

**TPM CIRCLE NO:** 2  
**TPM CIRCLE NAME:** Joshile  
**DEPT:** Manufacturing Engineering

**ACTIVITY** KK QM PM JH SHE OT DM E&T  
**LOSS NO. / STEP**  
**RESULT AREA** P Q DEF:- A C D S M

**KAIZEN IDEA SHEET**  
 F/IMS/05

**CELL:** A374 **CELL NAME:** Oil Pump Body **MACHINE / STAGE:** VMC/Machining **OPERATION:** Facing & Reaming

**KAIZEN THEME:** : To Reduce the Cost per component of A374 Oil Pump Body.

**WIDELY/DEEPLY:**

**IDEA:** Make to be replace Matheson to Rudrali.

**PRESENT STATUS :** Present Tooling Cost Per Component is INR 0.90/-

**COUNTERMEASURE :-** To Change the insert make Matheson to Rudrali & Now Cost per component is INR 0.72/-.

- 1) Insert Discription : SNEW 1204 ADDF DA2200
- 2) No of Insert / Cutter : 06 Nos
- 3) Total insert Life : 60000 Nos
- 4) Unit Price (6\*3550) : INR 21300/-
- 5) CPC : INR 0.35/-
- 6) Make : Matheson

- 1) Insert Discription : SNEW 1204 ADDF DA2200
- 2) No of Insert / Cutter : 06 Nos
- 3) Total insert Life : 64000 Nos
- 4) Unit Price (6\*1850) : INR 11100/-
- 5) CPC : INR 0.17/-
- 6) Make : Rudrali

**BEFORE**

**AFTER**

<b>BENCHMARK</b>	INR 0.85/-
<b>TARGET</b>	INR 0.67/-
<b>KAIZEN START</b>	05.07.2016
<b>KAIZEN FINISH</b>	15.10.2016

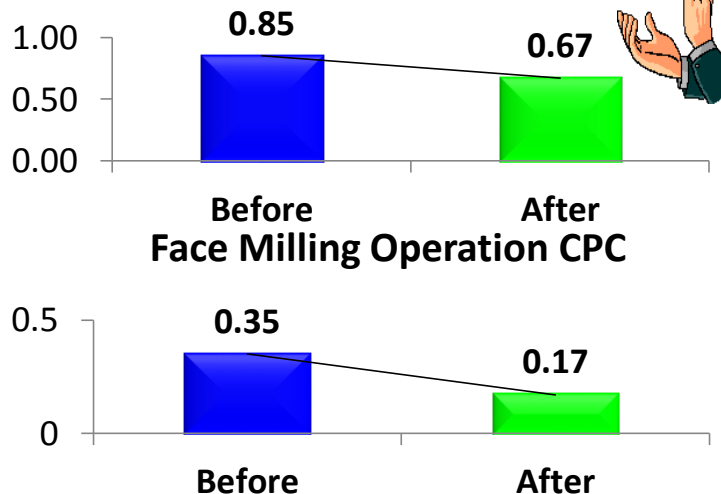
**TEAM MEMBERS:**  
 N.S.Pujari, Mr. Pradeep Kini  
 Mr. Praveen Jannu

**BENEFITS:**  
 1) Cost Saving in INR 61127 /- Annum.

**WHY - WHY ANALYSIS :-**

- Why1:** Present Tooling Cost Per Component is INR 0.90/-
- Why2:** Face milling operation CPC is INR 0.35/-
- Why3:** Present Face Milling Operation Is CPC is High
- Why4:** Motherson 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:-** Motherson Make Insert

<b>COST INCURRED FOR MAKING KAIZEN</b>		
<b>MATERIAL COST IN RS</b>	<b>LABOUR COST IN RS</b>	<b>TOTAL COST IN RS</b>
-----	-----	-----

**REGISTRATION NO. & DATE:** 1302,28.10.16

**REGISTERED BY:** Mr. Guru Bassappa

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

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

No Scope in P14, Case study share to other plant for HD implementation