

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

KAIZEN IDEA SHEET

F/IMS/05

CELL: A490 CELL NAME: CBS MACHINE / STAGE: Riveting/Assembly OPERATION: Riveting

KAIZEN THEME: To Reduce CPC of A490 CBS Assembly. In Riveting Tool.

WIDELY/DEEPLY:

RESENT STATUS : Present Riveting tool cost is INR 550/- Piece .

Discription	: RIVETING TOOL FOR A247
Cost Per Piece	: INR 550/-
Tool Life	: 40000 Nos
CPC	: 0.013
Production per month (Avg)	: 72000 Nos
No of Tools red./Year	: 22 Nos

Tool Drawing Detail Show Next Slide

BEFORE

IDEA: To be separate Bottom wear out & top fixed pin

COUNTERMEASURE : Made separate Piece of bottom wear out & top fixed pin & now after life over we are replacing bottom part & cost of bottom pin is INR 200/-

Discription	: RIVETING TOOL FOR A247
Cost Per Piece	: INR 200/-
Tool Life	: 40000 Nos
CPC	: 0.005
Production per month (Avg)	: 72000 Nos
No of Tools red./Year	: 22 Nos

Tool Drawing Detail Show Next Slide

AFTER

BENCHMARK	INR 11232/-
TARGET	INR 4320/-
KAIZEN START	10.12.17
KAIZEN FINISH	20.12.17

TEAM MEMBERS:
Mr. N.S.Pujari & Mr. Mallikarjun

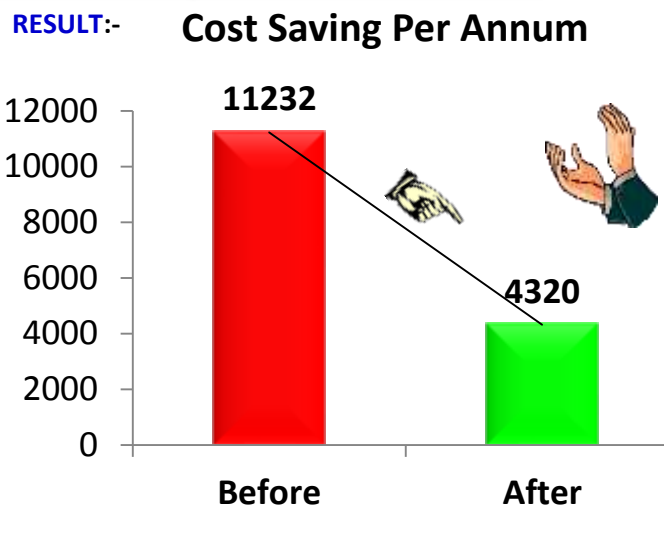
BENEFITS:
1) Cost Saving is INR 6912/- annum

WHY - WHY ANALYSIS :-
Why1: Present Riveting tool cost is INR 550/- Piece .
Why2: Bottom Wear Out Part & Top Fixed Part In One Piece

ROOT CAUSE:- Bottom Wear Out Part & Top Fixed Part In One Piece

REGISTRATION DATE: 21.12.17
REGISTRATION NO : P14/KK/2018/015

REGISTERED BY: Mr. Manas KP
MANAGER'S SIGN: Mr. N.S.Pujari



KAIZEN SUSTENANCE

WHAT TO DO : Tool Master list to be update with revision detail
HOW TO DO : ---
FREQUENCY : On-Going Activity

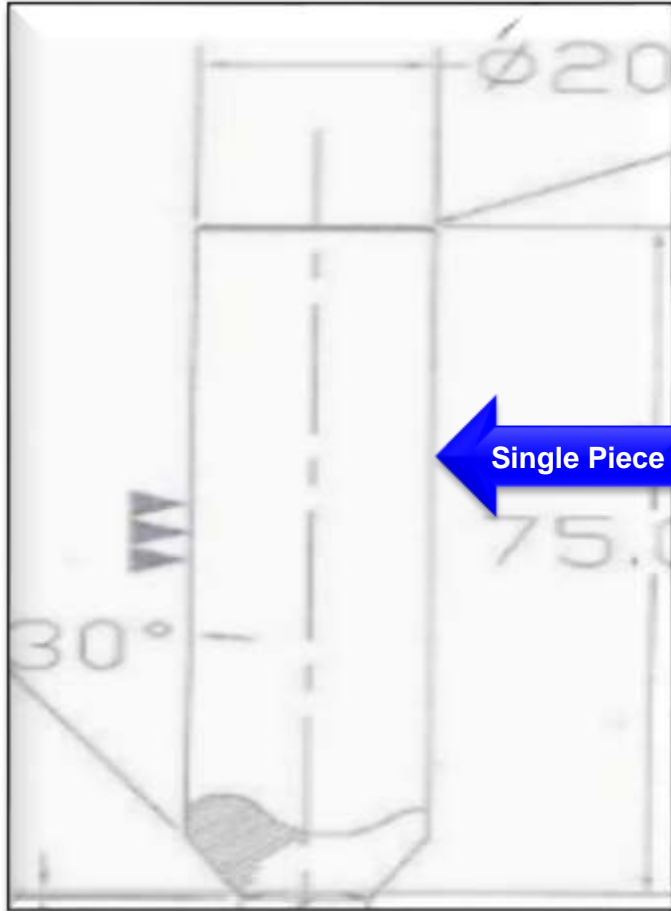
COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	-----	-----

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO	CELL	TARGET	RESP.	STATUS
No Scope in P14 , Kaizen share to CME for HD Implementation @ other plants				

Before Implementation



After Implementation

