. B Varpe				
					3. Mr. Pradeep S Patil					4. Mr. S. S. Kulkarni				
5.					6.									
Benefits														
Why Why Analysis :		Result :			Kaizen Sustenance :									
W1 : Why More Fixture JH time ?		<div><div></div></div>			What To Do : To check the bellow for damage									
A1 : Spatter accumulated on LM guide					How To Do : Through JH check sheet									
W2 : Why Spatter accumulated on LM guide ?					Frequency : Daily & Weekly.									
A2 : No masking provided to LM guide					Cost Incurred For Making Kaizen :									
W3 : Why No masking provided to LM guide ?					<table><tr><td>Material Cost</td><td>Labour Cost</td><td>Total</td></tr><tr><td>2500.00</td><td>200.00</td><td>2700.00</td></tr></table>							Material Cost	Labour Cost	Total
Material Cost	Labour Cost	Total												
2500.00	200.00	2700.00												
A3 :		Scope & Plan For Horizontal Deployment :												
W4 :														
A4 :														
Root Cause														
No masking provided to LM guide														
Date : 02/01/2018														
Registered By : Mr Pradeepkumar Patil														
Manager's Sign :														
----- BAL Prass and Fab Team -----														