

<div></div>	Equipment :	SSW	Loss Type :	Yield Loss							KAIZEN IDEA SHEET
	Department :	Materials -QA	Result :	N	P	Q	C	D	S	M	
	Cell :	Welding	Type :								
Unit Name : Press and Fab - Quality, Pune			Operation : Projection welding								
Kaizen Theme: To eliminate stud weak projection welding defect -Bracket 24165375			Idea :								
Problem / Present Status		Counter Measure			Benchmark :		09 No's				
09 Frames found at BAL for weak projection		Electrode design revised - Dia 19 mm to 15 mm , more clearance between electrode & bracket (No shunting)			Target :		Zero				
					Start :		30/11/2017		Finished :		01/12/2017
<div></div>		<div></div>			Note :						
					Team Members :						
					1. Mr. Nitin Shinde				2. Mr.KG Narwade		
					3. Mr.PS Choudhari				4.		
					5.				6.		
					Benefits						
Why Why Analysis :		Result :			Kaizen Sustenance :						
W1 : Stud projection weak		As below			What To Do : Ensure electrode dia 15 mm during PM						
A1 :											
W2 : Current by Pass					How To Do : Check dia during PM						
A2 :		<div></div>									
W3 : Shunting of electrode to bracket					Frequency : Every week						
A3 :					Cost Incurred For Making Kaizen :						
W4 : Very less clearance between electrode diameter and bracket inner dimension.					Material Cost		Labour Cost		Total		
A4 :					0.00		0.00		0.00		
Root Cause					Scope & Plan For Horizontal Deployment :						
					Equipmnet				Target		Status
Date : 03/01/2018											
Registered By : Mr Nitin Shinde											
Manager's Sign :											
----- BAL Prass and Fab Team -----											