


	Equipment :	CNC Lathe	Loss Type :	Setup & adjustment Loss							KAIZEN IDEA SHEET
	Department :	pProduction	Result :	N	P	Q	C	D	S	M	
	Cell :	CNC	Type :								
Unit Name : Varad Engineering,			Operation : TURNING ,BOARING								
Kaizen Theme: To reduce setup time for CNC machining for component coller exhaust tube			Idea : Hold the component at same location and set the jaw position such that in both setup component holding will be at same dia & length								
Problem / Present Status		Counter Measure		Benchmark :		1.2 hrs					
While machining coller exhaust tube 2 set up each for one sdie required .And avery time jaw setting & boring is required which requires 0.6 hrs each.		Jaw boring is done in a such way that at both set up component can be clamped on same area & length		Target :		.6 hrs					
				Start :		19/10/2013		Finished :		22/10/2013	
				Note :							
				Team Members :							
				1. Mr Malkar		2.					
				3.		4.					
				5.		6.					
Benefits											
P		set up time reduced by 50% Rs 0.00									
D		lead time reduced as both sides can be machined one after another in same set up. Rs 0.00									
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : A1 : W2 : A2 : W3 : A3 : W4 : A4 :		set up time reduced to .6 hrs for both set up . and lead time of component is also reduced as both sides can be machined at a time one bye one		What To Do : each supervisor has to be informed & trained for setting.							
				How To Do : Mr maklar will explain how to do setting							
				Frequency :							
				Cost Incurred For Making Kaizen :							
				Material Cost		Labour Cost		Total			
				0.00		0.00		0.00			
Root Cause				Scope & Plan For Horizontal Deployment :							
Date : 19/10/2013				Equipmnet		Target		Status			
Registered By : Mr. Abhay deshmkh											
Manager's Sign :											
----- Rucha Engineering Pvt Ltd -----											