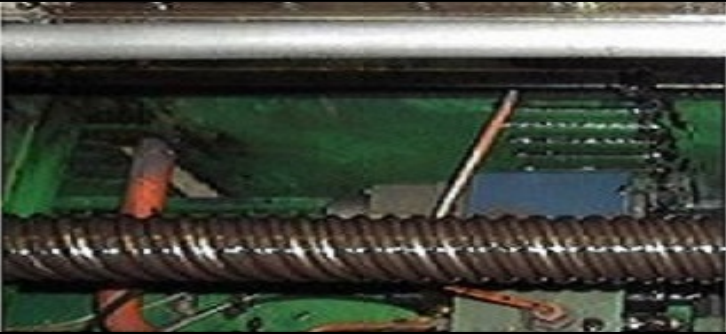
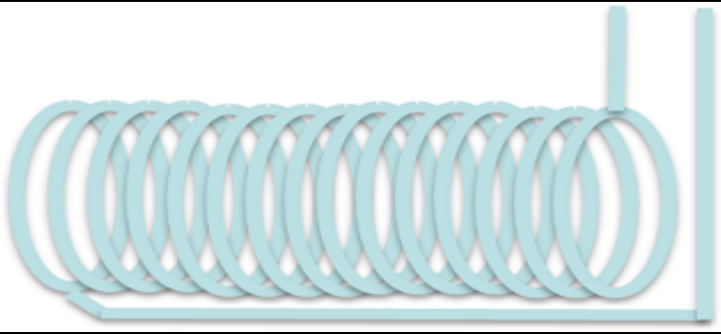

	Equipment :	Pipe Bending	Loss Type :	Productivity							KAIZEN IDEA SHEET
	Department :	Maintenance	Result :	N	P	Q	C	D	S	M	
	Cell :	weld shop	Type :								
Unit Name : Rucha Engineers Pvt Ltd Plant 2, Ahmedabad			Operation : To reduce breakdown time of bending m/c.								
Kaizen Theme: Improve the MTTR and MTBF			Idea : To provide forced cooling system.								
Problem / Present Status		Counter Measure		Benchmark :		In hyd power pack					
Oil temp of machine power pack is high causing frequent tripping of m/c.		12 MM dia. Cu pipe heat exchanger inserted in power pack.		Target :		Increased life of servo valve & power.					
				Start :		23/04/2017		Finished :		25/04/2017	
				Note :							
				Team Members :							
				1. Tulsi Kasotiya		2. Bipul Singh					
3. Jayesh Sathvara		4. Naveen Sharma									
5.		6.									
Benefits											
C		Increased life of servo valve & power pack Rs 4000.00									
P		TO improve MTBF & MTTR Minutes 4800.00									
Kaizen Sustenance :											
Why Why Analysis :		Result :		What To Do : CONTROLLING SYSTEM							
W1 : Why Machine breakdown time high ?		Improve MTTR /MTBF , Increased life of servo valve & power pack.		How To Do : WHEN TEMP GO UP TO LIMIT THEN MOTOR TRIP.							
A1 : overheating of power pack & servo valve.				Frequency :							
W2 : Why overheating of power pack & servo valve. ?				Cost Incurred For Making Kaizen :							
A2 : Oil heating high and circulate it				Material Cost		Labour Cost		Total			
W3 : Why Oil heating high and circulate it ?				2500.00		250.00		2750.00			
A3 : No cooling arrangement to hyd power pack				Scope & Plan For Horizontal Deployment :							
W4 : Why No cooling arrangement to hyd power pack ?				Equipmnet		Target		Status			
A4 : No available cooling system											
Root Cause											
Cooling system is not available in design											
Date : 19/04/2017											
Registered By : Rucha Engineers Pvt Ltd Plant 2											
Manager's Sign : Mr. S G Sohoni											
----- Rucha Group - Corporate -----											