



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. 10

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

WIDELY/DEEPLY:

PRESENT STATUS : Presently we are using OFHT 040305 Insert for A351 DGS facing operation at OP#10,

- 1) No of Corner / Insert : 8 Nos
- 2) No Insert Required/ Cutter : 4 Nos
- 3) Life / Tool (=2800*8) : 22400 nos.
- 4) Unit Price (=800*4) : INR 3200/-
- 5) CPC of Facing Operation (=3200/22400) Is : INR 0.14 /-



Make : Ceratizit

BEFORE

IDEA: No of insert corner 16 no's /Insert.

COUNTERMEASURE : To Change The Insert Specification from OFHT 040305 to OHKU 060508 Insert for A351 DGS facing operation at OP#10,

- 1) No of Corner / Insert : 16 Nos
- 2) No Insert Required/ Cutter : 3 Nos
- 3) Life / Tool (=3000*16) : 48000nos.
- 4) Unit Price (=800*3) : INR 2400/-
- 5) CPC of Facing Operation (=2400/48000) Is : INR 0.05/-



Make : WNT

AFTER

BENCHMARK	INR 1.84
TARGET	INR 1.72
KAIZEN START	01.05.16
KAIZEN FINISH	25.07.16

TEAM MEMBERS:
N.S.Pujari
Praveen Jannu, Pradeep Kini, Ambi

BENEFITS:
Save INR 48600 cost /Annum.

WHY - WHY ANALYSIS :-

- Why1:** Tooling Cost Per Component is INR 1.78.
- Why2:** Facing Operation Cost Per Component is INR 0.14
- Why3:** No of insert corner 8 Nos/Insert.

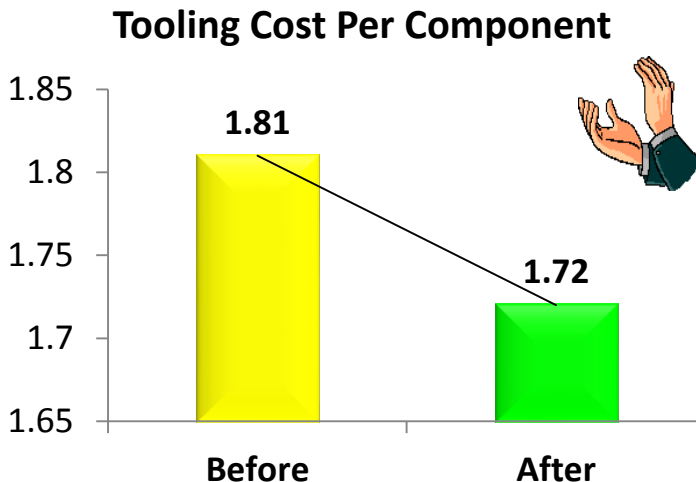
ROOT CAUSE:- No of insert corner 8 Nos/Insert.

REGISTRATION NO. & DATE : #1198 & 26.07.16

REGISTERED BY: Mr. Pujari N.S

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

RESULT:-



KAIZEN SUSTENANCE

WHAT TO DO : Changed the Insert Specification 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	04.08.16	M.E	Open