

	Equipment :	Robot	Loss Type :	Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 515																																																																				
	Department :	Production	Result :	N	P	Q	C	D	S	M																																																																					
	Cell :	Sprint chassis	Type :																																																																												
Unit Name :			112236 - BADVE ENGINEERING LIMITED. (2 Wh Waluj), Aurangabad		Operation :							full Welding																																																																			
Kaizen Theme:			Improvements Of Welding Quality		Idea :							No Manual Welding Error																																																																			
Problem / Present Status			Counter Measure					Benchmark :		17																																																																					
e.g.Grab handldled to upper rear pipe LH-Welding penetraion,shabby welding,run shifting.blow holes ,etc.			e.g.Grab handldled to upper rear pipe LH-Improve weld quality.					Target :		Zero																																																																					
								Start :		25/06/2013		Finished :		01/07/2013																																																																	
								Note :																																																																							
								Team Members :																																																																							
								1. Mr.V.P.Neel		2. Mr.Sayyed Imran																																																																					
3. Mr.Vishnu		4. Mr.Kalpesh M.Badguja		5.		6.																																																																									
Benefits																																																																															
C			Rework cost Reduce Rs 0.00																																																																												
P			productivity per hr increases Nos 0.00																																																																												
Q			IHR Reduce Nos 0.00																																																																												
Why Why Analysis :			Result :					Kaizen Sustenance :																																																																							
W1 : Why Improvements Of Welding Quality ? A1 : Welding Penetration & Defects W2 : Why Welding Penetration & Defects ? A2 : Touch angle approach (position) not available W3 : Why Touch angle approach (position) not available ? A3 : Manual welding error W4 : Why Manual welding error ? A4 :			Weld penetraion & quality imrove. <table border="1"> <thead> <tr> <th colspan="14">Grab handled to Seat rail pipe LH</th> </tr> <tr> <th>Date:-</th> <th>21-May</th> <th>30-May</th> <th>8-Jun</th> <th>30-Jun</th> <th>7-Jul</th> <th>15-Jul</th> <th>21-Jul</th> <th>30-Jul</th> <th>10-Aug</th> <th>25-Aug</th> <th>9-Sep</th> <th>14-Sep</th> <th>17-Sep</th> </tr> </thead> <tbody> <tr> <td>P1</td> <td>13.67</td> <td>15.33</td> <td>40.2</td> <td>102.3</td> <td>27.93</td> <td>34.2</td> <td>63</td> <td>59.87</td> <td>49.87</td> <td>41.28</td> <td>91.4</td> <td>37.87</td> <td>47.53</td> </tr> <tr> <td>P2</td> <td>70.33</td> <td>77.66</td> <td>68.93</td> <td>63..73</td> <td>61.2</td> <td>71.46</td> <td>63.4</td> <td>59.86</td> <td>49.13</td> <td>29.62</td> <td>9.8</td> <td>52.07</td> <td>56.26</td> </tr> </tbody> </table>					Grab handled to Seat rail pipe LH														Date:-	21-May	30-May	8-Jun	30-Jun	7-Jul	15-Jul	21-Jul	30-Jul	10-Aug	25-Aug	9-Sep	14-Sep	17-Sep	P1	13.67	15.33	40.2	102.3	27.93	34.2	63	59.87	49.87	41.28	91.4	37.87	47.53	P2	70.33	77.66	68.93	63..73	61.2	71.46	63.4	59.86	49.13	29.62	9.8	52.07	56.26	What To Do : Make SOP for robotic programme change How To Do : Daily maintaining the record of robot touch up Frequency : Daily Cost Incurred For Making Kaizen : <table border="1"> <thead> <tr> <th>Material Cost</th> <th>Labour Cost</th> <th>Total</th> </tr> </thead> <tbody> <tr> <td>1000.00</td> <td>440.00</td> <td>1440.00</td> </tr> </tbody> </table> Scope & Plan For Horizontal Deployment : <table border="1"> <thead> <tr> <th>Equipmnet</th> <th>Target</th> <th>Status</th> </tr> </thead> <tbody> <tr> <td>Robot full welding</td> <td>28/10/2013</td> <td>COMPLETE</td> </tr> </tbody> </table>				Material Cost	Labour Cost	Total	1000.00	440.00	1440.00	Equipmnet	Target	Status	Robot full welding	28/10/2013	COMPLETE
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