

CELL :-A351 CELL NAME:- Drum Change MACHINE / STAGE :- CNC Turning OPERATION :- Operation No. 60

KAIZEN THEME : To Reduce the Tooling Cost Per Component in Drum Change Cell.

IDEA :- Op. 60 Insert CPC should be < INR 0.34

WIDELY/DEEPLY:-

COUNTERMEASURE:- Changed the Insert Make on Operation No. 60 CNC Turning Machine as per below said details to get low Tooling Cost Per Component because of excess life of new Inserts comparatively than existing inserts.

BENCHMARK	2.78 INR
TARGET	2.65 INR
KAIZEN START	05.04.2014
KAIZEN FINISH	20.04.2014

PROBLEM / PRESENT STATUS :- Present Tooling Cost Per Component is INR 2.78/-

TEAM MEMBERS :-
Appasab Magadum, Praveen Jannu
Pradeep Kinni

BENEFITS :-

WNMG 080408 WIDIA Make
(Old CPC – 0.167)

VNMG 160404 MITUSHUBHSI Make
(Old CPC – 0.170)

WNMG 080408 SANCOTECH Make
(New CPC – 0.079)

VNMG 160404 KYOCERA Make
(New CPC – 0.134)

1. Save INR 80147 cost /Annum.

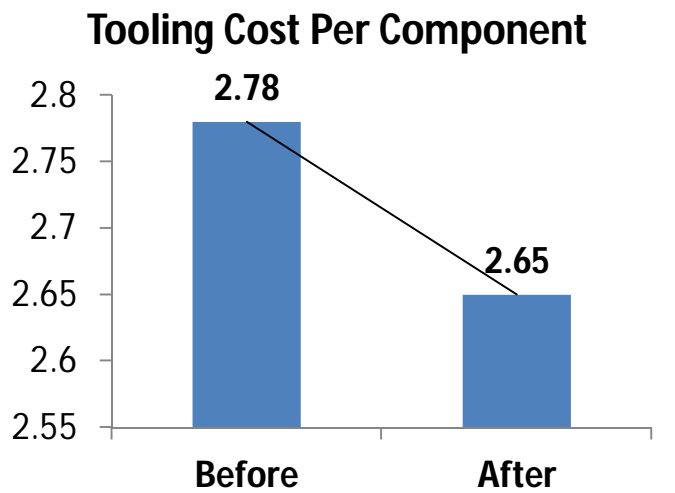
BEFORE

AFTER

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-
Why1: Tooling CPC is INR 2.78/-
Ans.1: Op. 60 Insert CPC is INR 0.34/-

RESULT :-



WHAT TO DO: Changed the Insert Make in PCP & Tooling Master List.
HOW TO DO:-----
FREQUENCY : 1 Time activity

ROOT CAUSE :- Op. 60 Insert CPC is INR 0.34/-

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE : 12 & 21.04.2015

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Guru Basappa

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	A351 – 2 nd Cell	25.05.14	Appasab	Comp.

MANAGER'S SIGN :- Ravi Gouda