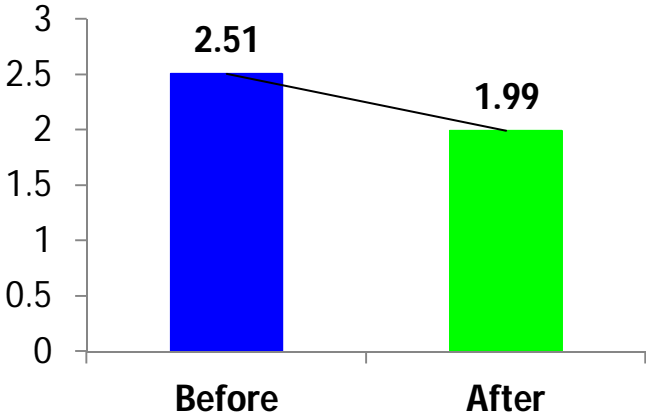
	TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T	<h1 style="margin: 0;">KAIZEN IDEA SHEET</h1>																		
	TPM CIRCLE NAME : Joshile	LOSS NO. / STEP																											
	DEPT :- Manufacturing Engg.	RESULT AREA	P	Q	DEF :- A	C	D	S	M																				
CELL :-A351	CELL NAME:- Drum Change Line	MACHINE / STAGE :- Winner / Widma					OPERATION :- Profile Groove Milling																						
KAIZEN THEME : To Reduce the Tooling Cost Per Component in Drum Change Cell.		IDEA :- Ø 7.1 Profile Grooving operation Tool i.e. Ø 7.1 End Mill should not scrap after reaching tool life.																											
WIDELY/DEEPLY:-		COUNTERMEASURE:- Started re-sharpening for Ø 7.1 mm End Mill. We can do re-sharpening two times. One time re-sharpening cost is INR 450/- And life is 85 % of original life i.e. 2550.																											
PROBLEM / PRESENT STATUS :- Present Tooling Cost Per Component is INR 2.51/-		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>BENCHMARK</td> <td>2.51 INR</td> </tr> <tr> <td>TARGET</td> <td>1.99 INR</td> </tr> <tr> <td>KAIZEN START</td> <td>18.08.2014</td> </tr> <tr> <td>KAIZEN FINISH</td> <td>19.08.2014</td> </tr> <tr> <td colspan="2">TEAM MEMBERS :-</td> </tr> <tr> <td colspan="2">Appasab Magadum, Praveen and Pujari</td> </tr> <tr> <td colspan="2">Pradeep Kini</td> </tr> <tr> <td colspan="2">BENEFITS :-</td> </tr> <tr> <td colspan="2">1. Save INR 3,38,520/- cost /Annum.</td> </tr> </table>										BENCHMARK	2.51 INR	TARGET	1.99 INR	KAIZEN START	18.08.2014	KAIZEN FINISH	19.08.2014	TEAM MEMBERS :-		Appasab Magadum, Praveen and Pujari		Pradeep Kini		BENEFITS :-		1. Save INR 3,38,520/- cost /Annum.	
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<div style="background-color: red; color: black; padding: 10px; border-radius: 15px; display: inline-block;"> Ø 7.1 mm End Mill not re-sharpening </div>		<div style="background-color: green; color: black; padding: 10px; border-radius: 15px; display: inline-block;"> Ø 7.1 mm End Mill re-sharpening established. </div>																											
BEFORE		AFTER																											
WHY - WHY ANALYSIS :- Why1: Present Tooling CPC is INR 2.51/- Why2: Present Ø 7.1 mm Groove Profile Milling CPC is INR 1.00/- Why3: Present Ø 7.1 mm Groove Milling operation Tool i.e. Ø 7.1 End Mill scrapping after reaching tool life.		RESULT :- <div style="text-align: center;"> <h3>Tooling Cost Per Component</h3>  <table border="1" style="margin: 10px auto; border-collapse: collapse;"> <thead> <tr> <th>Category</th> <th>Cost (INR)</th> </tr> </thead> <tbody> <tr> <td>Before</td> <td>2.51</td> </tr> <tr> <td>After</td> <td>1.99</td> </tr> </tbody> </table> </div>										Category	Cost (INR)	Before	2.51	After	1.99												
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ROOT CAUSE :- Present Ø 7.1 mm Groove Milling operation Tool i.e. Ø 7.1 End Mill scrapping after reaching tool life.		WHAT TO DO: Revised the Master list of tooling by adding re-sharpening of this Tool. HOW TO DO: Life over tool sent for re-sharpening. FREQUENCY : ongoing activity																											
REGISTRATION NO. & DATE : 162 & 19.08.14		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="3">COST INCURRED FOR MAKING KAIZEN</th> </tr> <tr> <th>MATERIAL COST IN RS</th> <th>LABOUR COST IN RS</th> <th>TOTAL COST IN RS</th> </tr> <tr> <td>-----</td> <td>-----</td> <td>-----</td> </tr> </table>										COST INCURRED FOR MAKING KAIZEN			MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS	-----	-----	-----									
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REGISTERED BY :- Guru Basappa		SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT																											
MANAGER'S SIGN :- Ravi Gouda		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>SR. NO.</th> <th>CELL</th> <th>TARGET</th> <th>RESPONSIBILITY</th> <th>STATUS</th> </tr> </thead> <tbody> <tr> <td>-</td> <td>-</td> <td>--</td> <td>--</td> <td>--</td> </tr> </tbody> </table>										SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS	-	-	--	--	--								
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