

<div></div>	Equipment :	Robotic cell	Loss Type :	Tool change Loss							KAIZEN IDEA SHEET	
	Department :	Press & Fabrication	Result :	N	P	Q	C	D	S	M		
	Cell :	Robotic Welding	Type :									Kaizen ID : 3244
Unit Name : Press and Fab - Quality, Pune			Operation : Welding wire drum change operation.									
Kaizen Theme: To Reduce - Tool change loss (Jumbo Wire durm change loss)			Idea : Parallel activity									
Problem / Present Status		Counter Measure			Benchmark :		20 min/occ					
More time i.e 20 min/occurrence required to change wire spool.		To provide reed switch with magnet to indicate spool going to be empty before 30 min, so that material handling person can bring drum in adv. on stage			Target :		05 min/occ					
<div></div>		<div></div>			Start :		04/10/2017		Finished :		15/10/2017	
					Note :							
					Team Members :							
					1. Mr. Omkar Patinge					2. Mr. M C Kulkarni		
					3. Mr. A S Satpute					4.		
					5.					6.		
					Benefits							
D		Tool change time / occurrence reduced. Minutes 5.00										
Why Why Analysis :		Result :			Kaizen Sustenance :							
W1 : Why More tool change time ?		<div></div>			What To Do : Interlock monitoring.							
A1 : Wire drum change time more (20 min/Occurrence)					How To Do : Pokayoke audit							
W2 : Why Wire drum change time more (20 min/Occurrence) ?					Frequency : Daily.							
A2 : More time take to replace drum					Cost Incurred For Making Kaizen :							
W3 : Why More time take to replace drum ?												
A3 : No prior intimation about wire drum comes to end.												
W4 : Why No prior intimation about wire drum comes to end. ?												
A4 : No system which tells about end of wire prior to its end.												
Root Cause												
No system which tells about end of wire prior to its end.												
Date : 05/12/2017												
Registered By : Mr Omkar Patinge												
Manager's Sign :												
----- BAL Prass and Fab Team -----												