	Equipment :	Welding machine		Loss Type :	Defect	Loss													
	Department	Development		Result :	N	Р	Q	С	D S	М	🗌 ка	DEA SHEE	т						
warmeng energ				Type :							-								
Cell : KTM	JY pipe A assy.		Operation : Pipe A to pipe B Full welding																
Kaizen Theme: To eli	minate pipe A to pip	e B welding bead not uniform	n KTM JY exhaust pipe A assembly.	Idea :	Torc	h angle	and ar	rc length co	nstant on rou	und perip	ohery during we	elding by	automation.						
Problem / Present Status			Counter Measure					Benchmark : 5 n			no's								
When = July 13 (Who = Pipe A to Pipe B welding operator. (What = KTM JY pipe A assy. (Where = Pipe A to pipe B welding. (Which = Pipe A to pipe B			Round welding SPM provided.					Target : 0											
								Start : 25/06/2013)13	Finis	Finished : 27/07/2013		3					
								Note :											
		Manual				1		Team Mem	bers :										
		welding	SPM		K	7		1. Mr. Shin	gavi		2.								
			SPINI ARE	1	Torch			3. Mr. S R Shaikh			4.	4.							
						1		5. Mr. S K Kulkarni			6.	6.							
							Benefits												
		EACH S			Con and	Real Property lies													
				Pipe B															
Ok	Not Ok		Pipe A 10.32																
Why Why Analysis :			Result :					Kaizen Sustenance :											
W1 : Why Pipe A to Pipe B welding bead not uniform. ?			Customer complaint zero					What To Do : Preventive Maintaince for SPM as per V6 check sheet.											
A1 : Pipe A to Pipe B welding bead not uniform due to torch angle and arc length not constant.																			
A1 : Pipe A to Pipe B weld length not constant.					Pipe A to Pipe B welding bead not uniform								How To Do : V6 audit.						
length not constant. W2 : Why Pipe A to Pipe B	s welding bead not u	niform due to torch angle and	Pipe A to Pipe B w	velding bea	d not	unifo		How To Do	: V6 audit.										
length not constant. W2 : Why Pipe A to Pipe B arc length not constant. ? A2 : Torch angle and arc le	-	-		velding bea CC trend	d not	unifo		How To Do	: V6 audit.										
length not constant. W2 : Why Pipe A to Pipe B arc length not constant. ? A2 : Torch angle and arc le manual welding operation. W3 : Why Torch angle and	ength not constant or	-	6 - 5	-	d not	unifo	rm		: V6 audit. : V6 audit as	per freq	uency.								
length not constant. W2 : Why Pipe A to Pipe B arc length not constant. ? A2 : Torch angle and arc le manual welding operation. W3 : Why Torch angle and to manual welding operation	ength not constant or	n round periphery due to	6 5 5 7	-	d not	unifo	rm	Frequency			-								
length not constant. W2 : Why Pipe A to Pipe B arc length not constant. ? A2 : Torch angle and arc le manual welding operation.	ength not constant or	n round periphery due to		-	d not	unifo 0	rm	Frequency Cost Incur	: V6 audit as		-		Total						
length not constant. W2 : Why Pipe A to Pipe B arc length not constant. ? A2 : Torch angle and arc le manual welding operation. W3 : Why Torch angle and to manual welding operation A3 :	ength not constant or	n round periphery due to	6 5 5 5 7 4 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7	CC trend		0	rm	Frequency Cost Incur Mate	: V6 audit as red For Mak		en :		Total 0.00						
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