S DA 14 1	Equipment :	Full Welding	Loss Type :	Defect	Loss														
S BAJAJ	Department	Quality		Result :	N	Р		Q C	D	S	М	KAIZEN	KAIZEN IDEA SHEET						
Wortwerty Anenn				Type :															
Cell : (3W))Full frame				Оре	ration :		Full weldin	g										
Kaizen Theme: To el	liminate rejection fo	r Welding lumps at main mem	ber ,lower part & lower reinforcement join	ing Idea :	No n	nannual	err	ror											
Problem / Present Status			Counter Measure					Benchr	Benchmark :			1146/month							
Welding lumps at at main member ,lower part & lower reinforcement joining due to heavy gap.			By providing copper plate at FF-30 main member,bottom reinforcement & lower part weld joint bottom side area.				Target	Target : zer			ero/month								
			iower part weid joint bottom side area.					Start : 12/08/2013		3	Finished : 17/08/2013		2013						
					1240	100	K	Note :											
								Team Members :											
20								1. Mr.C	1. Mr.Chopade			2. Mr.Rakhade							
	- lun							3.					4.						
	AT AL	State of the local division of the local div						5.				6.							
		1-02						Benefits											
L 2							9												
Why Why Analysis :			Result :					Kaizen Sustenance :											
W1 : Why To eliminate rejection for Welding lumps at main member ,lower part & lower reinforcement joining due to heavy gap. ?			No Lumps at main member					What T	What To Do : Check copper plate bolting & top surface.										
?									How To Do : Point added in daily JH check sheet.										
? A1 : Co2 weld lumps at lov	wer reinf & Y memb	er weld joint					IHR												
W2 : Why Co2 weld lumps	s at lower reinf & Y	member weld joint ?	IHE	2				How IC			,	in check sheet.							
W2 : Why Co2 weld lumps A2 : Gap observed at lowe	s at lower reinf & Y er reinf & Y member	member weld joint ?	IHE	2							,	TT CHECK SHEET.							
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a	s at lower reinf & Y er reinf & Y member at lower reinf & Y me	member weld joint ? ember. ?	1500 1123		- 1			Freque											
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a	member weld joint ? omber. ? ssly insetion.	1500 1123	19				Freque	ncy : Da										
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a	member weld joint ? omber. ? ssly insetion.	1500 1123 928 928	19	_	•— 1 HIF	R	Freque Cost In	ncy : Da	ily For Making	g Kaizen		Т	otal					
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a	member weld joint ? omber. ? ssly insetion.	1500 928 1000 928 83			•— 1 HIF	R	Freque Cost In	ncy : Da curred I	ily For Making Cost	g Kaizen	:		otal					
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a	member weld joint ? omber. ? ssly insetion.	1500 1000 500 1123 1123 83 83 83 83 83 83 83 83 83 8	0		◆ — 1 H F	R	Freque Cost In	ncy : Da curred I laterial (400.00	ily For Making Cost	g Kaizen	: abour Cost 180.00							
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua A4 : Mannualy error.	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a	member weld joint ? omber. ? ssly insetion.	1500 1000 500 0	0		♦ —— 1 H4F	R	Freque Cost In	ncy : Da curred I laterial (400.00	ily For Making Cost	g Kaizen L ntal Dep	: abour Cost 180.00							
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a	member weld joint ? omber. ? ssly insetion.	1500 1000 500 0	0	-	\$ +45	R	Freque Cost In	ncy : Da curred I laterial (400.00	ily For Making Cost) For Horizo	g Kaizen L ntal Dep	: abour Cost 180.00	58	0.00					
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua A4 : Mannualy error. Root Cause Mannualy error.	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a aly gap for main men	member weld joint ? omber. ? ssly insetion.	1500 1000 500 0	0	-	• 1 HF	R	Freque Cost In	ncy : Da curred I laterial (400.00	ily For Making Cost) For Horizo	g Kaizen L ntal Dep	: abour Cost 180.00	58	0.00					
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua A4 : Mannualy error. Root Cause Mannualy error. Date : 12/08	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a aly gap for main men	member weld joint ? omber. ? ssly insetion.	1500 1000 500 0	0	-	●—— 1 H45	R	Freque Cost In	ncy : Da curred I laterial (400.00	ily For Making Cost) For Horizo	g Kaizen L ntal Dep	: abour Cost 180.00	58	0.00					
W2 : Why Co2 weld lumps A2 : Gap observed at lowe W3 : Why Gap observed a A3 : Create mannualy gap W4 : Why Create mannua A4 : Mannualy error. Root Cause Mannualy error. Date : 12/08	s at lower reinf & Y er reinf & Y member at lower reinf & Y me o for main member a aly gap for main men aly gap for main men 8/2013 A S Pawar	member weld joint ? omber. ? ssly insetion.	1500 1000 500 0	0	-	• 1 HF	R	Freque Cost In	ncy : Da curred I laterial (400.00	ily For Making Cost) For Horizo	g Kaizen L ntal Dep	: abour Cost 180.00	58	0.00					