



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: A128/A157 **CELL NAME:** Tensioner Body **MACHINE / STAGE:** CNC/Machining **OPERATION:** ID Boring

KAIZEN THEME: To Reduce the Tool/Insert Change over Time of A128 Tensioner Body.

WIDELY/DEEPLY:

PRESENT STATUS : Present ID Boring Insert change over time is average 96 min / month .

- ID Boring Insert Description : CCGT060204AK10
- Insert Material : Carbide
- Insert Make : Sancotech
- Insert Life /Corner : 6000 Nos
- No of Corner /Insert : 02 Nos
- Insert Change Over time : 4 Min
- Average Production/Month : 145000 Nos
- Insert Change over time : 96 Min /Month
- CPC (240/(6000*2)) : INR 0.02/-



BEFORE

IDEA: Insert material to be replace with carbide to PCD

COUNTERMEASURE : Insert material replaced with Carbide to PCD & Now ID Boring insert change over time is 10min / Month

- ID Boring Insert Description : CCGT060204
- Insert Material : PCD
- Insert Make : KHK Diamond Tools
- Insert Life /Corner : 60000 Nos
- No of corner/Insert : 01 No
- Insert Change Over time is : 4 Min
- Average Production/Month : 145000 Nos
- Insert Change over time is : 10 Min /Month
- CPC (850/60000) : INR 0.014/-



AFTER

BENCHMARK	96 Min
TARGET	10 Min
KAIZEN START	28.11.2016
KAIZEN FINISH	31.01.2017

TEAM MEMBERS:

N.S.Pujari
Mr. Pradeep

- BENEFITS:**
- Reduce ID Boring Insert Change Change over time from 96 min to 10 min
 - Cost saving is INR 870/- annum
 - Availability increase by reducing Insert Change over time
 - Quality improved (No size variation comp. to comp)

WHY - WHY ANALYSIS :-

- Why1:** Present ID Boring Insert change over time is average 96 min / month .
- Why2:** Number of insert change over occurrence is more.
- Why3:** Insert Life / Corner is Less
- Why4:** Carbide Insert

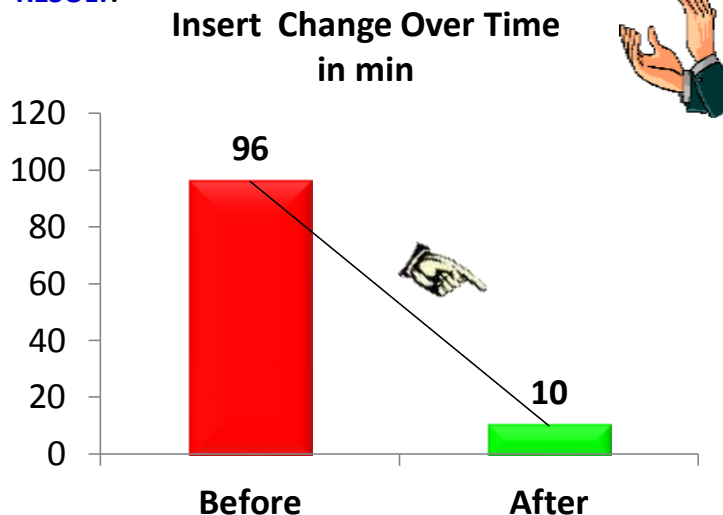
ROOT CAUSE:- Carbide Insert

REGISTRATION NO. & DATE: 1459 & 31.01.2017

REGISTERED BY: Mr. Guru Bassappa

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

RESULT:-



KAIZEN SUSTENANCE

- WHAT TO DO :** Revised PCP & Cutting tool list
- HOW TO DO :** One time action
- FREQUENCY :** irreversible kaizen

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	A467	28.02.2017	N.S.Pujari	Open