K4		1													
TPM CIRCLE NO :- 2 TPM CIRCLE NAME : Joshile DEPT :- Manufacturing Enga		ACTIVITY LOSS NO. / STEP	KK	QM	PM J	H SHE	1	OT	DM	E&T	$k\Lambda 17$		IDEAS		
DEPT :- Manufacturing Engg.		RESULT AREA	P	Q	DEF :- A	С		D	S	М	MAIL				
CELL :-A479 CELL NAME:- Drum Change Line		HINE / STAGE :- DTC-30				J			_		acing ,Dri	ill & T	apping		
KAIZEN THEME: To Reduce the Tooling Cost Per Component of A479 DGS in OP#10.		:- Ø 4.2 mm Sc Drill I				ng Edge	-	ool t	be	intro					
•	coul	NTERMEASURE:- Intr	oduce	d bot	h end c	uttina				//ARK			95NR		
WIDELY/DEEPLY:-	-	for Ø 4.2 mm Sc drill				•			RGET	STAR	-		86INR		
		and tool cost is INR 1			9					FINISH			.05.2016		
PROBLEM / PRESENT STATUS :- Present Tooling	& co:	st per component is I	NR 2	.86.				- KA	ZLIV	1111131			.03.2010		
Cost Per Component is INR 2.95/-									TEAM MEMBERS :-						
CA O F. INCH. 'I.		C 4 0 F		a • 1 1					.Puja			4 5	1 1/1 1		
Ø4.2 mm End Mill single	Ø 4.2 mm End Mill double							Mr. Praveen Jannu, Mr. Pradeep Kini BENEFITS:-							
end tool		end	l toc	ol .							0742/	aact	/Annum.		
3116/1001		3113						1.	Sav	emk	9/42/-	COST	/Ammum.	•	
WHY - WHY ANALYSIS :- Why1: Present Tooling CPC is INR 2.95/- Why2: Present Ø 4.2 mm drilling CPC is INR 0.28/- Why3: Present Ø 4.2 mm End mill is single cutting Edge.	RESU 3 2 95	Tooling Cost F	Per 0	omį	ooner	AFTE	R	to H(us	oling W T e an	TO Do by a O DC othe	adding r	sed the new be ver fo	ne Maste both end or one en	tool	
WHY - WHY ANALYSIS :- Why1: Present Tooling CPC is INR 2.95/- Why2: Present Ø 4.2 mm drilling CPC is INR 0.28/- Why3: Present Ø 4.2 mm End mill is single		Tooling Cost F	Per C	omį	ooner		R	HC us FR	oling OW T e an EQU	TO Do by a O DO othe	O: Revis adding r O: Life ov r end ' : ongoi	sed the hew be were for	ne Maste both end or one en	tool d then	
WHY - WHY ANALYSIS :- Why1: Present Tooling CPC is INR 2.95/- Why2: Present Ø 4.2 mm drilling CPC is INR 0.28/- Why3: Present Ø 4.2 mm End mill is single	3 2.95	Tooling Cost F	Per 0	om	ooner		R	HC us FR	OST ERIAL	TO DO by a TO DO othe ENCY	O: Revised ding red rend rend rend rend rend rend rend	sed the new between formal series of the new between the new b	he Maste both end or one en ctivity	AIZEN L COST	
WHY - WHY ANALYSIS :- Why1: Present Tooling CPC is INR 2.95/- Why2: Present Ø 4.2 mm drilling CPC is INR 0.28/- Why3: Present Ø 4.2 mm End mill is single cutting Edge. ROOT CAUSE :- Present Ø 4.2 mm End mill is	3	Tooling Cost F	Per C	omp			R	HC us FR	oling OW T e an EQU	TO DO by a TO DO othe ENCY	O: Revised ding red rend rend rend rend rend rend rend	sed the new be ver for an accordance of the contract of the co	he Maste both end or one en ctivity	tool d then	
WHY - WHY ANALYSIS :- Why1: Present Tooling CPC is INR 2.95/- Why2: Present Ø 4.2 mm drilling CPC is INR 0.28/- Why3: Present Ø 4.2 mm End mill is single cutting Edge.	3 2.95 2.9	Tooling Cost F	Per 0	omp	ooner 2.86		R	HC us FR	OST ERIAL	TO DO by a TO DO othe ENCY	O: Revised ding rend rend rend rend rend rend rend rend	sed the new between formal series of the new between the new b	he Maste both end or one en ctivity	AIZEN L COST	
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WHY - WHY ANALYSIS:- Why1: Present Tooling CPC is INR 2.95/- Why2: Present Ø 4.2 mm drilling CPC is INR 0.28/- Why3: Present Ø 4.2 mm End mill is single cutting Edge. ROOT CAUSE:- Present Ø 4.2 mm End mill is single cutting Edge.	3 2.95 2.9	Tooling Cost F	Per 0	omp		t	R	C MAT	OST ERIAL IN R	TO DO by a TO DO othe ENCY INCU COST S	O: Revisedding red rend rend rend rend rend rend rend	OR MUJR COS	he Master both end or one en ctivity MAKING K ST TOTA IN	AIZEN L COST I RS	