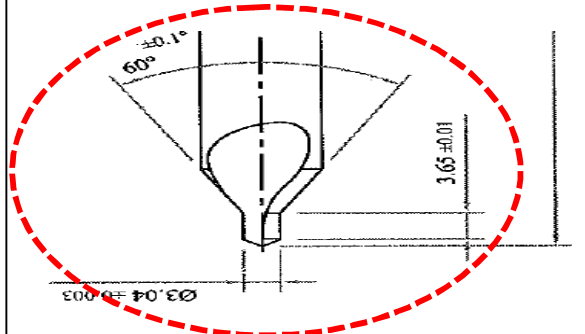


CELL : A351      CELL NAME:- Drum Change      MACHINE / STAGE :- VMC/ Machining      OPERATION :- Operation No. 10

**KAIZEN THEME :** To Reduce the Tooling Cost Per Component in A351 Drum Change Cell.

**WIDELY/DEEPLY:-**

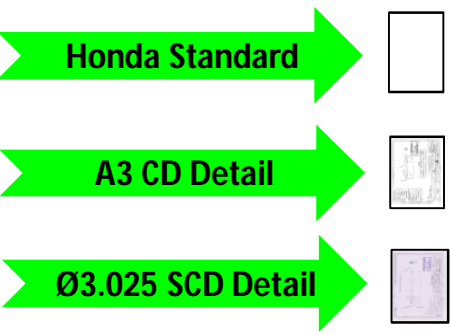
**PROBLEM / PRESENT STATUS :-** In #OP10 Operation Present Tooling CPC INR 0.62 /-. i.e. A3 Center drill Scraping after reaching tool lifer & more wear out pattern is 60° angle in tool.



BEFORE

**IDEA :-** A3 Center drill tool should be use for Ø3.025 drill hole operation

**COUNTERMEASURE:-** Started A3 scrapped center drill for Ø3.025 Drill hole operation (Before using Checked Honda standard of A3 center drill for dimension), & Ø3.025 Sc drill Eliminated from #OP10.



AFTER

<b>BENCHMARK</b>	INR 0.62
<b>TARGET</b>	INR 0.56
<b>KAIZEN START</b>	01.09.15
<b>KAIZEN FINISH</b>	01.10.15

**TEAM MEMBERS :-**  
 N.S.Pujari, Praveen, Ambrish

- BENEFITS :-**
1. Save INR 37384 cost /Annum.
  2. Save tool changing time 312 min/Annum.

**KAIZEN SUSTENANCE**

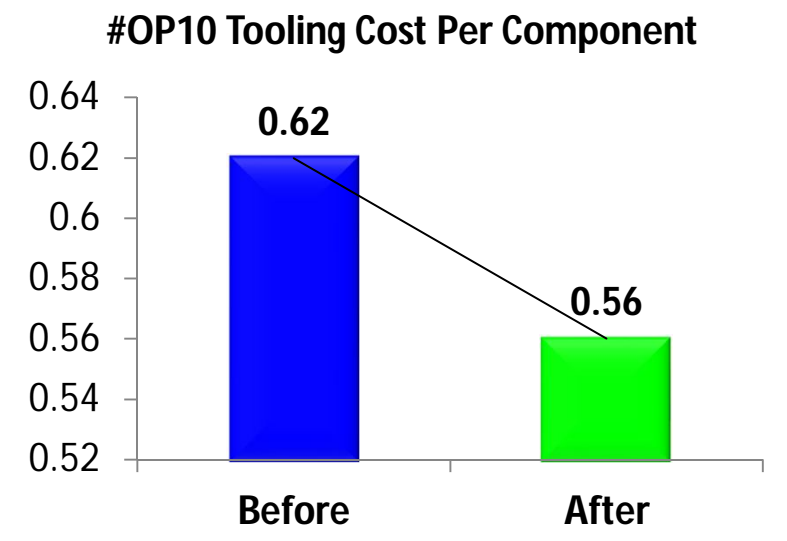
**WHAT TO DO:** Changed the Tooling Master List.  
**HOW TO DO:**-----  
**FREQUENCY :** 1 Time activity

**WHY - WHY ANALYSIS :-**  
**Why 1 :** In #OP10 Operation Present Tooling CPC INR 0.62 /-.  
**Why2 :** A3 Center drill Scraping after reaching tool lifer & more wear out pattern is 60° angle in tool.

**ROOT CAUSE :-** A3 Center drill Scraping after reaching tool lifer & more wear out pattern is 60° angle in tool.

**REGISTRATION NO. & DATE:** 891 & 30.10.15  
**REGISTERED BY :-** Mr.Pujari  
**MANAGER'S SIGN :-** N.S.Pujari

**RESULT :-**



**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	-----	-----

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

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

CELL : A351	CELL NAME:- Drum Change	MACHINE / STAGE :- VMC/ Machining	OPERATION :- Operation No. 10
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**KAIZEN THEME :** To Prevent the Defect of A351 DGS In Operation-10

**WIDELY/DEEPLY:-**

**PROBLEM / PRESENT STATUS :-**In Operation 10 In-house defect may happen due to M6 Tap hole damage.



BEFORE

**IDEA :-** Quick Change Tap tool Holder To Be Use For Tapping Operation.

**COUNTERMEASURE:-** Used Quick Change Tap Tool Holder For Tapping Operation, No chance Of Tap breakage while Ø5.0 Drilling Operation Skip.

Quick Change Tap Tool Holder

Closed Condition

Open Condition

BEFORE

AFTER

BENCHMARK	3 Nos
TARGET	Zero
KAIZEN START	01.10.15
KAIZEN FINISH	20.11.15

**TEAM MEMBERS :-**  
N.S.Pujari, Shanth Kumar

- BENEFITS :-**
1. Prevent In-house Rejection.
  2. Save Tool Cost.
  3. Save tool Change time 148 min/Annum

KAIZEN SUSTENANCE

**WHAT TO DO:-** Ir-Reversible  
**HOW TO DO:-**.....  
**FREQUENCY :** 1 Time activity

**WHY - WHY ANALYSIS :-**  
**Why 1 :** In Operation 10 In-house defect may happen due to M6 Tap hole damage.  
**Why2 :** Due to Ø5.0 Drill Operation skip or breakge,M6 x 1 Tap will Break & hole get damage..  
**Why3 :** No Quick change Tap Tool Holder.

**ROOT CAUSE :-** No Quick Change Tap Tool Holder.

**REGISTRATION NO. & DATE:** 897 & 30.10.15

**REGISTERED BY :-** Mr.N.S Pujari

**MANAGER'S SIGN :-** N.S.Pujari

**RESULT :-**



COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
-----	-----	-----

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT				
SR. NO	CELL	TARGET	RESPONSIBILITY	STATUS
1.	-----	-----	-----	-----.