K3

ADVIK P14

TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	KAIZEN IDEA SHEET
TPM CIRCLE NAME : Joshile	LOSS NO. / STEP									
DEPT :- Manufacturing Engg.	RESULT AREA	P	Q	DEF :- A		C	D	S	M	

CELL :-A351 | CELL NAME:- Drum Change Line | MACHINE / STAGE :- VMC Machining | OPERATION :- Operation No. 50

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

IDEA :- Ø 3.025 mm Drilling operation Tool i.e. Drill should not scrap after reaching tool life.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- Present Tooling Cost Per Component is INR 2.65/-

COUNTERMEASURE:- Started re-sharpening for Ø 3.025 mm drill. We can do re-sharpening two times. One time re-sharpening cost is INR 300/- And life is 85 % of original life i.e. 7650

BENCHMARK	2.65 INR
TARGET	2.59 INR
KAIZEN START	22.07.2014
KAIZEN FINISH	27.07.2014

TEAM MEMBERS :-

Appasab Magadum, Praveen and Pujari Pradeep Kini

BENEFITS :-

1. Save INR 38,409 cost /Annum.

Ø 3.025 mm Drill not re-sharpening

BEFORE

Ø 3.025 mm Drill re-sharpening established.

AFTER

KAIZEN SUSTENANCE

WHAT TO DO: Revised the Master list of tooling by adding re-sharpening of this Tool.

HOW TO DO: Life over tool sent for re-sharpening.

FREQUENCY : ongoing activity

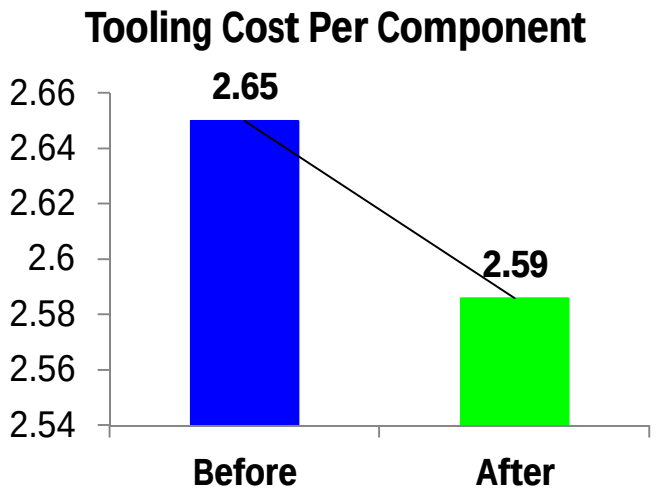
WHY - WHY ANALYSIS :-

Why1: Present Tooling CPC is INR 2.65/-

Why2: Present Ø 3.025 mm Drilling CPC is INR 0.144/-

Why3: Present Ø 3.025 mm Drilling operation Tool i.e. Drill scrapping after reaching tool life.

RESULT :-



ROOT CAUSE :- Present Ø 3.025 mm Drilling operation Tool i.e. Drill scrapping after reaching tool life.

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE : 138 & 27.07.14

REGISTERED BY :- Guru Basappa

MANAGER'S SIGN :- Ravi Gouda

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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