

CELL :-A315	CELL NAME:- Oil Pump Machining	MACHINE / STAGE :- VMC Machining	OPERATION :- Operation No. 50
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**KAIZEN THEME :** To Reduce the Tooling Cost Per Component in Oil Pump Cell.

**IDEA :-** PCD Reamer Tool Cost should be less than INR 22,000/-

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Changed the 9.0+0.022 PCD Reamer from existing KJK Make to Rudrali Make by implementing trial on same life with less cost (INR 12,000/-).

<b>BENCHMARK</b>	0.88 INR
<b>TARGET</b>	0.76 INR
<b>KAIZEN START</b>	15.4.2014
<b>KAIZEN FINISH</b>	20.08.2014

**PROBLEM / PRESENT STATUS :-** Present Tooling Cost Per Component is INR 0.88/-

**KJK PCD REAMER**

**RUDRALI PCD REAMER**

**TEAM MEMBERS :-**  
Appasab Magadum, Praveen and Pujari Pradeep Kinni

**BENEFITS :-**  
1. Save INR 92,876/- cost /Annum.

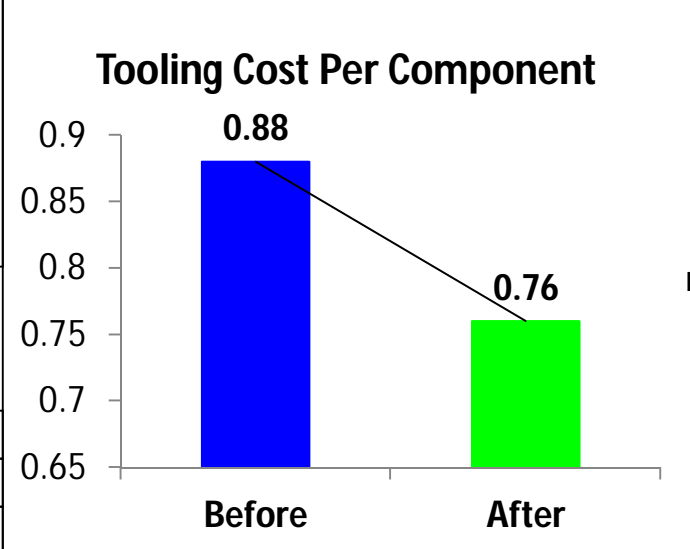
BEFORE

AFTER

**KAIZEN SUSTENANCE**

**WHY - WHY ANALYSIS :-**  
**Why1:** Present Tooling CPC is INR 0.88/-  
**Why2:** Present Op. 10 PCD reamer Dia. 9.0+0.022 CPC is INR 0.22/-  
**Why3:** Present PCD Reamer Tool Cost is INR 22,000/-

**RESULT :-**



**WHAT TO DO:** Revised the Tooling Master list by changing the make of Reamer.  
**HOW TO DO:**-----  
**FREQUENCY :** 1 Time activity

**ROOT CAUSE :-** Present PCD Reamer Tool Cost is INR 22,000/-

<b>COST INCURRED FOR MAKING KAIZEN</b>		
<b>MATERIAL COST</b> IN RS	<b>LABOUR COST</b> IN RS	<b>TOTAL COST</b> IN RS
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**REGISTRATION NO. & DATE :** 163 & 20.07.14  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** Ravi Gouda

<b>SCOPE &amp; PLAN FOR HORIZONTAL DEPLOYMENT</b>				
SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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