

Process	Process Stage	Process Elements	Items	Waste in form of	Classifn. of Waste Type:1/2
Shearing	Input	Raw Materials	CRCA Sheets		
		Consumables			
		Utilities	Electricity	Energy & Water	Type 1 Waste
		Information			
	Process	Equipment	Shearing Machine	Waiting	Type 1 Waste
		Facilities			
		Systems			
		People	Shearing Operators	Untapped Human Potential	Type 2 Waste
			Inprocess Inspection	Untapped Human Potential	Type 2 Waste
	Output	Products	Blanks		
		Defectives	Taper shearing Incorrect shearing size Heavy Burr	Defects	Type 2 Waste
		Bye-products	Shearing Scrap	Material	
		Information	Inspection reports	Material	Unavoidable
		Customer Satsfn.	NA		
Punching	Input	Raw Materials		Defects	
		Consumables			
		Utilities			
		Information			
	Process	Equipment	Inprocess Inspection via measurement	Waiting	Type 1 Waste
		Facilities			
		Systems			
		People	Quality Inspector	Untapped Human Potential	Type 1 Waste
	Output	Products			
		Defectives	Rejected blanks due to tickli Wrong side punching Wrong hole punching	Defects	Type 2 Waste
		Bye-products			
		Information			
		Customer Satsfn.			
CNC Punching	Input	Raw Materials		Defects	
		Consumables			
		Utilities			
		Information			
	Process	Equipment	Inprocess Inspection via measurement	Waiting	Type 1 Waste
		Facilities			
		Systems			
		People	Quality Inspector	Untapped Human Potential	Type 1 Waste
	Output	Products			

		Defectives	Rejected blanks due to tickli Wrong side punching Wrong hole punching	Defects	
		Bye-products			
		Information			
		Customer Satsfn.			
Transport to NPT	Input	Raw Materials			
		Consumables			
		Utilities			
		Information			
	Process	Equipment			
		Facilities			
		Systems			
		People	Counting of Material at both ends	Unwanted Processing	Type 1 Waste
	Output		Loading into vehicle wihtout palette or trolley	Unnecessary Motions	Type 2 Waste
		Products			
		Defectives			
		Bye-products			
		Information			
		Customer Satsfn.			

Description	Quantity	Unit Cost	Cost	Annual Cost Impact	Industry Benchmark	Target	Waste Reduction
	56,700						
Waiting time of other products to be sheared							
Man hours in shearing width wise and handling big sheets				4,67,664			
100% Inspection of sheared blanks			4000	48,000			
Rejected CRCA blanks	1%	28	15,876	1,90,512			
Strips / blanks	10% = 5.6 tons			22,04,496	3%	5%	2.5 tons
Paper used for insepection							
rejected blanks of doors or boxes							
Production held due to OK signal from inspection	4 hours per day	Rs. 1000 per day	Rs. 500 per day	1,37,500		1 hour per day	1,03,125
Measurements to be taken on blanks from hard tooling	2 people @ 50% time	12000 / month	12000 per month	1,44,000			1,08,000
Tickli marks on blank due to flaring							
rejected blanks of doors or boxes							
Production held due to OK signal from inspection	4 hours per day	Rs. 1000 per day	Rs. 500 per day	1,37,500		1 hour per day	1,03,125
Measurements to be taken on blanks from hard tooling	2 people @ 50% time	12000 / month	12000 per month	1,44,000			1,08,000

[illegible]

21,16,42€

Rank	Expected Reduction in Cost	Action Item
2	4,67,664	CTL & Coil development
1	48,000	
3	11,78,512	CTL & Coil development
	1,03,125	Checking Templates
	1,08,000	Checking Templates
	1,03,125	Checking Templates
	1,08,000	Checking Templates

		Job Route cards and proper counting at operation stage
		Use of dedicated pallettes from Press Shop to Bending shop