

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
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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:-

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

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

Ø23.15 PCD Reamer With Chamfer



BEFORE



AFTER

BENCHMARK	0
TARGET	0
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

KAIZEN SUSTENANCE

WHAT TO DO: Changed the reamer Make in PCP & Tooling Master List.

HOW TO DO:-----

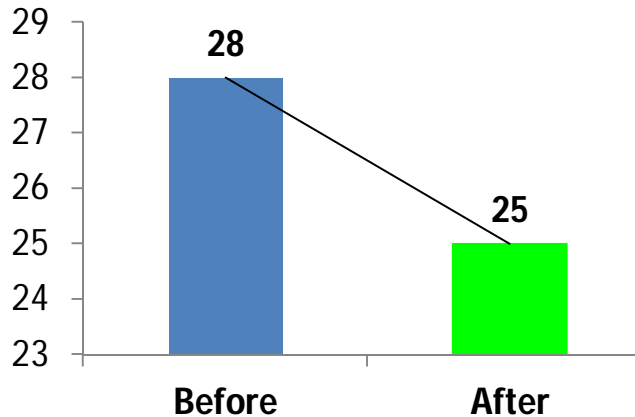
FREQUENCY : 1 Time activity

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 :-

Tooling Cost Per Component



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

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE: 811 & 31.08.15

REGISTERED BY :- Guru Basappa

MANAGER'S SIGN :- N.S.Pujari

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

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