

<b>CELL :-</b> A351	<b>CELL NAME:-</b> Drum Gear Shifter	<b>MACHINE / STAGE :-</b> VMC /Machining	<b>OPERATION :-</b> Operation No. 10
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**KAIZEN THEME :** To Reduce the A479 Drum Gear Shifter Machining Fixture Capital Cost.

**IDEA :-** Existing A351 Fixture Locating Pin – 60° need to make replace-able.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Changed the Existing Machining Fixture Design with replaceable Locating Pin concept and provided new Locating Pins for A479 Drum Change 66° , to use same A351 Machining Fixture for A479.

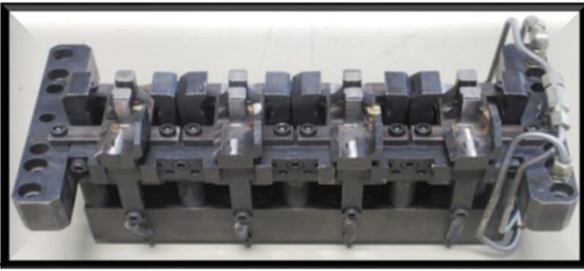
<b>BENCHMARK</b>	INR 280000 /-
<b>TARGET</b>	INR 5600 /-
<b>KAIZEN START</b>	05.03.2016
<b>KAIZEN FINISH</b>	22.03.2016

**PROBLEM / PRESENT STATUS :-** A479 Drum Gera Shifter New Machining Fixture Cost is INR 2,80,000/-

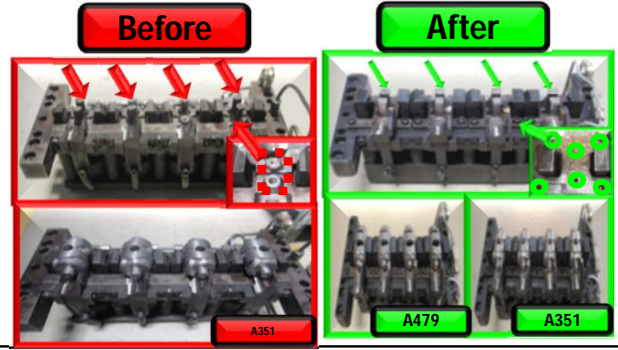
**TEAM MEMBERS :-**  
N.S.Pujari .  
Mr. Praveen

A479 Drum Gear Shifter Machining Fixture

**BENEFITS :-**  
P- Increase availability Time by reduce set-up change over time 400 min Per Occurrence.  
Q- Reduce May Happen Set-up Rejection.  
C1 - Reduce Capital Cost of New Machining Fixture From INR 280000/- To INR 5600 /-  
C2- Machine Cost Per Hour Saved by INR 3000/- Set-up Change Over



**BEFORE**



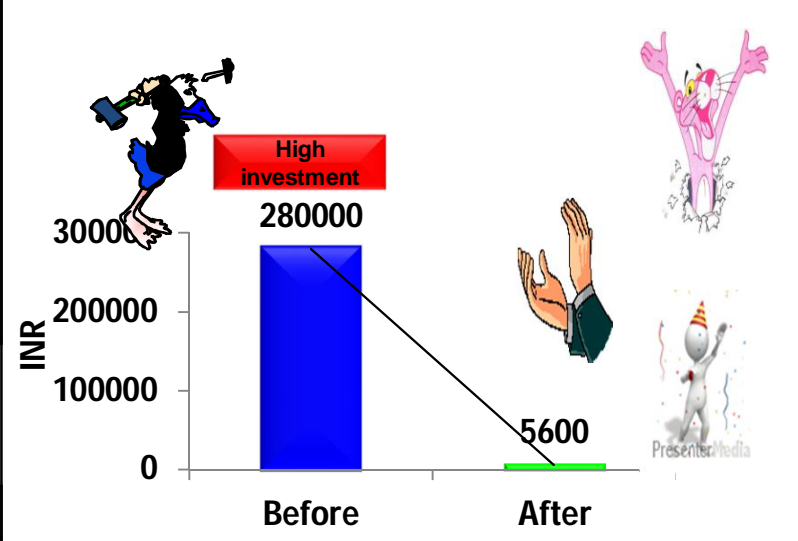
**AFTER**

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**

- Why1 :** New Machining Fixture Required For A479 Drum Gear Shifter.
- Why2 :** Existing available Machining Fixture Was Not Suitable for A479 Drum Gear Shifter Machining.
- Why3 :** A479 & A351 Drum Gear Shifter Component Design Concept is Change. (A351 DGS Location Window Angle Is 60° & A479 DGS Location Window Angle Is 66°)
- Why4:** Existing A351 Fixture Locating Pin – 60° was fixed in existing Fixture.

**RESULT :-**



**ROOT CAUSE :- Existing A351 Fixture Locating Pin – 60° was fixed in existing Fixture.**

**WHAT TO DO: ---**  
**HOW TO DO: ---**  
**FREQUENCY : Irreversible kaizen.**

**REGISTRATION NO. & DATE: #1118, 30.04.16**

COST INCURRED FOR MAKING KAIZEN		
<b>MATERIAL COST</b>	<b>LABOUR COST</b>	<b>TOTAL COST</b>
IN RS	IN RS	IN RS
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**REGISTERED BY :- N.S Pujari**

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO	CELL	TARGET	RESPONSIBILITY	STATUS
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**MANAGER'S SIGN :- N.S.Pujari**