KAIZEN IDEA SHEET

ADVIK P14

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

CELL :-A177 | CELL NAME:- Oil Pump Line | MACHINE / STAGE :- VMC Machining | OPERATION :- Operation No. 10

KAIZEN THEME : To Reduce the Cycle time In A177 Oil Pump Body Machining Cell.

IDEA :- Ø23.15 PCD reamer to be modify with chamfer.

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS :- Separate tools used for Ø23.15 Rotor hole reaming & chamfering , & Cycle time is 28 Sec / Comp.

BEFORE

COUNTERMEASURE:- Introduced Ø23.15 +0.03 with chamfer tool for OP.10 rotor hole reaming

Ø23.15 PCD Reamer With Chamfer

AFTER

BENCHMARK	28 Sec
TARGET	25 Sec
KAIZEN START	16.08.2014
KAIZEN FINISH	31.08.2015

TEAM MEMBERS :-

N.S.Pujari ,Praveen
Shanthkumar

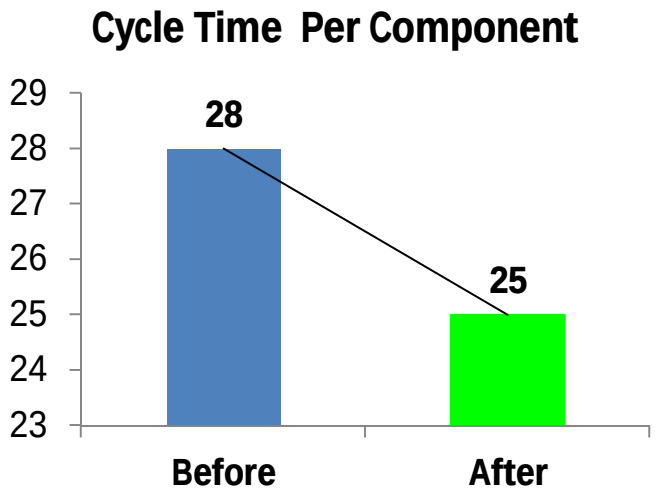
BENEFITS :-

1. Out Per Shift Increase From 985 Nos to 1104 Nos

WHY - WHY ANALYSIS :-

Why1: Cycle Time Is More.
Why 2:- Rotor hole machining is complete by using two tools
Why 3:- Separate Ø23.15 PCD Reamer & Chamfer tool used for rotor hole machining.

RESULT :-



KAIZEN SUSTENANCE

WHAT TO DO: Changed the reamer Make in PCP & Tooling Master List.
HOW TO DO:----------
FREQUENCY : 1 Time activity

ROOT CAUSE :- Separate Ø23.15 PCD Reamer & Chamfer tool used for rotor hole machining.

REGISTRATION NO. & DATE: # 815, 31.08.15

REGISTERED BY :- Guru Basappa

MANAGER'S SIGN :- N.S.Pujari

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	------	-------	------	--------.