
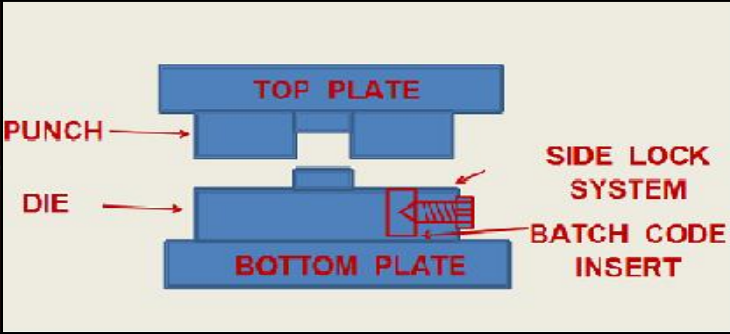
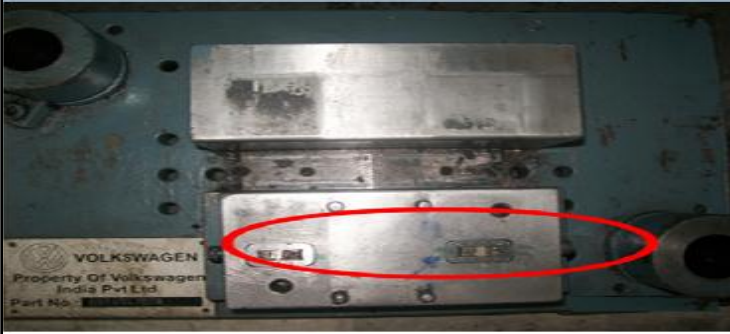
	Equipment :	Press machine	Loss Type :		Defect Loss							KAIZEN IDEA SHEET Kaizen ID : 2729		
	Department :	Production	Result :		N	P	Q	C	D	S	M			
	Cell :	Press shop	Type :											
Unit Name :			100264 - RUCHA ENGINEERING PVT LTD., Aurangabad			Operation :							Stamping.	
Kaizen Theme:			REDUCTION IN CHANGE OVER TIME OF BATCH CODE IN 707/709			Idea :							WE CAN SHIFT BATCH CODE IN BOTTOM DIE & ELIMINATE VERTICAL LOCK SYSTEM	
Problem / Present Status			Counter Measure				Benchmark :		41					
Total time required to change the batch plate is 41 min.			BATCH CODE IS FIXED INTO RE STRIKE DIE WITH SIDE LOCK SYSTEM				Target :		3					
							Start :		15/05/2015		Finished :		25/05/2015	
							Note :							
							Team Members :							
							1. MR Navnat		2.					
3.		4.												
5.		6.												
Why Why Analysis :			Result :				Kaizen Sustenance :							
W1 : Why Problem:-Cycle Time Require For Change Over Of Batch Code Is More ? A1 : Die Need To Be Open During Change Over W2 : Why Die Need To Be Open During Change Over ? A2 : Operator Cannot Change Batch Code In Ongoing Production W3 : Why Operator Cannot Change Batch Code In Ongoing Production ? A3 : Vertical Lock System As Batch Code Is In Punch W4 : Why Vertical Lock System As Batch Code Is In Punch ? A4 :			Time required to change batch plate is 3 min.				What To Do : Updated in toll history card How To Do : check tool history card Frequency : Daily							
Root Cause							Cost Incurred For Making Kaizen :							
Vertical Lock System As Batch Code Is In Punch							Material Cost		Labour Cost		Total			
Date :							90.00		220.00		310.00			
Registered By :							Scope & Plan For Horizontal Deployment :							
Manager's Sign :			Equipmnet		Target		Status							
15/05/2015			6R0.804.181/182		28/06/2015		COMPLETE							
Mr. Amol Girme			6RU.803.215/216		15/07/2015		COMPLETE							
Mr.R S Makasare			6RU.803.481		21/07/2015		COMPLETE							
----- Bajaj Auto Ltd. (Fabrication) -----			6RF.881.091		02/10/2015		PROCESS							