

CELL :-      CELL NAME:-A316      MACHINE / STAGE :-Incoming      OPERATION :-A316 Rotors

**KAIZEN THEME :-**  
To Reduce the Inward freight cost

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS:-**

More freight cost found in A316 Knock Form GKN supply due to less lot size weight was very less

Total yearly Inward freight cost (Rs.) as per lot size of 5000 nos from GKN Nagar

119058 Rs.

**BEFORE**

**IDEA :-** Change the lot size`

**COUNTERMEASURE:-**we changed the lot size of A316 Knock from 5K to 10K )

Inward freight cost is controlled we saved 250 Rs. In per lot supply  
Total 59029 Rs. Annual saving in Inward Freight cost

Total yearly Inward freight cost (Rs.) as per lot size of 59029 nos from GKN Nagar

59029 Rs.

**AFTER**

**WHY - WHY ANALYSIS :-**

**WHY 1:-** more Inward freight cost found In A316 Knock supply from GKN side

**WHY 2:-** more delivery charges

**ANS :-** more delivery charges because lot size weight is very less

**ROOT CAUSE :-**

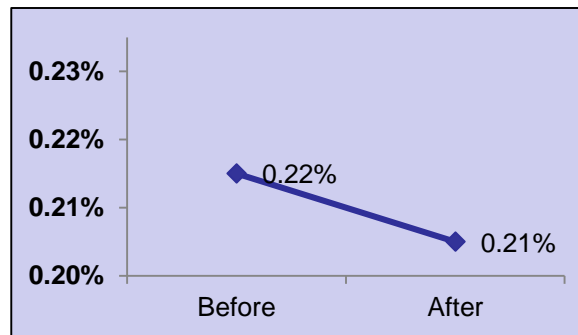
**Lot size**

**REGISTRATION NO&DATE:**

**REGISTERED BY :-**

**MANAGER'S SIGN :-**

**RESULT** Freight Cost 0.01% yearly down



<b>BENCHMARK</b>	0.22 % of sale
<b>TARGET</b>	0.21 % of sale
<b>KAIZEN START</b>	1.03.16
<b>KAIZEN FINISH</b>	10.03.16

**TEAM MEMBERS :-**

Jay Sharma , Dheeraj

**BENEFITS :-**

1. Inward freight cost reduced

**KAIZEN SUSTENANCE**

**WHAT TO DO :-** lot size changed

**HOW TO DO :-**Monitoring

**FREQUENCY :-** daily

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST RS.	LABOUR COST RS.	TOTAL COST RS.

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1				