RECP Best Practices Catalogue

Reliability of the sheet metal supply on the lines of the printing workshop

Developed within the framework of MED TEST II

UNITED NATIONS
INDUSTRIAL DEVELOPMENT ORGANIZATION

switchmed

The SwitchMed Programme is funded by the European Union

Best Practice - Reliability of the sheet metal supply on the lines of the printing workshop

SECTOR:	**Metal, electrical and motor vehicle parts**
SUBSECTOR:	Manufacture of other fabricated metal products
PRODUCTS	Metal packaging, printing on metal, plastic bottles, tin cans, frustoconical pails, cylindrical boxes, rectangular bottles.
CATEGORY	Good Housekeeping
APPLICABILITY	Process

COMPANY SIZE	120

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Description of the Problem (Base Scenario):	Waiting for a driver to arrange the loads is too long, "The priority" is about the production. Similarly the positioning of the pallets with its loads will have to be made reliable, for the driver and on the machine; any wait is detrimental to the productivity of the printing lines and the quality of the product. In addition, the loads are frequently damaged by bad handling, or too much movement, as well as the improper load positioning at the machine feeding stage, and the stray fork blows that damage them.
Description of the Solution	The line operator must regularly check the availability of the sheet stock on the printing line in order to avoid the stoppages noted during the diagnosis. Review drivers' priorities -> put the machines in priority so as not to Interrupt the line. Kaizens are planned to shorten the distances travelled by the loads, and the risks of defects caused by fork blows and bad loading. Moreover the forks themselves will be modified to reduce their length and shape. Plan subsequently an automated feed system for continuous production, with pallet change in hidden time.

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Economic Gain	Productivity gains on 38 loads/day, which is a savings of 3 to 5 minutes per load Which is about 2 hours minimum/day of productivity A potential gain of optimised machine opening time of 600 hours x € 11.25 = € 6,750 Savings on the sheets saved by a good machine feed and a neat transport = € 22,545
Environmental Gain	Waste: 2 to 5 sheets/load x 38 loads/day x 300 days/year x 1 kg/sheet = 57 tons/year maximum
Health and Safety Impact	None

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Investment and Financial Indicators	No investment costs Maintenance time and supplies for automation (Time for Return on Investment: Immediate)
Suppliers	Internally by the engineering department
Other aspects	Limitation of failed sheets during stamping Gains in quality
Implementation and New Indicator	Planned before the end of 2018