

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

### KAIZEN IDEA SHEET

F/IMS/05

**CELL:** A315 | **CELL NAME:** Oil Pump Body | **MACHINE / STAGE:** VMC/Machining | **OPERATION:** Facing ,Reaming & Back Facing

**KAIZEN THEME:** To Reduce the Cost per component of A315 Oil Pump Body.

**WIDELY/DEEPLY:**

**PRESENT STATUS :** Present Tooling Cost Per Component is INR 0.59/-

- 1) Insert Discription : SNEW 09T3 ADFR3
- 2) No of Insert / Cutter : 06 Nos
- 3) Total insert Life : 87500 Nos
- 4) Unit Price (6\*2390) : INR 14340/-
- 5) CPC : INR 0.16/-
- 6) Make : Jungsan Diamond

**BEFORE**

**IDEA:** Make to be replace Jungsan Diamond to Rudrali.

**COUNTERMEASURE :** :- To Change the insert make Jungsan Diamond to Rudrali & Now Cost per component is INR 0.53/-.

- 1) Insert Discription : SNEW 09T3 ADFR3
- 2) No of Insert / Cutter : 06 Nos
- 3) Total insert Life : 100000 Nos
- 4) Unit Price (6\*1800) : INR 10800/-
- 5) CPC : INR 0.10/-
- 6) Make : Rudrali

**AFTER**

<b>BENCHMARK</b>	INR 0.59/-
<b>TARGET</b>	INR 0.53/-
<b>KAIZEN START</b>	10.01.2017
<b>KAIZEN FINISH</b>	28.02.2017

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

**BENEFITS:**  
1) Cost Saving in INR 55541 /- Annum.

**WHY - WHY ANALYSIS :-**

- Why1:** Present Tooling Cost Per Component is INR 0.59/-
- Why2:** Face milling operation CPC is INR 0.16/-
- Why3:** Present Face Milling Operation Is CPC is High
- Why4:** Jungsan Diamond Make Insert

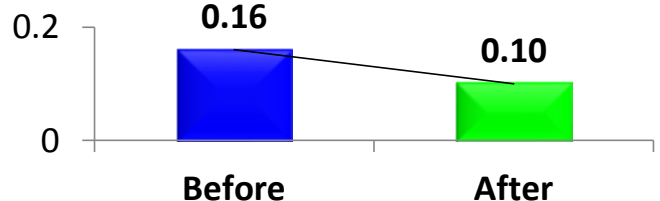
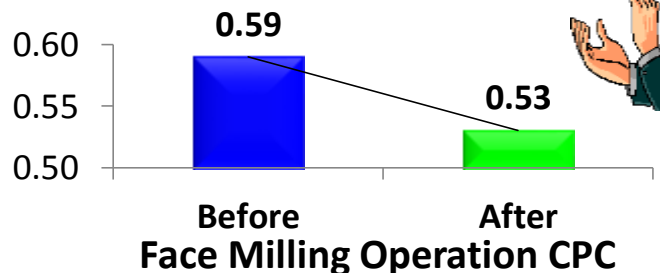
**ROOT CAUSE:-** Jungsan Diamond Make Insert

**REGISTRATION NO. & DATE:** 1502 & 28.02.2017

**REGISTERED BY:** Mr. Guru Bassappa

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

**RESULT:- Tooling Cost Per Component**



**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
1	A177 A271 A337 A478	30.03.17	N.S.Pujari	Open