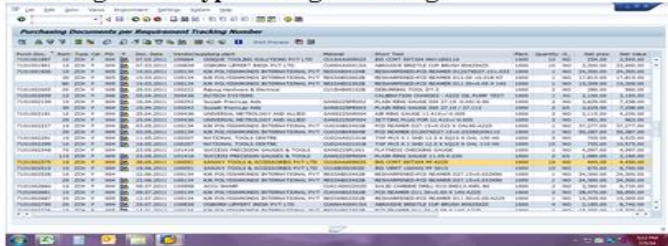
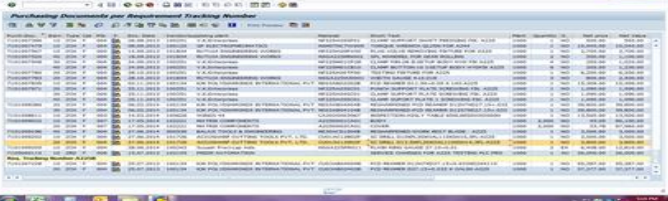
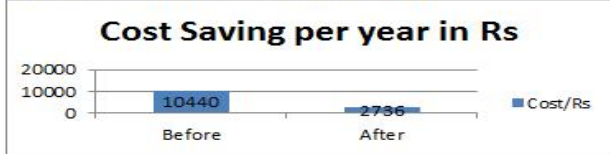


COST IMPROVEMENTS

PROD

ADVIK	TPM Circle No.:	Activity	KK	JH	QM	PM	SHE	OT	DM	E&T	KAIZEN IDEA SHEET	
	TPM Circle Name:	Loss no.	✓									
Plant-1 Chakan	Dept.: Machine Shop	Step									Kaizen No.:	
		Result Area	P	Q-Def. A / B / C			C	D	S	M		
Cell No.: A225	Cell Name: A225 Oil Pump	Process / Stage : FRD-1									Operation : Machining	
Kaizen Theme: To Reduce Tool Cost.		Idea : Use S/C Reamer Instead of Insert.										
		Counter Measure: New S/C Reamer Design For A225 Body Suction Hole & Delivery Hole.										
Problem / Present Status: 1.For A225 Body Suction Hole Machining Tool cost per Component is 0.29 paisa.		Before : A225 body For Suction Hole & Delivery Hole Machining Insert Type Boring Bar Using.					Bench Mark					
							Target		0			
							Kaizen Start		3-May-14			
							Kaizen Finish		15-Jun-14			
							Team Members With Sign : 1. Umesh Pimple. 2. Ritesh Bhole. 3.Ajay Bhor					
							Benefits:					
Why Why Analysis :		After :					P					
Why 1:For A225 Body Suction Hole Machining Tool cost per Component is....		1) New S/C Reamer Design For A225 Body Suction Hole & Delivery Hole.					Q					
Why 2: Less Cutting Force Used.(S3000 , F0.1)		2) Cutting Parameter Increase (S - 4770 F - 0.20).					C	Tool Cost Reduced.				
Why 3:Insert CCMT 09T304 Using For Machining							D					
							S					
							M					
							Kaizen Sustenance :					
							What to do : Use Only New S/C Reamer.					
							How to do : Tool Life Monitoring.					
Root Cause : Insert CCMT 09T304 Using For Machining.		Result : 1) Tool Cost Reduced by0.29 paisa. To 0.076 paisa 2)Cost Saved /Year 10440 Rs to 2736 Rs					Scope & Plan for Horizontal Deployment					
Registration no.& dt : :15/06/14							Sr. no.	Model	Target Date	Responsibility	Status	
Submitted by : Umesh Pimple							—	—	—	—	—	
Manager's Sign : Surendra Kulkarni							—	—	—	—	—	