S PA IA I	Equipment :	Piercing punch	Los	Loss Type : Defect Loss								KAIZEN IDEA SHEET					
S BAJAJ	Department :	Tool room		Res	sult :	N	Р	Q C		D	s	Μ	-				
Distinctly Akead	Cell :	Tool mainetainence	Тур	e:			Kaizen IE					Kaizen ID : 27	28				
Unit Name : 100264 - RUCHA ENGINEERING PVT LTD., Aurangabad Operation : PIERCING																	
Kaizen Theme: PRODUCTIVITY IMPROVEMENT Idea : Change the punch design, Step punch to standard plan punch with sleeve.																	
Problem / Present Status			Counter Measure					Benchmark : 8				8					
PIERCING PUNCH BROKEN FREQUENTLY .			Change the punch design, Step punch to standard plan punch with sleeve.					Target : 0				0					
									Start : 02/06/2015				Finished	Finished : 04/06/2015			
20 3840 4000 16 3500 15 2880 3000 Punch Broken			Sieeve Standard pan					Note :	lote :								
								Team Members :									
								1. Tool maint team					2.	2.			
2400	250	00 Punch Broken	The second secon	Tool S				3.					4.	4.			
10		00 Cost	Gen - Contraction - Contractio				- 5.					6.	6.				
5 5 6								Benefits									
	50	D	The second se					P Productivity Nos 400.00									
0 Mar-15 Apr-	15 May-15							C Cost saved Rs 300.00									
Why Why Analysis : W1 : Why Very Hard To Piercing Dia 5.2mm Hole & in 6.0 mm Material			Result : Zero production loss due to broken punch.						Kaizen Sustenance : What To Do : Point added in JH/PM sheet.								
Thickness. ? A1 : Piercing punch broken frequently.																	
W2 : Why Piercing punch broken frequently. ?									How To Do : Doint added in 1H/DM aboat								
A2 : Due To High load on			20 4500					How To Do : Point added in JH/PM sheet.									
W3 : Why Due To High loa			15 13 2880 - 4000 - 3500 - 3000 Punch Brcken														
?									Frequency : Daily								
A3 : No strength to piercin W4 : Why No strength to p			8	2000	Cost				Cost Incurred For Making Kaizen :								
?			_ 5 _ _	500 000			Material Cost La			La	our Cost Total		otal				
A4 :			0 00 00 00	500)					0.00				0.00 0.00				
			Mar-15 Ma					Scope &	Scope & Plan For Horizontal Deployment :								
Root Cause								Equipmnet						Target	Status		
No strength to piercing punch.						New Transport shakel pier tool 25/08/201						25/08/2015	PROCESS				
Date : 02/06	6/2015																
	Amol Girme																
Manager's Sign : Mr.R																	
Bajaj Auto Ltd.	(Fabrication)																