

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

# KAIZEN IDEA SHEET

F/IMS/05

**CELL:** A128    **CELL NAME:** Tensioner Body    **MACHINE / STAGE:** CNC/Machining    **OPERATION:** Tapping, ID Boring, Facing & Drilling

**KAIZEN THEME:** To Reduce the Cost per component of A128 Tensioner Body.

**WIDELY/DEEPLY:**

**IDEA:** Make to be replace Emuge to Emkay Taps

**PRESENT STATUS :** Present Tooling Cost Per Component is INR 0.24/-

1) Tool Discription : TAP M6X1 6H REKORD 1 A-H TICN COATED

1) No of Insert / Holder : 01 Nos

2) Total Tap Life : 6000 Nos

3) Unit Price : INR 390/-

4) CPC : INR 0.07/-

5) Make : Emuge

**BEFORE**

**COUNTERMEASURE :** :- To Change the Tap make Emuge to Emkay Taps & Now Cost per component is INR 0.20/-.

1) Tool Discription : TAP M6X1 6H REKORD 1 A-H TICN COATED

1) No of Insert / Holder : 01 Nos

2) Total Tap Life : 15000 Nos

3) Unit Price : INR 403/-

4) CPC : INR 0.03/-

5) Make : EMKAY TAPS

**AFTER**

|                      |            |
|----------------------|------------|
| <b>BENCHMARK</b>     | INR 0.24/- |
| <b>TARGET</b>        | INR 0.20/- |
| <b>KAIZEN START</b>  | 03.03.2017 |
| <b>KAIZEN FINISH</b> | 29.04.2017 |

**TEAM MEMBERS:**  
N.S.Pujari, Mr. Chamaraj BT  
Mr. Praveen Jannu

**BENEFITS:**

1) Cost Saving in INR 69912 /- Annum.

2) Tool Changing Time Saved 349 Min /Annum

**WHY - WHY ANALYSIS :-**

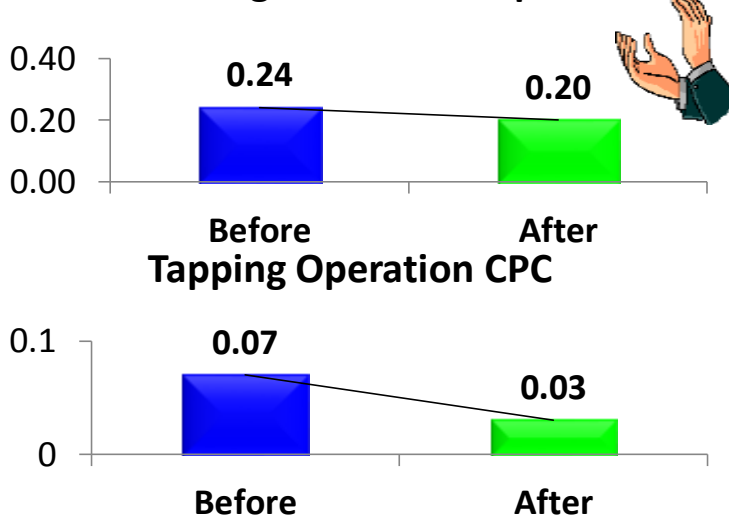
**Why1:** Present Tooling Cost Per Component is INR 0.24/-

**Why2:** Tapping operation CPC is INR 0.07/-

**Why3:** Present Tapping Operation Is CPC is High

**Why4:** Emuge Make Insert

**RESULT:- Tooling Cost Per Component**



**KAIZEN SUSTENANCE**

**WHAT TO DO :** Revise the Cutting tool Master List & PCP .

**HOW TO DO :** ----

**FREQUENCY :** 1 Time activity

**ROOT CAUSE:-** Emuge Make Insert

**COST INCURRED FOR MAKING KAIZEN**

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

**REGISTRATION NO. & DATE:** 1610 & 29.04.2017

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

**REGISTERED BY:** Mr. Nigamananda

| SR. NO. | CELL | TARGET   | RESP.      | STATUS |
|---------|------|----------|------------|--------|
| 1       | A351 | 30.05.17 | N.S.Pujari | Open   |

**MANAGER'S SIGN:** Mr. N.S.Pujari