

K1

**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	

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

CELL :- A479    CELL NAME :- Drum Change    MACHINE / STAGE :- VMC / Machining    OPERATION :- Operation No. 10

**KAIZEN THEME :** To Reduce the Tooling Cost Per Component in A479 Drum Gear Shifter.

**IDEA :-** To be Implement Multi Edge Cutting Tool (Inserted type End Mill Cutter)

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** To Change The Single Edge cutting tool to multi edge cutting tool inserted type of End mill cutter)OP#10, & Cost Per Component Is INR 3.24

<b>BENCHMARK</b>	INR 3..98
<b>TARGET</b>	INR 3.24
<b>KAIZEN START</b>	01.05.2016
<b>KAIZEN FINISH</b>	31.05.2016

**PROBLEM / PRESENT STATUS :-** We are using END MILL D20XFL35XOAL90-CARBIDE (Single Edge Cutting tool) for Ø12.3 spot facing operation, & Cost per component is INR 3.98.

**TEAM MEMBERS :-**  
N.S.Pujari ,  
Praveen Jannu  
**BENEFITS :-**



Single Edge Cutting Tool & Tool Life is 8300 nos



Inserted Type End Mill & Tool/Inset Life is 24000 no's



Make : Ceratizit

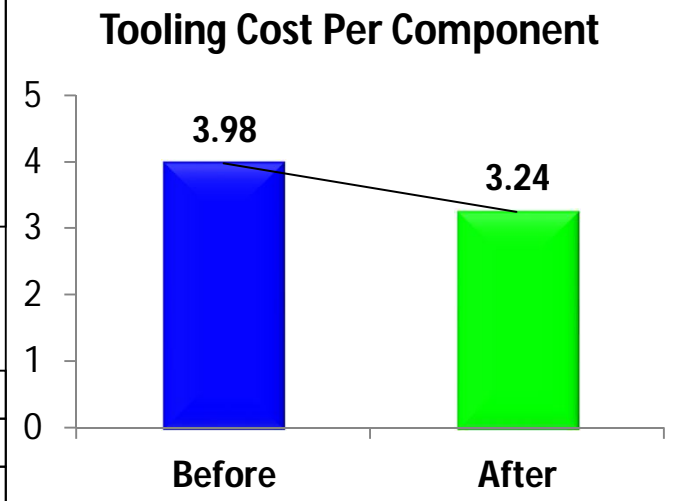
**BEFORE**

**AFTER**

1. Save INR 80106 cost /Annum

**WHY - WHY ANALYSIS :-**  
**Why1:** Tooling Cost Per Component is INR 3.98.  
**Why2:** Spot Facing Operation Cost Per Component is INR 0.84  
**Why 2:-** Single Edge Cutting Tool .

**RESULT :-**



**KAIZEN SUSTENANCE**

**WHAT TO DO:** Changed the Tool/Insert Specification in PCP & Tooling Master List.  
**HOW TO DO:**-----  
**FREQUENCY :** 1 Time activity

**ROOT CAUSE :-** Single Edge Cutting Tool .

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**REGISTRATION NO. & DATE:** 1157/31.05.16  
**REGISTERED BY :-** Guru Basappa  
**MANAGER'S SIGN :-** N.S.Pujari

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
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