

K4

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: A479 CELL NAME: Drum Change MACHINE / STAGE: VMC / Machining OPERATION: Operation No. 10

KAIZEN THEME: To Reduce the Tooling Cost Per Component of A479 Drum Gear Shifter in Operation 10.

WIDELY/DEEPLY:

PRESENT STATUS : Cost per component is INR 3.24.
 Ø3.0 ±0.01 mm hole machining CPC is : INR 0.28/-



SC STEP DRILL
D2.99XD6XFL20XOAL60



SC HOLE MILL
DIA3XFL8XOAL60XSH6

BEFORE

IDEA: 1 Tool 1 Operation

COUNTERMEASURE : To change the drill design of SC STEP DRILL D2.99XD6XFL20XOAL60 to SC STEP DRILL D2.97XD6XFL20XOAL60 & eliminated Ø3.0 End mill tool.



SC STEP DRILL
D2.97XD6XFL20XOAL60

AFTER

BENCHMARK	4 %
TARGET	0 %
KAIZEN START	15.05.16
KAIZEN FINISH	15.06.16

TEAM MEMBERS:
 N.S.Pujari
 Praveen Jannu, Chamaraj

BENEFITS:

1. Save INR 14072/- cost /Annum.
2. Reduce C.T 51 Sec to 49 Sec.
3. Increase Out Put/Hour 70 Nos to 73 Nos
4. Tooling Changing time 88 min /Year

WHY - WHY ANALYSIS :-

Why1: Present Ø3.0 ±0.01 mm hole machining CPC is : INR 0.28/-

Why2: 2 Tool 1 Operation

ROOT CAUSE:- 2 Tool 1 Operation

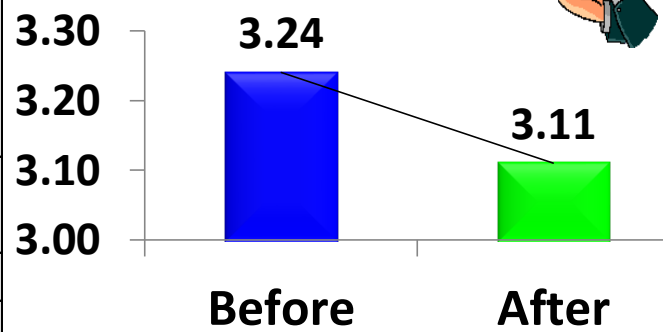
REGISTRATION NO. & DATE: 1314 , 15.06.16

REGISTERED BY: Mr. Guru Bassappa

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

RESULT:-

Tooling Cost Per Component



KAIZEN SUSTENANCE

WHAT TO DO : Revised the PCP,CP & Master list of tooling,

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
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