

TPM CIRCLE NO :- 2  
 TPM CIRCLE NAME : Joshile  
 DEPT :- Manufacturing Engg.

ACTIVITY  
 LOSS NO. / STEP  
 RESULT AREA

KK	QM	PM	JH	SHE	OT	DM	E&T
P	Q	DEF:- A	C	D	S	M	

CELL :-A479      CELL NAME:- Drum Change Line      MACHINE / STAGE :- DTC-300/Machining      OPERATION :- Facing, Drilling & Tapping

**KAIZEN THEME :** To Reduce the Tooling Cost Per Component of A479 DGS in OP#10.

**IDEA :-** Ø 2.97 mm Sc Drill Double Ended Cutting Edge tool to be introduce.

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Introduced both end cutting tool for Ø 2.97 mm Sc drill and per edge life is 7500 No's and tool cost is INR 1904/- & cost per component is INR .

**PROBLEM / PRESENT STATUS :-** Present Tooling Cost Per Component is INR 2.86/-

Ø2.97 mm End Mill single end tool

Ø 2.97 mm End Mill double end tool

<b>BENCHMARK</b>	2.86INR
<b>TARGET</b>	2.83INR
<b>KAIZEN START</b>	01.05.2016
<b>KAIZEN FINISH</b>	31.05.2016

**TEAM MEMBERS :-**  
 N.S.Pujari,  
 Mr. Praveen Jannu, Mr. Pradeep Kini

**BENEFITS :-**  
 1. Save INR 3247/- cost /Annum.

**KAIZEN SUSTENANCE**

**WHAT TO DO:** Revised the Master list of tooling by adding new both end tool  
**HOW TO DO:** Life over for one end then use another end  
**FREQUENCY :** ongoing activity

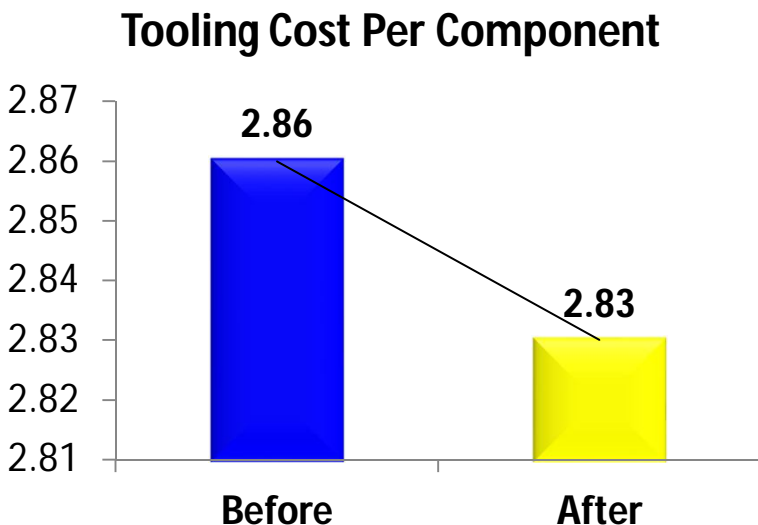
BEFORE

AFTER

**WHY - WHY ANALYSIS :-**

- Why1:** Present Tooling CPC is INR 2.86/-
- Why2:** Present Ø2.97 mm drilling CPC is INR 0.15/-
- Why3:** Present Ø2.97 mm End mill is single cutting Edge.

**RESULT :-**



**ROOT CAUSE :-** Present Ø 2.97 mm End mill is single cutting Edge.

**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	A351	31.07.16	M.E	Open

**REGISTRATION NO. & DATE:**1193 &15.06.16

**REGISTERED BY :-** Guru Basappa

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