5S of a Turret Punch Press

Turret punch presses are often a focal point in a precision metal fabricating shop, which is one reason why it is so important to keep them and the areas around them organized and standardized. The turret press is like the eight-lane highway of the manufacturing plant: it gets a lot of use by a lot of different parties, so there’s a lot of havoc that can occur if rules don’t get applied and followed.

**High Traffic, High Variety, High Change = High Need for 5S**

Areas that get particularly high use by multiple parties are especially good candidates for 5S.

5S is a set of organizing principles that is a major factor in Lean philosophy. For a beginners' outline of 5S, take a look at our previous article on the topic.

There are a number of changes that take place at the turret punch press each day, with the changeover of operators and jobs run:

- Tools need to be changed
- Raw material needs to be changed
- The program needs to be changed

This causes a number of unanswered questions to occur with each new operator or job:

- What tools are in the machine?
- What is the condition of the tools in the machine?
- Where are the tools that are needed for the next job?
- Where are the hand tools needed for setup?
- What is the condition of the machine?
  - Station alignment?
  - Maintenance required?

**5S Dramatically Improves Success of the Turret Work Center**

By applying 5S to your turret punch press work center, you will quickly see a huge impact in that area in a number of ways:

- Reduced setup times
Wilson Tool | 5S of a Turret Punch Press

- Improved part quality
- Improved tool life
- Heightened morale of everyone that works in the area

The following images show workspaces that have not applied 5S.

Tooling and hand tools are scattered across surfaces, there is no indication of what’s loaded in the machine or how it’s programmed or where key tooling is located. Arriving at this location to start your shift would be like coming home to find that your house had been broken into. You wouldn’t know where things were, if everything was still there, and what state anything was in. The operator would need to waste substantial time tracking down tools, determining the state of the tooling and the machine. He may also feel significantly overwhelmed and ticked off.

The following images are of turret punch press areas that have been 5S’d.
Wilson Tool | 5S of a Turret Punch Press
• Hand tools are easily available
• The current turret setup is displayed
• Tooling needed for the next job is available and has been setup correctly, with:
  ◦ Sharpening
  ◦ Adjustment
  ◦ Shimmed, if necessary
  ◦ The layout of the tools on the cart matches the turret layout
  ◦ An empty cart is available to hold standard tools that must be removed from the turret

An operator arriving at one of these work centers wouldn’t have to dig himself out of a mess in order to begin running parts. He would be able to start his first job with clarity of purpose and ease.

We’ll be covering “5S of a Turret Punch Press” in our next webinar on April 27th at 1pm Central Time, so if you found this article helpful, there will be a more thorough discussion of the topic online. Otherwise, simply contact your local Wilson Tool sales engineer, or our turret sales desk at salesdesk@wilsontool.com for more assistance with tips for making your organization more productive with 5S.