

TPM CIRCLE NO: 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME: Joshile	LOSS NO. / STEP								
DEPT: Manufacturing Engineering	RESULT AREA	P	Q	DEF:-A		C	D	S	M

# KAIZEN IDEA SHEET

F/IMS/05

CELL: A467    CELL NAME: Tensioner Body    MACHINE / STAGE: CNC/Machining    OPERATION: Facing ,ID boring & Grooving

**KAIZEN THEME:** To Reduce the Cost per component of A467 Tensioner Body

**WIDELY/DEEPLY:**

**PRESENT STATUS :** Present Tooling Cost Per Component is INR 0.63/-

1) Insert Discription : CCGT 09T304  
 2) No of Insert / Holder : 01 Nos  
 3) Total insert Life : 4000 Nos  
 4) Unit Price : INR 277/-  
 5) CPC : INR 0.07/-  
 6) Make : Sacnotech

**BEFORE**

**IDEA:** Insert grade to be replace with Carbide to PCD

**COUNTERMEASURE :** Changed insert grade from Carbide to PDC & Now CPC is INR 0.60/-

1) Insert Discription : CCGT 09T304  
 2) No of Insert / Holder : 01 Nos  
 3) Total insert Life : 20000 Nos  
 4) Unit Price : INR 800/-  
 5) CPC : INR 0.04/-  
 6) Make : KHK Diamond

**AFTER**

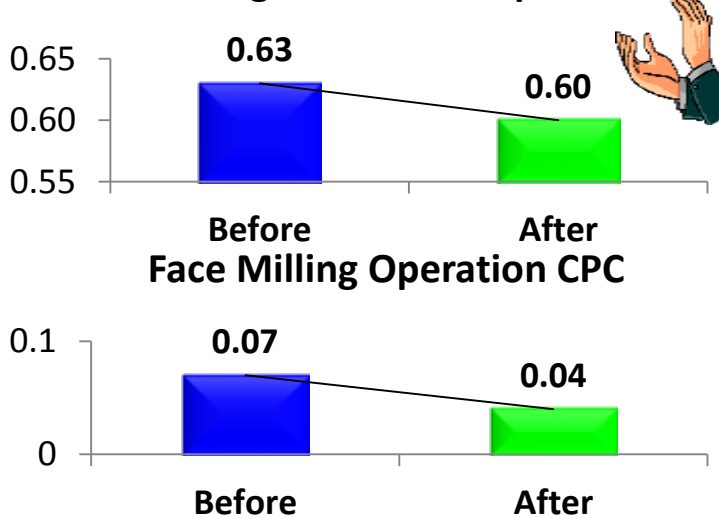
<b>BENCHMARK</b>	INR 0.63/-
<b>TARGET</b>	INR 0.60/-
<b>KAIZEN START</b>	26.05.2017
<b>KAIZEN FINISH</b>	23.06.2017

**TEAM MEMBERS:**  
 N.S.Pujari,  
 Mr. Praveen Jannu, Mr. Prabhakar

**BENEFITS:**  
 1) Cost Saving in INR 18842 /- Annum.  
 2) Tool Changing time saved 1160 min /annum

**WHY - WHY ANALYSIS :-**  
**Why1:** Present Tooling Cost Per Component is INR 0.63/-  
**Why2:** Facing operation CPC is INR 0.07/-  
**Why3:** Present Face Milling Operation ICPC is High  
**Why4:** Insert life was less  
**Why4:** Carbide Insert

**RESULT:- Tooling Cost Per Component**



**ROOT CAUSE:-** Carbide Insert

**KAIZEN SUSTENANCE**

**WHAT TO DO :** Revise the Cutting tool Master List & PCP .  
**HOW TO DO :** ----  
**FREQUENCY :** 1 Time activity

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESP.	STATUS
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**REGISTRATION NO. & DATE:** 1701 & 28.02.2017

**REGISTERED BY:** Mr. Guru Bassappa

**MANAGER'S SIGN:** Mr. N.S.Pujari