

Plant : P14

TPM CIRCLE NO :-	1	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET
TPM CIRCLE NAME :		LOSS NO./STEP									
DEPT :	Production	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M	
CELL :	A351 /A611/ A479	CELL NAME :	Drum Gear Shifter		M/C STAGE:	Mazak , LMW			OPERATION:	#Op 20 & 30 Facing & Turning	

KAIZEN THEME :

KAIZEN IDEA :

To reduce Cost per component in DGS Machining stage.

Trial to be conducted to any other make which is less in cost.

BENCHMARK:	INR 0.25/-
TARGET:	INR 0.19/-
KAIZEN START:	01.08.18
TARGET DATE:	31.08.18
KAIZEN FINISH:	31.08.18
TEAM MEMBERS:	
Mr. Praveen Jannu	Mr. Rajasekar
Mr. Manas Dey	
BENEFITS:-	
Annual saving of INR 22759/- for the current year 18-19	

PROBLEM PRESENT STATUS :

COUNTERMEASURE:

Present tooling cost per component of VNMG 160404 insert is INR 0.25/-

Changed make from Sancotech to Mitsubishi , & changed supplier from Raj Corporation Pune to Ascent Engineering Bangalore & reduced Tooling Cost per component from INR 0.25 /- to 0.19/- .

KAIZEN SUSTAINANCE				
WHAT TO DO: Revised the master tooling list				
HOW TO DO: -----				
FREQUENCY: One time activity				
SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO.	CELL/ PRODUCT	TDC	RESP.	STATUS
1	A479	31.08.18	Prod	Close
2	A611	31.08.18	Prod	Close

WHY-WHY ANALYSIS:

BEFORE

AFTER

Why1:- Present tooling cost per component of VNMG 160404 insert is INR 0.25/-
Why2:- Present VNMG 160404 insert cost is high.
Why3:- Sancotech make insert.

Raj Corporation Pune
 Make – Sancotech
 Insert cost – INR 395/-
 CPC –INR 0.25/-

Ascent Engineering
 Bangalore
 Make – Mitsubishi
 Insert cost – INR 300/-
 CPC –INR 0.19/-

ROOT CAUSE

RESULTS:

Sancotech make insert.

Tooling Cost per component reduced from INR 0.25/- to 0.19/-

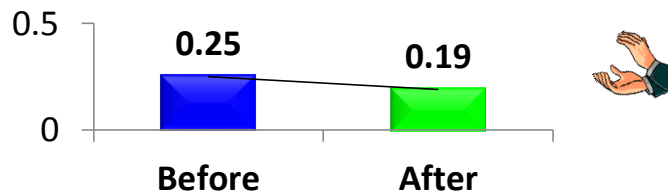
REGISTRATION NO.:

DATE:

REGISTERED BY:

MANAGER SIGN:

Mr. Manas Kumar Dey



HD SCOPE INFORMATION IN OTHER PLANT

SR.NO.	PLANT	WHEN	WHOM	STATUS
1	All	31.8.18	Prod	Open