

CELL :-A157/A128    CELL NAME:- Tensioner Line

MACHINE / STAGE :- CNC / Machining

OPERATION :- Operation No. 10

**KAIZEN THEME :** To Reduce the Tooling Cost Per Component in A157 Tensioner Cell.

**IDEA :-** Insert Make to be change.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Insert make changed, present we are using CCGT 060204 Ceratizit Make in OP 10 for Dia 11 mm ID boring operation. Present Cost Per Component is 0.17 / Component

**PROBLEM / PRESENT STATUS :-** Present we are using CCGT 060204 Korloy Make in OP 10 for Dia 11 mm ID Boring operation. Present Cost Per Component is 0.18 / Component

Insert Description : CCGT 060204  
 Make : Korloy  
 Insert Life : 12000 no's/ Insert  
 Insert Cost Per Comp. In INR : 0.023

Insert Description : CCGT 060204  
 Make : Ceratizit  
 Insert Life : 40000 no's/ Insert  
 Insert Cost Per Comp. In INR : 0.007

<b>BENCHMARK</b>	0.18INR
<b>TARGET</b>	0.17 INR
<b>KAIZEN START</b>	08.04.15
<b>KAIZEN FINISH</b>	30.04.15

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

- BENEFITS :-**
1. Save INR 24523 cost /Annum.
  2. Save Insert changing time 715 min/Annum.

**KAIZEN SUSTENANCE**

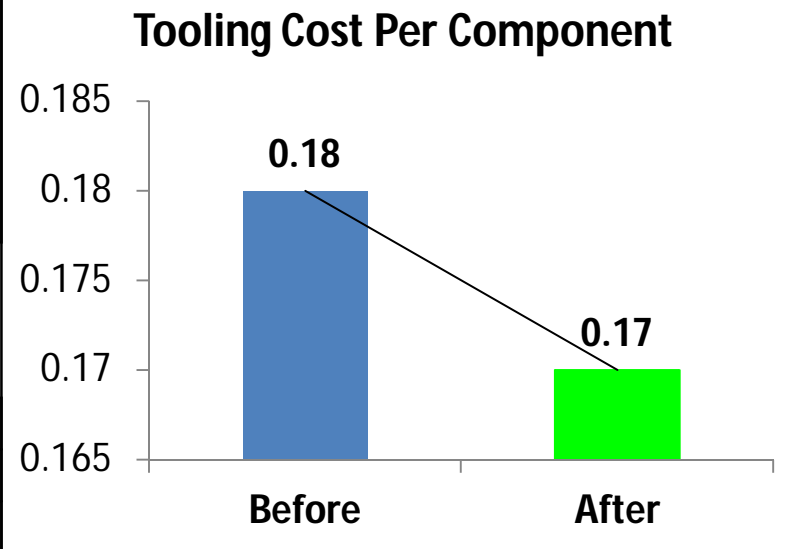
**WHAT TO DO:** Changed the Insert Life in PCP & Tooling Master List.  
**HOW TO DO:**-----  
**FREQUENCY :** 1 Time activity

BEFORE

AFTER

**WHY - WHY ANALYSIS :-**  
**Why1:** Tooling Cost Per Component is INR 0.18.  
**Why 2:-** Ø11.0 ID Boring insert life is less

**RESULT :-**



**ROOT CAUSE :-** Ø11.0 ID Boring insert life is less

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**REGISTRATION NO. & DATE:** 848 & 25.09.15

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

**REGISTERED BY :-** Guru Basappa

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	-----	-----	-----	-----.

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