

TPM CIRCLE NO :- 2

ACTIVITY

KK

QM

PM

JH

SHE

OT

DM

E&T

TPM CIRCLE NAME : Joshile

LOSS NO. / STEP

DEPT :- Manufacturing Engg.

RESULT AREA

P

Q

DEF:- A

C

D

S

M

CELL :-A479

CELL NAME:- Drum Change Line

MACHINE / STAGE :- DTC-300/Machining

OPERATION :- Facing ,Drill & Tapping

KAIZEN THEME : To Reduce the Tooling Cost Per Component of A479 DGS in OP#10.

IDEA :- \varnothing 4.2 mm Sc Drill Double Ended Cutting Edge tool to be introduce.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- Present Tooling Cost Per Component is INR 2.95/-

COUNTERMEASURE:- Introduced both end cutting tool for \varnothing 4.2 mm Sc drill and per edge life is 5000 No's and tool cost is INR 1904/- & cost per component is INR 2.86.

\varnothing 4.2 mm End Mill single end tool

\varnothing 4.2 mm End Mill double end tool

BENCHMARK	2.95NR
TARGET	2.86INR
KAIZEN START	01.05.2016
KAIZEN FINISH	31.05.2016

TEAM MEMBERS :-

N.S.Pujari,
Mr. Praveen Jannu, Mr. Pradeep Kini

BENEFITS :-

1. Save INR 9742/- cost /Annum.

KAIZEN SUSTENANCE

WHAT TO DO: Revised the Master list of tooling by adding new both end tool

HOW TO DO: Life over for one end then use another end

FREQUENCY : ongoing activity

WHY - WHY ANALYSIS :-

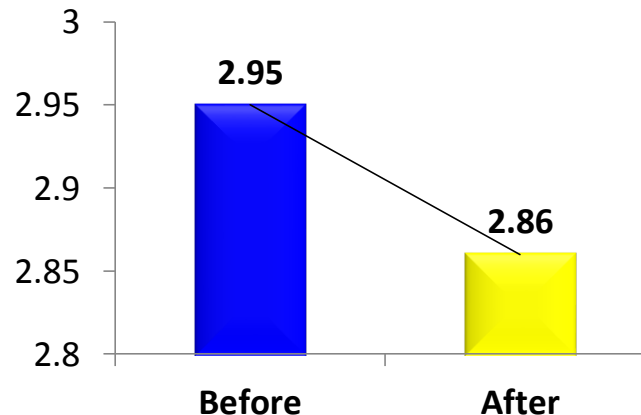
Why1: Present Tooling CPC is INR 2.95/-

Why2: Present \varnothing 4.2 mm drilling CPC is INR 0.28/-

Why3: Present \varnothing 4.2 mm End mill is single cutting Edge.

RESULT :-

Tooling Cost Per Component



ROOT CAUSE :- Present \varnothing 4.2 mm End mill is single cutting Edge.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE: 1311 ,15.06.16**REGISTERED BY :-** Guru Basappa**MANAGER'S SIGN :-** N.S.Pujari**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

Sr. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A479	31.05.16	M.E	Open