

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: A351 CELL NAME: Drum gear Shifter. MACHINE / STAGE: VMC/Machining OPERATION: Facing, Drilling & Tapping

KAIZEN THEME: To Reduce the Tooling others Cost of A351 Drum gear Shifter.

WIDELY/DEEPLY:

PRESENT STATUS : Present Face Mill Cutter cost per piece is INR 15887/-

- 1) Cutter Required/Year : 02 Nos
- 2) Cost Per Cutter : INR 15887/-
- 3) Cost Investment /Year for Face mill Cutter (15887*2) : INR 31774/-
- 4) Make : WNT



BEFORE

IDEA: Make to be replace from WNT to Ceratizit (Manufacturer)

COUNTERMEASURE : Replaced the make from WNT to Ceratizit (Manufacturer) & Now we are taken special offer for every 30 Nos insert , we will get 1 No cutter free of cost.

- 1) Cutter Required/Year : 02 Nos
- 2) Cost Per Cutter : INR 0/- (On 30 Nos Insert)
- 3) Cost Investment /Year for Face Mill Cutter (0*2) : INR 0/-
- 4) Make : Ceratizit



AFTER

BENCHMARK	INR 15887/-
TARGET	INR 0/-
KAIZEN START	01.03.17
KAIZEN FINISH	02.03.17

TEAM MEMBERS:

Mr. N.S.Pujari.
Mr. Pradeep.

BENEFITS:

- 1) Cost Saving in INR 31774 /- Annum.
- 2) Insert cost reduce per piece from INR 800/- to INR 742/-

WHY - WHY ANALYSIS :-

- Why1:** Present Face Mill Cutter cost per piece is INR 15887/-
- Why2:** Cost is more
- Why3:** Cutter Procuring from Dealer .

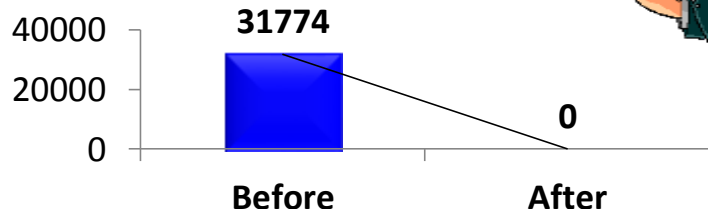
ROOT CAUSE:- Cutter Procuring from Dealer

REGISTRATION NO. & DATE: 1584 & 31.03.2017

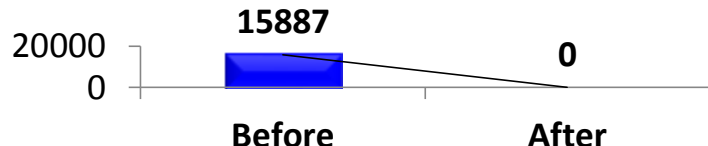
REGISTERED BY: Mr. Nigamananda

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

RESULT:- Face Mill Cutter Cost Saving per Annum



Face Cutter Mill Cost Per Piece



KAIZEN SUSTENANCE

WHAT TO DO : Revise the cutting tool list .
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	A479	30.03.17	N.S.Pujari	Completed