



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,

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



**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,

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



<b>BENCHMARK</b>	INR 1.84
<b>TARGET</b>	INR 1.72
<b>KAIZEN START</b>	01.05.16
<b>KAIZEN FINISH</b>	25.07.16

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

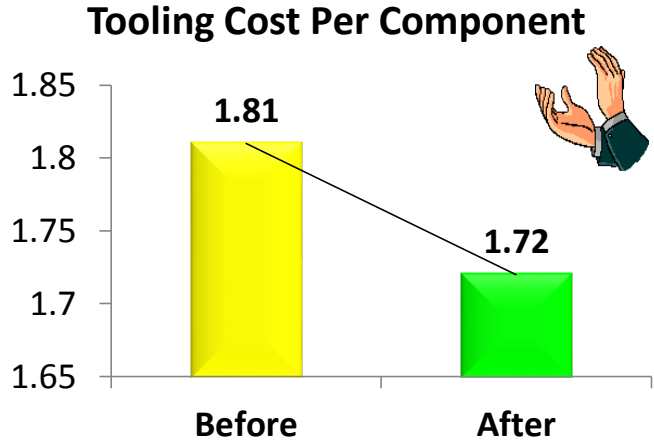
**BENEFITS:**  
Save INR 48600 cost /Annum.

**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:** 1320 , 26.07.16  
**REGISTERED BY:** Mr. Guru Bassappa  
**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