## **COST IMPROVEMENTS**

ADVIK	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	KAIZE	N IDEA	QUEET	
ADVIK	TPM Circle Name:	Loss no.	~				0 X				NAIZE	NIDEA	SHEEL	
Plant-1		Step									F	aizen No		
Chakan	Dept.: Machine Shop	Result Area	Р	Q-Def. A / B /C		B/C	C	D	S	M				
Cell No.: A22		Process / Stage : FRD-1									<b>Operation : Machining</b>			
Kaizen Theme		Idea : Use S/C	Reamer	Instead	of Inse	rt.								
To Reduce To	ool Cost.													
		Counter Meas	ure: New	S/C Re	amer D	esign Fo	or A225 E	lody Sı	iction H	Iole & De	livery Hole	•.		
Problem / Pre	sent Status:	Before : A225 body For Suction Hole & Delivery Hole							Bench	Mark	· · · · · · · · · · · · · · · · · · ·			
I.For A225 Be	ody Suction Hole Machining Tool cost	Machining Insert Type Boring Bar Using.							Targe	t	\ \	(	0	
per Component is 0.29 paisa.		C = [et al. (et						_	Kaize	n Start	5	3-Ma	ay-14	
									Kaizer	n Finish		15-Ju	un-14	
		Protection     Bit D = 7     <						Team Members With Sign :						
								1. Umesh Pimple. 2. Ritesh Bhole.						
		Number     International     State							3. Ajay Bhor					
									S.Ajay Duor					
									Benefits:					
		g 😰 🔳 💽 🎬		-	2			ALC: NO.	Р					
Why Why An:	alysis :	After :							Q					
		1) New S/C Reamer Design For A225 Body Suction Hole							С	Tool Cost	ost Reduced.			
	225 Body Suction Hole Machining	& Delivery Hole.							D					
Tool cost per Component is		2) Cutting Parameter Increase (S - 4770 F - 0.20).							1000					
Why 2: Less Cutting Force Used.(S3000 , F0.1) Why 3:Insert CCMT 09T304 Using For Machining		IP (a) (b) (b) (b)   IP → (b) (b) (b) (b) (b)							S					
									M		8			
									Kaizen Sustenance :					
									What to do : Use Only New S/C Reamer.					
									How to do : Tool Life Monitoring.					
									How to do : 1001 Life Monitoring.					
Root Cause :	Insert CCMT 09T304 Using For	Result :1) Too	Cost Re	duced b	y0.29 p	aisa. To	0.076 pai	isa	1					
Machining.		2)Cost Saved	Year 104	40 Rs to	2736 H	Rs								
		Cost Saving per year in Rs							Scope & Plan for Horizontal Deployment					
									Sr.	Target Responsi				
Registration 1	ao.& dt : :15/06/14	20000							no.	Model	Date	bility	Status	
Sector Sector	: Umesh Pimple		10440	-	2736		Cost/Rs			11				
	gn : Surendra Kulkarni	1	Before		After				_		_	_	_	
annager 3 DI	Sa . Sarchara Isansaran							-	1	2		1		