
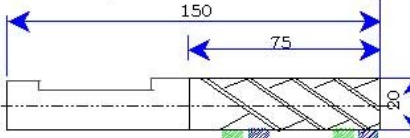
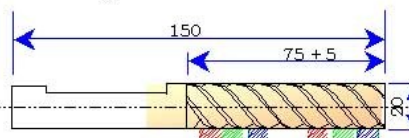







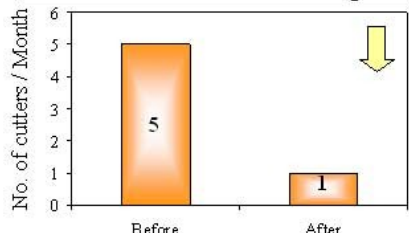


	5 th KAIZEN CONFERENCE	Activity	KK	JH	QM	PM	SHE	OTPM	DM	E&T	TM	 Brakes India Limited, Brake Division, Sholinghur.
	KAIZEN IDEA SHEET	Result Area					P	Q	C	D	S	
Dept / Unit	Tool Room	Equipment:	CNC Radial Shoe Milling Machine (SPM)						BI Plant No	BI - 1441 - 004		
1. Kaizen Theme : To Reduce the Tool (End Milling Cutter) Consumption							4. Idea :To increase the flute length					
2. Problem / Before improvement : Used in 2 Stages with out Coating 30° helix angle 				5. Countermeasure / After Improvement: Used in 3 Stages with TiN+TiAlN Coating 50° helix angle 				Bench Mark		5 Cutters / Month		
Stage 1  Stage 2  Unutilized Area 				Stage 1  Stage 2  Stage 3  Unutilized Area 				Target		1 Cutter / Month		
3. Analysis: (Why – Why Analysis): Tool Consumption was High, Why Tooling area used for 2 Stages, Why Tool was not utilized to it's full length, Why The Existing flute length is short,				6. Result: (Trend chart) Reduction in Cutter Consumption 				Kaizen Start		23 - 08 - 04		
								Kaizen Finish		15 - 02 - 05		
								Team Members: Mr. P.Baskaran, A.S.Balasubramanian, Annamalai, & M. Tamil selvan.				
								7. Benefits: Cost per component 		Cost Saving Rs.5.18 Lakhs / annum		
								Sandering Operation & the Operator Eliminated 		No. of Component Produced / Cutter		
								8. Scope & Plan for horizontal deployment:				
Sl no		Machine / Area		Tgt dt		Re sp.		Statu s				
-		-		-		-		-				