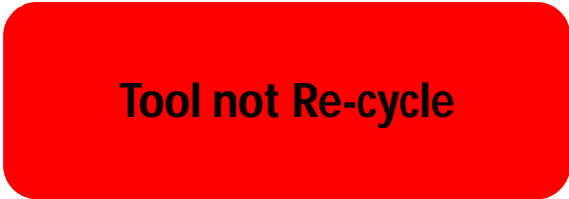

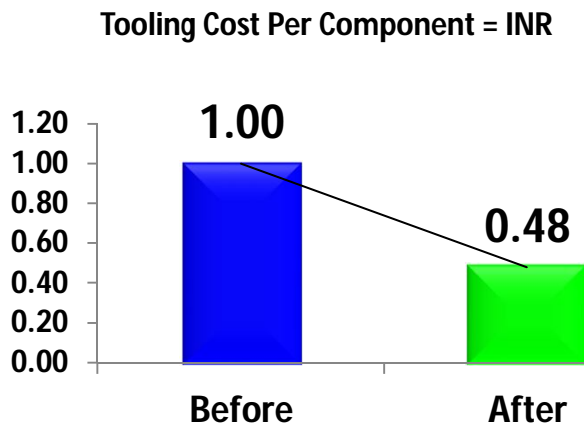


ADVIK P14	TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET										
	TPM CIRCLE NAME : Joshile	LOSS NO. / STEP																			
	DEPT :- Manufacturing Engg.	RESULT AREA	P	Q	DEF :- A	C	D	S	M												
CELL :-A351	CELL NAME:- Drum Change Line	MACHINE / STAGE :- Winner / Widma	OPERATION :- Profile Groove Milling																		
KAIZEN THEME : To Reduce the Tooling Cost Per Component for Profile Groove Milling in A351 Drum Change Soft Cell.		IDEA :- Tool should recycle after reaching the Tool life.																			
WIDELY/DEEPLY:-		COUNTERMEASURE:- Started the re-sharpening process for Ø 7.1 mm End Mill. We can do re-sharpening two times. One time re-sharpening cost is INR 450/-						<table border="1"> <tr><td>BENCHMARK</td><td>1.0 INR</td></tr> <tr><td>TARGET</td><td>0.5 INR</td></tr> <tr><td>KAIZEN START</td><td>18.08.2014</td></tr> <tr><td>KAIZEN FINISH</td><td>19.08.2014</td></tr> </table>				BENCHMARK	1.0 INR	TARGET	0.5 INR	KAIZEN START	18.08.2014	KAIZEN FINISH	19.08.2014		
BENCHMARK	1.0 INR																				
TARGET	0.5 INR																				
KAIZEN START	18.08.2014																				
KAIZEN FINISH	19.08.2014																				
PROBLEM / PRESENT STATUS :- Ø 7.1 mm Profile Groove Milling CPC : INR 1.00/- Tool Life : 3000 No's. Tool Cost : 3000/- INR Tooling CPC : INR 1.00/-																					
BEFORE												AFTER									
WHY - WHY ANALYSIS :- Why1- Present Ø 7.1 mm Profile Groove Milling CPC is INR 1.00/- Why2- Present Ø 7.1 mm Groove Milling operation Tool i.e. Ø 7.1 End Mill scrapping after reaching tool life.		RESULT :- Tooling Cost Per Component = INR																			
ROOT CAUSE :- Tool Scrap after reaching the Tool Life.								<table border="1"> <tr> <td>MATERIAL COST</td> <td>LABOUR COST</td> <td>TOTAL COST</td> </tr> <tr> <td>IN RS</td> <td>IN RS</td> <td>IN RS</td> </tr> <tr> <td>-----</td> <td>-----</td> <td>-----</td> </tr> </table>				MATERIAL COST	LABOUR COST	TOTAL COST	IN RS	IN RS	IN RS	-----	-----	-----	
MATERIAL COST	LABOUR COST	TOTAL COST																			
IN RS	IN RS	IN RS																			
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REGISTRATION NO. & DATE: 270 & 21.08.2014		WHAT TO DO: Revised the Master list of tooling by adding re-sharpening of Tool. HOW TO DO: Life Monitoring after re-sharpening FREQUENCY : Ongoing activity																			
REGISTERED BY :- Guru Basappa		SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																			
MANAGER'S SIGN :- Ravi Gouda		<table border="1"> <tr> <th>SR. NO.</th> <th>CELL</th> <th>TARGET</th> <th>RESPONSIBILITY</th> <th>STATUS</th> </tr> <tr> <td>1</td> <td>A351</td> <td>18.09.2014</td> <td>Team</td> <td>Completed</td> </tr> </table>				SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS	1	A351	18.09.2014	Team	Completed						
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS																	
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