



KAIZEN SHEET

Activity Pillar	KK	JH	PM	QM	TM	E&T	OTPM	SHE	DM
Loss No./ Step									
Benefit Area		P	Q	C	D	S	M		



Lucas TVS Padi

B.Unit: CSBU **Module/Cell:** YOKE **Machine:** Submerged Arc Welding **Machine No:** IVW0117

Kaizen Theme : Reducing Start up Loss in Yoke Welding **Idea :** Automatic switch on

Problem/Present status :
Start up time Loss high in Submerged Arc Welding machine



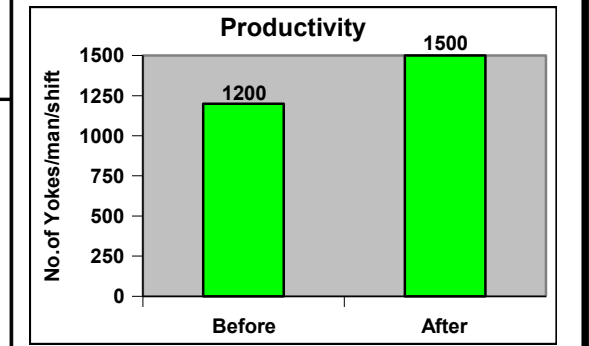
Countermeasure (kaizen):
Providing 7 Day Programmable Timer to switch on flux heating at 6.15 a.m.



Bench mark	60mts
Target	zero
Kaizen start	29.12.04
Kaizen Finish	4. 1. 05

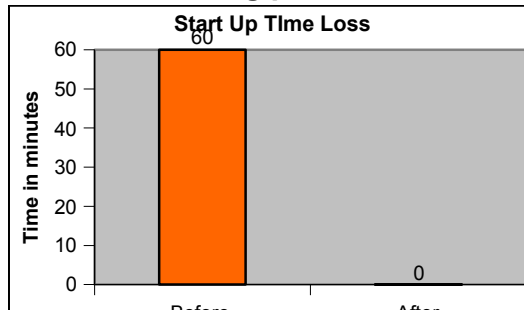
Team members
Kothandaraman
Rajagopal
Diwakar
Srinivasan

Benefits:



Analysis :
Start up Loss high
Why?
Flux heat up time high
Why?
Flux heater switched on only at start of shift
Why?
Manual switch on at the start of shift

Results : Flux Tank attains set temp. at 7.15 a.m to start welding process



Scope & Plan for Horizontal Deployment

S.No	M/c No.	Target date	Responsibility	Status
1	IVW0013	Mar'05	VK	Completed

Root cause: Manual switch on

Before

After

Before 60

After 0

Before 1200

After 1500