K2														
TPM CIRCLE NO :- 2 TPM CIRCLE NAME : Joshile	ACTIVITY	KK	QM	PM	JH	SHE	ОТ	DM	E&T	12 N 17	ENI INE			
ADVIK P14 TPM CIRCLE NAME : Joshile DEPT :- Manufacturing Eng		P	0	DEF :-	^	С	D	S	М		CIN İVÇ	W OUEE I		
CELL :-A479 CELL NAME:- Drum Change Line	MACHINE / STAGE :- DTC-300									L acing . D	<u>F/IIVI</u> rilling & Ta	S/U5 ppina		
KAIZEN THEME: To prevent the defect of Ø3.0 Hole Over size in A479 DGS (OP#10).	IDEA :- Tool size to be revised Ø3.005 mm to Ø2.97 mm.													
	COUNTERMEASURE:- To Change the tool							BENCHMARK 4%						
WIDELY/DEEPLY:-		specification Ø3.0 05mm Hole mill to Ø2.97 Sc drill.							TARGET         0%           KAIZEN START         15.05.2016					
	& now we are achieving component hole size							KAIZEN START 15.05.2016  KAIZEN FINISH 15.06.2016						
PROBLEM / PRESENT STATUS :- Ø3.0±0.01 mm	Ø3.0mm.							IGHILLIA I HAISH						
hole size is more then specification 0.015mm.								TEAM MEMBERS :-						
	Ø 0.010 A			(ho)				l.S.Puj						
<u></u>	8 p (A)	8 o o o o o o o o o o o o o o o o o o o							Mr. Praveen Jannu. Mr. Chamaraj					
§								BENEFITS :-						
, 8 2 3 4 8								1. Reduce C.T 51 Sec to 49 Sec.						
, , , , , , , , , , , , , , , , , , , ,	45=01							2 . Increase Out Put/Hour 70 Nos to 73						
822	20 =2							Nos						
100	→ 60 ±2	- 60±2							3. Save INR 14072/- cost /Annum.					
60 ±2 L							4	. Save	e (Ø2.	.99 Sc di	ill )Toolin	g Changing		
Ø3.0+0.005 Hole Mill	Ø2.97+0.005 Sc Drill							time 88 min /Year						
BEFOR	E   92.77+0.005 \	AFTER												
WHY - WHY ANALYSIS :-	RESULT :-	RESULT :-						KAIZEN SUSTENANCE						
Why1: Ø3.0±0.01 mm hole size is more then							V	WHAT TO DO: Revised the PCP,CP &						
specification 0.02mm.	Rejecti	Rejection in %						Master list of tooling,						
Why2: Tool size is Ø3.025mm including tool run	_							HOW TO DO:						
out.	5 7							FREQUENCY : Ir-reversible						
Why3: Tool size is Ø3.005 mm.	4	4												
	4 -							COST	INICII	IDDED E		NG KAIZEN		
	3													
ROOT CAUSE :- Tool size is Ø3.005 mm.							IVIA	MATERIAL COST   LABOUR COST   TOTAL COST   IN RS   IN RS						
	2 -	2 -												
	1						<u> </u>	SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT						
REGISTRATION NO. & DATE:1162 &15.06.16	_ 1 -			<b>0</b>			SR	. CE		N FOR HO	ı	BILITY STATUS		
REGISTERED BY :- Guru Basappa	0	ı					¬ NC	).  CE	LL	IAKUEI	KESPUNSI	DILITY STATUS		
MANAGER'S SIGN :- N.S.Pujari	Before			Afte	er		-	-	-	-	-	-		
WATER O STORE - 18.3.1 UJUIT														