2012	Equipment :	Progressive stamping	Loss Type :	Defect	Loss										
	Department	Production		Result :	N	Р	Q	С	D	S	М	KAIZEN IDEA SHEET			
				Type :								1			
Cell: Stamping					Ope	ration :	St	Stamping (EGR Header)							
Kaizen Theme: Produ	ctivity improvement			Idea :	Red	uce the	tool b	reakdown	time						
Problem / Present Status			Counter Measure					Benchmark :			200	200 mins time loss per month			
Productivity losses due to frequently tool breakdown time occures due to EGR Header punch broken issue.			All piercing punches radius increased & Maintain min. 0.5 to 0.7					Target :			14.	14.6.2013			
								<b>Start</b> : 02/06/2013		3	Finished: 20/06/2013				
					100	90 d	1	Note :				•	<u> </u>		
	R		R0.5				Team Members :								
		0.15	NO.5					1. Rathnakumar				2. Nitin P	2. Nitin P		
		(	0				3. Santosh J				4. Gurunath				
							5. Guru				6. Abdulla	6. Abdulla			
	Santa Santa							Benefits							
4								P Tool downtime due to punch broken issue reduced Rs 0.00							
Why Why Analysis : Result :							-6	Kaizen Sustenance :							
W1 : Why Productivity loss higher from last three month  Tool downtime reduced from 200 mins							What To Do: Punch Radius to be added in punch drawing								
?															
A1 : Tool breakdown time v	vas increased							How To E	Do : Ini	tially					
W2 : Why Tool breakdown	time was increased		250 200 200 178 150 -						, , , , , , , , , , , , , , , , , , , ,						
?															
A2 : EGR Header progress	ive tool piercing pur	nches broken frequently							Frequency : Once						
W3 : Why EGR Header pro	gressive tool piercir	ng punches broken frequently	100 -		Cost Incurred For Making Kaizen :										
? A3 : Proper strength & support not maintain in tool to the piercing punches			50 -	21				Ma	terial (	Cost		Labour Cost	Total		
			0		0	0	_		0.00			5000.00	5000.00		
W4 : Why Proper strength & support not maintain in tool to the piercing					AFTE	ER		Scope & Plan For Horizontal Deployment :							
punches						Equipmnet					Target Status				
? A4:		Result:  three month  Tool downtime reduced from 200 mins to 0 mins.  What To Do: Punch Radius to be added in punch drawing  How To Do: Initially  Frequency: Once  Cost Incurred For Making Kaizen:  Material Cost Labour Cost Total  0.00 5000.00 5000.00  Scope & Plan For Horizontal Deployment:  Equipmnet Target Status													
Root Cause															
Piercing punches radius wa	as maintain only 0.1	5													
Date : 02/06/	2012		.												
		S INDIA PUNE PVT LTD													
Manager's Sign :	2 . 20 10200120	JJIIII ONE I VI LID	•												

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