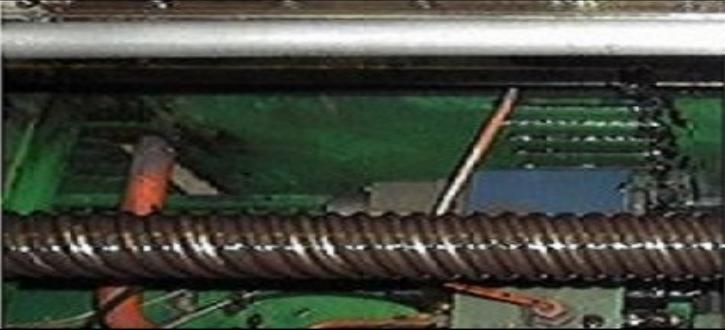
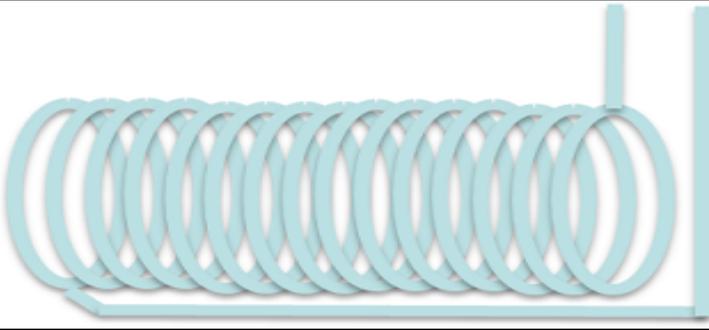
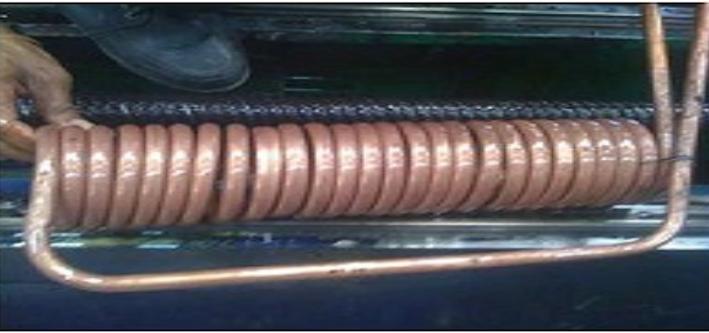


✘	Equipment :	Pipe Bending	Loss Type : Productivity					KAIZEN IDEA SHEET							
	Department :	Maintenance	Result :									N	P	Q	C
	Cell :	weld shop	Type :												
Unit Name : Rucha Engineers Pvt Ltd Plant 2, Ahmedabad			Operation : To reduce breakdown time of bending m/c.												
Kaizen Theme: 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 :							
Why Why Analysis :			Result :					Kaizen Sustenance :							
W1 : Why Machine breakdown time high ? A1 : overheating of power pack & servo valve. W2 : Why overheating of power pack & servo valve. ? A2 : Oil heating high and circulate it W3 : Why Oil heating high and circulate it ? A3 : No cooling arrangement to hyd power pack W4 : Why No cooling arrangement to hyd power pack ? A4 : No available cooling system			Improve MTTR /MTBF, Increased life of servo valve & power pack.					What To Do : CONTROLLING SYSTEM							
Root Cause Cooling system is not available in design								How To Do : WHEN TEMP GO UP TO LIMIT THEN MOTOR TRIP.							
								Frequency :							
Date : 19/04/2017			Cost Incurred For Making Kaizen :												
Registered By : Rucha Engineers Pvt Ltd Plant 2			Material Cost		Labour Cost		Total								
Manager's Sign : Mr. S G Sohoni			2500.00		250.00		2750.00								
Scope & Plan For Horizontal Deployment :			Equipmnet		Target		Status								
----- Rucha Group - Corporate -----															