
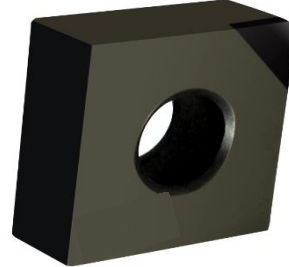
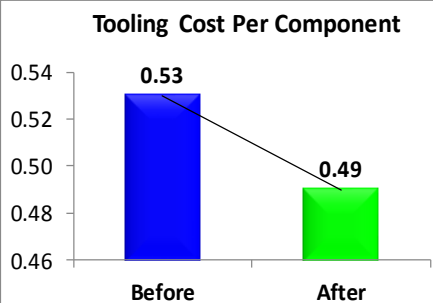
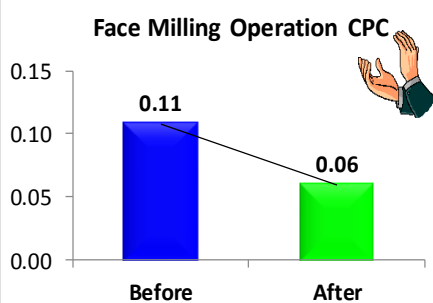


AD  IK		TPM CIRCLE NO :-	2	ACTIVITY	KK	QM	PM	JH	SHE	OTPM	DM	E & T	KAIZEN IDEA SHEET	
		TPM CIRCLE NAME :-	Joshile	LOSS NO./STEP										
Plant : P14		DEPT :	Manufacturing Engineering	RESULT AREA	C	Q	P	P, C	S	M, D	P, C	M		
CELL : A315		CELL NAME :	Oil Pump	MACHINE STAGE:	VMC/Machining				OPERATION:	Face Milling Reaming & Back facing				
KAIZEN THEME :		KAIZEN IDEA :												
To Reduce Cost per component of A315 Oil Pump Body @ Machining Stage .		Make to be replaced from Rudali to KHK diamond							BENCHMARK:	INR 0.53/-				
									TARGET:	INR 0.49/-				
									KAIZEN START:	12.01.2018				
PROBLEM PRESENT STATUS :		COUNTERMEASURE:							TARGET DATE:	Apr-18				
Present Tooling Cost Per Component is INR 0.53/-		Changed insert Make from Rudrali to KHK Diamond							KAIZEN FINISH:	21.02.2018				
									TEAM MEMBERS:					
									Mr.Mallikarjun		Mr.Praveen Jannu			
									BENEFITS:-					
									1) Reduce tooling CPC from INR 0.53/- to INR 0.49/- 2) Cost saving is INR 51608/- annum					
WHY-WHY ANALYSIS:		BEFORE			AFTER			KAIZEN SUSTAINANCE						
WHY - WHY ANALYSIS :-		Insert Make : Rudrali Cutting Tools			Insert Make : KHK Diamod			WHAT TO DO: Revise the Cutting tool Master list & Process control plan						
Why1: Present Tooling Cost Per Component is INR 0.53/-								HOW TO DO:---						
Why2: Facing Milling CPC is INR 0.11/-														
Why3: Present Face Milling Operation CPC is High														
Why4: Rudrali Make Insert														
ROOT CAUSE:-		RESULTS:							SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT					
Rudrali Make Insert		<b>Tooling Cost Per Component</b> 			<b>Face Milling Operation CPC</b> 				SR.NO.	CELL/PRODUCT	TDC	RESP.	STATUS	
REGISTRATION NO.: P14/KK/2018/021									1	All Oil Pump	May-18	Pujari.NS	Inprocess	
DATE:									HD SCOPE INFORMATION IN OTHER PLANT					
REGISTERED BY:									SR.NO.	PLANT	WHEN	WHOM	STATUS	
MANGERS SIGN:									1	P3&P9	03.03.18	Ajay/Snehal	Open	
AHPL/QMS/FR/09/E, Rev. No.:03, Rev. Date:23.01.2018									2	P15	"	"	Open	