ADVIK P14 — KAIZEN IDEA SHEET

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 Tooling Cost Per Component in A177 Oil Pump Cell.

WIDELY/DEEPLY:-

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 Nos

Tool KJK PCD Reamer –Dia 23.15 +0.03

KJK PCD REAMER

BEFORE

WHY - WHY ANALYSIS :-
Why1: Tooling Cost Per Component is INR 0.98.
Why 2:- OP.10 Ø23.15 Hole reaming tools CPC is INR 0.48.
Why 3:- Separate tools used for rotor hole machining.

ROOT CAUSE :- Separate tools used for rotor hole machining.

REGISTRATION NO. & DATE: 810 & 31.08.15

REGISTERED BY :- Guru Basappa

MANAGER'S SIGN :- N.S.Pujari

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

COUNTERMEASURE:- Introduced Ø23.15 +0.03 with chamfer tool for OP.10 rotor hole reaming & Tooling CPC Is INR 0.77 & Tool life is 130682 no's .

Tool MAPAL PCD Reamer –Dia 23.15 +0.03

MAPAL PCD REAMER

AFTER

RESULT :-

Tooling Cost Per Component

	Before	After
Value	0.98	0.77

BENCHMARK	0.48INR
TARGET	0.27 INR
KAIZEN START	16.08.2014
KAIZEN FINISH	31.08.2015

TEAM MEMBERS :-
N.S.Pujari ,Praveen
Pradeep Kinni

BENEFITS :-
1. Save INR 101085 cost /Annum.

KAIZEN SUSTENANCE

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

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.	------	-------	------	--------.