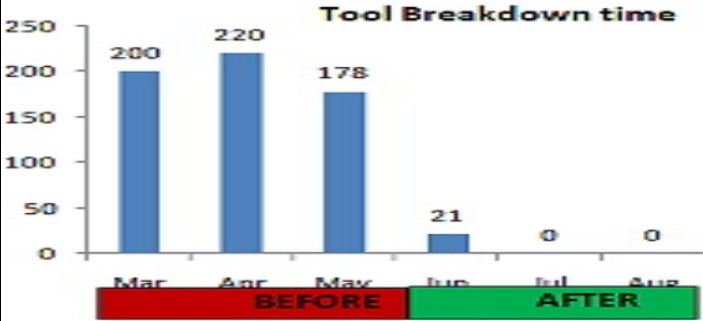
	Equipment :	Progressive stamping	Loss Type :	Defect Loss							KAIZEN IDEA SHEET
	Department	Production	Result :	N	P	Q	C	D	S	M	
			Type :								
Cell : Stamping			Operation : Stamping (EGR Header)								
Kaizen Theme: Productivity improvement			Idea : Reduce the tool breakdown time								
Problem / Present Status		Counter Measure		Benchmark :		200 mins time loss per month					
Productivity losses due to frequently tool breakdown time occurs due to EGR Header punch broken issue.		All piercing punches radius increased & Maintain min. 0.5 to 0.7		Target :		14.6.2013					
				Start :		02/06/2013		Finished :		20/06/2013	
				Note :							
				Team Members :							
				1. Rathnakumar				2. Nitin P			
				3. Santosh J				4. Gurunath			
				5. Guru				6. Abdulla			
				Benefits							
				P		Tool downtime due to punch broken issue reduced Rs 0.00					
Why Why Analysis :		Result :		Kaizen Sustenance :							
W1 : Why Productivity loss higher from last three month ? A1 : Tool breakdown time was increased		Tool downtime reduced from 200 mins to 0 mins.		What To Do : Punch Radius to be added in punch drawing							
W2 : Why Tool breakdown time was increased ? A2 : EGR Header progressive tool piercing punches broken frequently				How To Do : Initially							
W3 : Why EGR Header progressive tool piercing punches broken frequently ? A3 : Proper strength & support not maintain in tool to the piercing punches				Frequency : Once							
W4 : Why Proper strength & support not maintain in tool to the piercing punches ? A4 :				Cost Incurred For Making Kaizen :							
Root Cause Piercing punches radius was maintain only 0.15											
Date : 02/06/2013											
Registered By : TREND TECHNOLOGIES INDIA PUNE PVT LTD											
Manager's Sign :											

