

Cost Saving

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.: A304	Cell Name: A304 Shaft	Process / Stage : VMC							Operation : Machining														
Kaizen Theme: To improve tool life.		Idea : To change coating of drill to improve tool life																					
		Counter Measure: Drill coating changed from futura to HSN squire																					
Problem / Present Status: A304 shaft drilling dia 4.10 mm tool consumption is excess.		Before : Futura coated drill used. Tool Life recorded 200 no's / tool.				Bench Mark		200/ tool															
						Target		1000/ tool															
						Kaizen Start		07.02.2015															
						Kaizen Finish		12.03.2015															
		Team Members With Sign : Nilesh Khadke. Nitin Sutar.																					
		Benefits:																					
		P																					
		Q																					
		C Reduce tool cost.																					
		D																					
		S																					
		M																					
		Kaizen Sustenance :																					
		What to do : 1.Tool life to be monitored.																					
		How to do : 1. Daily Checking Start of Shift.																					
Why Why Analysis : Why 1 – A304 shaft drilling dia 4.10 mm tool consumption is excess. Why 2 – Less tool life (200 to 225 against of 1000 no's as per PCP) Why 3 - Dia.4.0 Drill Cutting edges blunt. Why 4 – futura coated drill used.		After : Helica coated drill used. Tool Life recorded 1000 no's / tool.																					
Root Cause : Futura coated drill used.		Result :																					
		<p>Tool consumption</p> <table border="1"> <tr><th>Category</th><th>Before</th><th>After</th></tr> <tr><td>Consumption</td><td>10</td><td>2</td></tr> </table>					Category	Before	After	Consumption	10	2	<p>Tool life</p> <table border="1"> <tr><th>Category</th><th>Before</th><th>After</th></tr> <tr><td>Tool Life</td><td>200</td><td>1000</td></tr> </table>					Category	Before	After	Tool Life	200	1000
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Registration no.& dt : 12.03.2015																							
Submitted by : Umesh Pimple																							
Manager's Sign :Surendra Kulkarni																							
Scope & Plan for Horizontal Deployment																							
Sr. no.	Model	Target Date	Responsibility	Status																			
—	—	—	—	—																			