



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 Change MACHINE / STAGE: VMC/Machining OPERATION: Operation No. 20 & 30

KAIZEN THEME: To Reduce the Tooling Cost Per Component in A351 Drum Gear Shifter.

WIDELY/DEEPLY:

PRESENT STATUS : Present Cost Per Component is INR 1.72/-

- 1) No of Corner / Insert : 4 Nos
- 2) No Insert Required/ Cutter : 1 Nos
- 3) Life / Tool (=700*4) : 2800 nos.
- 4) Unit Price : INR 375/-
- 5) CPC of Facing Operation (=375/2800) Is : INR 0.14 /-



KYOCERA MAKE

BEFORE

IDEA: INS VNMG 160404 more life.

COUNTERMEASURE : To Change the Insert make Kyocera to Sancotech & CPC is INR 1.70/-

- 1) No of Corner / Insert : 4 Nos
- 2) No Insert Required/ Cutter : 1 Nos
- 3) Life / Tool (=800*4) : 3200 nos.
- 4) Unit Price : INR 395/-
- 5) CPC of Facing Operation (=390/3200) Is : INR 0.13 /-



SANCOTECH

AFTER

BENCHMARK	INR 1.72
TARGET	INR 1.70
KAIZEN START	24.06.16
KAIZEN FINISH	02.07.16

TEAM MEMBERS:

N.S.Pujari
Praveen Jannu, Pradeep Kini

BENEFITS:

Save INR 10800 cost /Annum.

WHY - WHY ANALYSIS :-

- Why1:** Present Cost Per Component is INR 1.72/-
- Why2:** INS VNMG 160404 CPC is INR 0.14/-
- Why3 :** INS VNMG 160404 less life.

ROOT CAUSE:- INS VNMG 160404 less life.

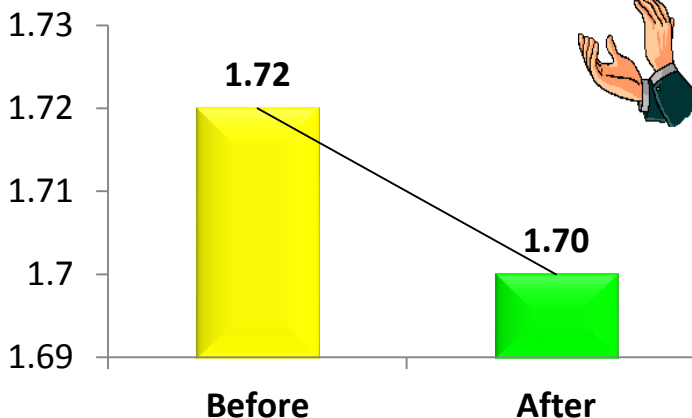
REG. NO. & DATE : #1197 & 26.07.16

REGISTERED BY: Mr.Pujari N.S

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

RESULT:-

Tooling Cost Per Component



KAIZEN SUSTENANCE

WHAT TO DO : Changed the Insert Life in PCP & Tooling Master 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
01	A479	--	M.E	Completed