ADVIK P14	TPM CIRCLE NO :- 2		ACTIVI		KK	QM	PM	JH	SHE	OT	DM	E&T	1/ 1/7			
	TPM CIRCLE NAME : Joshile			IO. / STEP									KAIZI	en Id	EA SI	
	DEPT IVIAITUIACU		RESULT		<u> P</u>	Q	DEF :- F	١	С	D	S	М				
CELL :-A177 CELI	L NAME:- Oil Pump L	Line N	MACHINE / ST	TAGE :- VM	C Mach	ining				OPER	RATIC	ON :- (<u>Operati</u>	on No. 1	0	
KAIZEN THEME : To Re Per Component in A1	•		DEA :- Ø23.	15 PCD rea	amer t	be ı	nodii	y w	ith ch	namfe	er.					
•	•		OUNTERM	EASURE:-	Introd	uced	Ø23.	15 +	0.03			MARK	(0.48		
WIDELY/DEEPLY:-		_	with chamfer tool for OP.10 rotor hole reaming								TARGET KAIZEN START			0.27		
PROBLEM / PRESENT STATUS :- Separate tools used for Ø23.15 Rotor hole reaming & chamfering , Tooling Cost Per Component is INR 0.98 & Ø23.15 PCD Reamer life Is 92000		&	& Tooling CPC Is INR 0.77 & Tool life is 130682 no's .							KAIZEN START				8.2014		
		ing & nent is							TE N. Pr	TEAM MEMBERS :- N.S.Pujari ,Praveen Pradeep Kinni						
Nos										B	NEF	ITS :-				
Tool KJK PCD Reamer –Dia 23.15 +0.03			Tool MAPAL PCD Reamer –Dia 23.15 +0.03							1.	Sa	ve IN	R 10108	35 cost	/Annu	m.
K IK DUU I	SEVIVIED		IVIAL	PAL PO	JU	KE	MIV		Λ							
KJK PCD I		BEFORE	IVIA	AL PO	JU	KE,	MIV		AFTER			TOE	00: Cha	JSTENA anged t	he rea	
	E			PAL PO	JD	KE /				<u> </u>	lake	TO E	OO: Cha	nged t	he rea	
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48.	E er Component is Hole reaming to	INR ols 1	ESULT :-	ng Cost				1	AFTER	M H	lake OW	TO E	00: Cha P & To 0:	nged t	he rea	
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48. Why 3:- Separate tool	E er Component is Hole reaming to	INR ols 1	ESULT :- Tooli	ng Cost				ent	AFTER	H	lake OW TEQU	TO E in PC TO DO JENC	OO: Cha P & To O:Y Y : 1 Ti	inged to	he rea laster l	List.
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48. Why 3:- Separate tool machining.	er Component is Hole reaming too s used for rotor h	INR ols ole 0	ESULT :- Tooli .2 1 -	ng Cost			pon	ent	AFTER	M Hi FF	lake OW TREQU	TO E in PC TO DO JENC	OO: Cha P & To O: Y : 1 Ti	anged t oling M me acti	he real	List.
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48. Why 3:- Separate tool machining. ROOT CAUSE :- Separate	er Component is Hole reaming too s used for rotor h	INR ols ole 0	ESULT :- Tooli .2 .1 .88 -	ng Cost			pon	ent	AFTER	M Hi FF	lake OW TREQU	TO E in PC TO DO JENC	OO: Cha P & To O: Y : 1 Ti	anged to oling Managed to oling Managed to oling the action of the oling the	he realister livity	List.
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48. Why 3:- Separate tool machining. ROOT CAUSE :- Separate	er Component is Hole reaming too s used for rotor h	INR ols 1 ole 0	ESULT :- Tooli .2 .1 .8 .6 .6 .4	ng Cost			pon	ent	AFTER	CCC MAT	OST II	TO E in PC TO DO JENC	OO: Cha P & To O: Y : 1 Ti	OR MA	he real laster	(AIZE COST RS
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48. Why 3:- Separate tool machining. ROOT CAUSE :- Separate tool of the column of the col	er Component is Hole reaming too s used for rotor h ate tools used for	INR ols 1 ole 0	ESULT :- Tooli .2 .1 .8 .6 .4 .4 .2 .2	ng Cost			pon	ent	AFTER	CC MAT	OST II FERIA IN R	TO E in PC TO DO JENC NCUF L COS	OO: Cha P & To O:Y: 1 Ti	OR MA JR COST I RS RIZONTA	he real laster livity	CAIZE COST RS OYME
WHY - WHY ANALYSIS Why1: Tooling Cost P 0.98. Why 2:- OP.10 Ø23.15 CPC is INR 0.48. Why 3:- Separate tool machining. ROOT CAUSE :- Separate rotor hole machining. REGISTRATION NO. & REGISTERED BY :- Gur	er Component is Hole reaming tooks used for rotor hate tools used for DATE: 810 & 31.0	INR ols 1 ole 0	ESULT :- Tooli .2 .1 .8 .6 .6 .4	ng Cost			pon	ent	AFTER	CC MAT	OST II FERIA IN R	TO E in PC TO DO JENC NCUF L COS	OO: Cha P & To O:Y: 1 Ti	OR MA	he real laster livity	CAIZE COST RS OYME