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Kaizen Theme:- Productivity improvement by using combination tool .

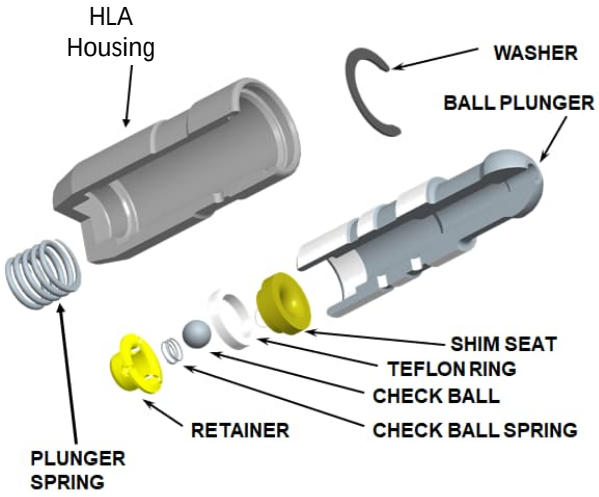
Date of Implementation:- 30.02.2024

Productivity ✓
Quality
Cost
Delivery
EHS

Total Productivity Improve- 85,96,224 Pcs

Company Introduction

Name: Schaeffler India Limited Pune
Product : Hydraulic Lash Adjuster (HLA)
Product Photograph & function :



The primary function of the hydraulic lash adjuster is to maintain zero tolerance of the valve on the engine.

Team Introduction

Name: Basavaraj Wagarale

Designation: Team Leader

Department: CNC Turning

Name: Dnyaneshwar Gawande

Designation: Team Leader

Department: CNC Turning

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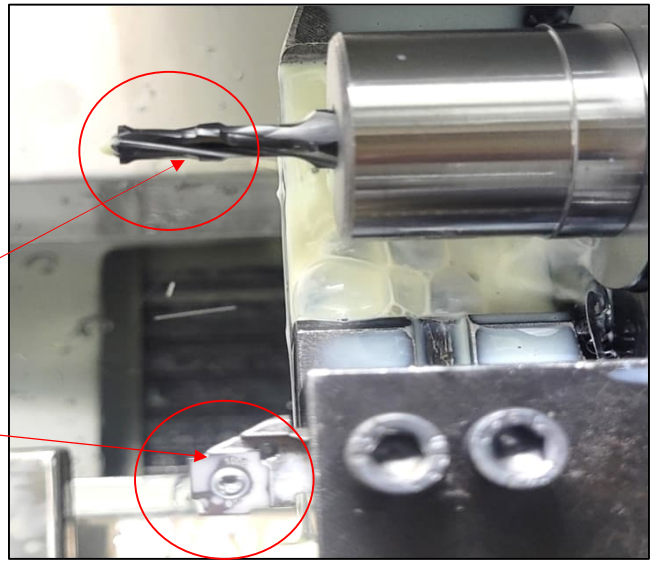
IMPROVEMENTS

BEFORE CONDITION

Two tools used for milling & facing operation

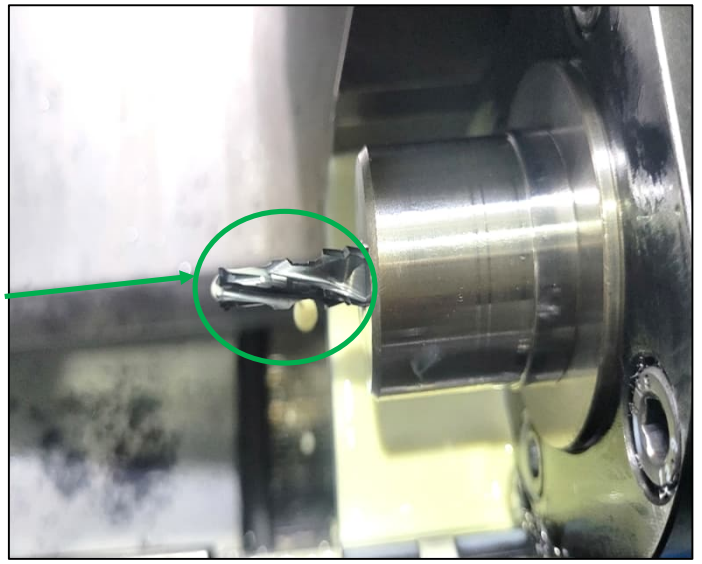


Two tools used for milling & facing operation Due to this following problems were occurred.

1. Cycle time (9 Sec) high for used two tools
2. Every Sunday run all turning machine due to high customer demand.
3. customer demand was not fulfilled.
4. Extra manpower for 24x7.
5. Extra electricity & bus transportation for Sunday working.

AFTER CONDITION

Combined operation in one tool used for milling & facing operation



Only one tool used for both milling & facing operation.
Due to this below points are improved

1. cycle time reduction by 1sec.
2. cost saving by eliminating facing tool.
3. productivity improvement by 8.8 %
4. Tool changing time decreased.
5. No Sunday working i.e., 24x6, electricity & bus transportation cost saved.
6. Fulfilled our customer demand

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Kaizen Presentation

BEFORE KAIZEN

Photograph/Video

Milling Tool

Facing Tool

Description= Using two tools for operation.

AFTER KAIZEN

Photograph/Video

Combined Tool

Description = Both tools are combined for operation.

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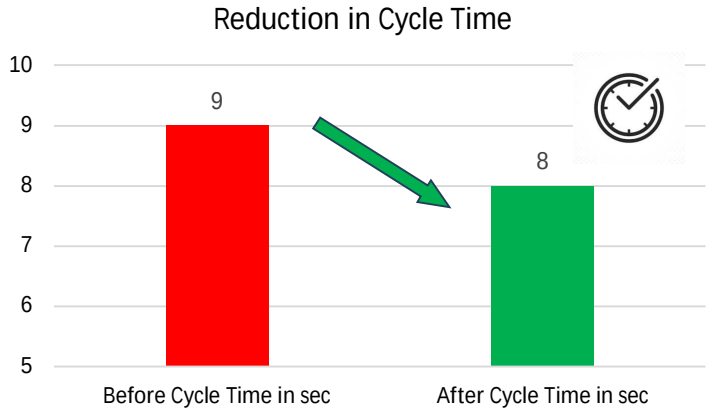
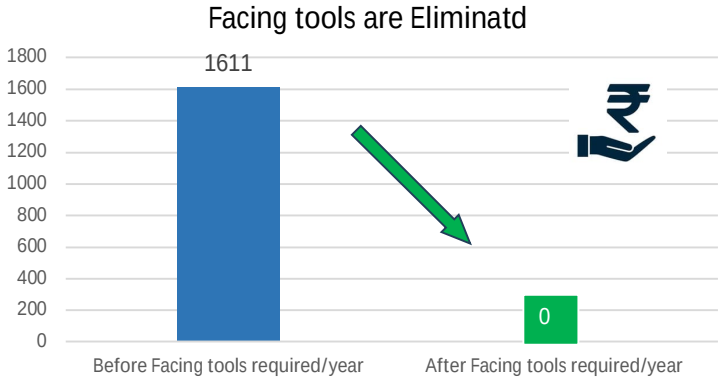
Kaizen Presentation

Benefits

Pls tick ✓ the benefits in below heads

Productivity up %				Quality			Cost Saving In Rs/month		Delivery			EHS			
Process	Material yield improvement	Space saving (sq. ft.)	Other	Rejection reduction (%)	Poka yoke	Others	Direct	Notional	Lead Time reduction	Customer delivery rating improvement	Others	Effect on Environment	Human Safety	Machine safety	Others
	✓						✓			✓				✓	





Horizontal deployment on 28 turning machines.

Cost Saving
1.58 Cr/ annum

Productivity
Improve- 85,96,224
PCS /annum

Calculation Sheet

Sr. No.	Description	Before	After	
1	Cycle time	9	8	Sec
2	Per min prod	6.6	7.5	Pcs.
3	Per day prod/ Machine	7,872	8,856	Pcs.
4	Prod from 28 machines/day	2,20,416	2,47,968	Pcs.
5	Monthly Productiuon	57,30,816	64,47,168	Pcs.

	Production increase in pcs/month	7,16,352	Pcs
	Production increase in pcs/year	85,96,224	Pcs
	Cost/piece	4.49	INR
	Sales increase/year	3,85,97,046	INR
	One machine Production /month	2,04,672	Pcs.
	One machine Production /annum	24,56,064	Pcs.
	28 machines Production /annum	6,87,69,792	Pcs.
	No of machines saved/Annum	3.5	Nos.
	Cost of 1 machine	40 Lac	
A	Cost of 3.5 machine	1.4 Cr.	
	Cost of one facing tool	1,200	INR
	No of tools saved/year	1,611	Pcs.
B	Cost saving	19,33,200	INR
C	Tool Development Cost	42,000	INR
A+B-C	Total Saving in Annum	1,58,91,200	INR
	Productivity Improvement	85,96,224	Pcs.

THANK YOU