**NARAYAN VASANT KHANKE** 

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**JOB OBJECTIVE**

Seeking Senior level assignments in Manufacturing / Project Management / Production Operations preferably in the Automobile / OEM sector/Auto Ancillary

**PROFILE SUMMARY**

* A highly competent professional with 30 years of experience in Production Operations, Quality & Process Enhancements and Team Management.
* Currently working with Shriram Foundry Ltd ,Zanvar Group Of Industries Kolhapur as a Plant Head For Unit No-1

Looking after Kirloskar ,Cummins,Johndeer Crank case Line Machining Plant. Total 6 Machining lines ,SL90/6R1080/4R1040/4K/K16/QSK60 Models.Handling Team of @300 nos & 30 Engineers.Responsible for complete PLM of Plant, Tooling, Purchase, Capex, New Product Development. All CNC Marching MAZAK, MAKAINO,BFW, DOOSAN,HMC/VMC

Started from Jan-2020.

* Recently worked as a Plant Head ( General Manager) to Mutha Group Satara Handling 2 Plants Independently.H25 & H21 8/03/2019 to 19/08/2019 .

Also associated with HPDC New components development for FML ,TML

* Was Associated with Firodia Group JAYAHIND INDUSTRIES from May-2014 to Jan-2018 as a Dy.Divisonal Manager CNC Machine Shop. Working as a In charge for all machining activities. **Total 54 CNC machines + Impregnation Plants**.

**HPDC-2 +New Machine Shop for Getrag/Export**

* Development of all new components for Mahindra /Ford/Cummins/Tata Motors/Eicher /Daimler/FML. Responsible for archiving daily /monthly production targets/quality norms/Kaizen /TPM activities/ for the entire machine Shop.
* **Development & Production line set up for Mahindra KUV 100 Crank Case Ford Crank case & Cylinder Head Line.**
* **F**rom July-2011 to May-2014 associated with MCD for Bharat Forge Ltd., Baramati Plant as Senior Manager (Production) for Indian railway crank shaft Project EMD/DLW/.ALCO. First time in Indian history 5 Mts.. crank shaft (BFL) supplied for our locomotive.
* Proficiency in implementing the production planning and efficiently managing the total work for getting higher production with higher yield
* Adept at process controls, quality management, regulating operations parameters, implementing preventive maintenance practices in plant & TPM as to achieve maximum productivity
* Deft in implementing cost saving measures to achieve substantial reduction in terms of man days, production cost, raw materials and energy consumption.
* **New line set up for R1040 cy.head & Crank Case in KOEL.**
* Ensuring compliance to quality standards and maintaining all related documents
* Dexterous in implementing the quality standards in production operations
* An effective leader with excellent people management skills

**CORE COMPETENCIES**

Production Operations Team Management Process & Product Development

Quality Assurance Operations & Maintenance Commissioning Activities

Cost Control Resource Optimisation Training & Development

**ORGANISATIONAL EXPERIENCE -**

**From 8/3/2019 Joined as a Plant Head(General Manager) to Mutha Group Satara. Responsible for 2 Units Of H25 & H21 as a Operational Heads.**

**Handling Team of almost 700 nos.+80 Managers/engineers/Supervisors/AM/DM/Officers.**

**Total no of work stations / Machines handled—156 nos all CNC/VMC/HMC/SPM/GPM/Leak Testing.**

**Responsible for P&LR of Both the Plants.PQCDSM.**

**May’2014 – Jan’18 Jayahind Industries Ltd, Pune as a** **Dy. Divisional Manager (CNC machine shop)**

**Role and Highlights:**

* Daily/weekly/Monthly/Quarterly achievement as per the production plan. Monthly almost supplying 60000 machined components to various customers. Ford/Mahindra/TML/Maruti/Cummins/Eicher/Daimeler/Force Motors.
* Continuous improvement to reduce breakdown /daily rejection rework/OEE/operation cost/cycle time/cutting tool cost/set up time reduction by doing various process improvements.
* **Set up new line for Mahindra S101 Crank case & Bed plate For KUV100 & TUV 300 Car. At present capacity 90 per day.**
* **I**nvolvement of people in Kaizen /TPM /Six sigma Cultre/SPC.
* New Product Development for Cummins FW HSG. 100% Export Per Month 2500.
* Ladder Frame Development for FORD 100% export to 6 countries.
* Maintain & improve the OEE of critical Machines to 85 to 95%.
* Development of New components for Mahindra Automotive/Tata Motors/Fprd /Eicher.
* Maintain & reduce 8000 PPM to 2000 PPM for In-house machining & 100 PPM at customer end.
* Jig fixture maintenance /development of new tooling & trials for Productivity & Process Improvement.
* Single piece flow for Ford Block.
* Machines look after Mazak 6800/Mazak Nexus 5000/BFW HMC 440/VMC Chakara/Unicorn./VTC/BFW Dhruva.

**Jul’11 - May’14 Bharat Forge Ltd.(Baramati Plant) as a Senior Manager (Production)**

**Role and Highlights:**

* Reduced manpower in HHP Crank Shaft Line from 195 to 178.
* Developed & production line set up for DLW/ EMD crank shaft for Indian Railways .new crank shaft development for
* American Locomotive co of 4.3 mts. In length.
* Played a major role in reducing cycle time on Pin & Journal Grinding machine from 3.5 hrs to 1.5 Hrs.
* Efficiently reduced:
  + Setup change time on PAD Milling Machine from 8 hrs to 4.00 Hrs
  + Machining rejection of Cranks Shafts from 3.5 % to 1.90%
  + Crank Shaft Inspection Time.
  + Number of setup for models.
* Successfully sustained presently available technologies like:
  + CBN Grinding TOYODA machines
  + HMC & VMCs
* Introduced new Technology to monitor suitability of " CREEP FEED GRINDING" for Pin & Journal grinding
* Developed "Combination Graded Grinding wheels" for Pin & Journal for better surface finish.
* Identified atomization in "Oil-hole polish" operation (Robot application)
* Successfully set-up:
  + Manufacturing of Non-Auto Crankshafts ranging from 2.00 Mtrs. to 5.00 Mtrs.
* QSK-60 Cummins Crankshaft
* **Handling Modern machine shop (*DMG* MORI and Hyundai having *control* Heidenhain & Fanuc)**
* **Handling of WFL 5- Axis Mill turn MACHINES /5-Axis WIDMA MACHINES.**
* Significantly saved energy by training the officials on the same and transforming the existing equipment
* Distinguished efforts towards the production of Tata Cummins CrankShaft (Die. No. 2470) in MAN Line
* Utilized Perkins Crank Shaft Die No. -3337 for off Highway Engines with the same HHP Line.
* Extensively undertook the transport cost initiative by replacing Nilesimense Machine with CNC Machines
* Effectively diminished machine hour by reducing:
  + No. of set ups for GES/ FWS drilling tapping on BFW HMC
  + Time from 10 hours to 4 hours
  + No. of set up from 10 to 6 per month
* Entrusted with the responsibility of offering trainings in order to:
  + Improve Capability of Managers & Engineers
  + Enhance Cutting Tool Life of costly equipment
  + Comprehend MQPs

**Jan’96 – Jul’11 Kirloskar Oil Engines Ltd., Pune as a Manager (HA Machine Shop) (15.5 years)**

**Growth Path**

Jan’96 – July-’03 Senior Engineer

Aug-’03 – ’July-07 Deputy Manager

Aug-’07 –July-’09 Manager Machine Shop

Aug-’09 – Jul’11 Unit Manager HA Machine Shop

**Key Result Areas**

* Involved in the updation of Transformation Cycles, Process FMEA and related Control Plan
* Provided support in the development of new processes including sharing of technical requirement to coordinating design with suppliers
* Executed lean manufacturing initiatives like TPM, 5S, etc.
* Ensured the reduction in ETU costs / O.E.E. implementing Kaizens, TPM, QC and 5S
* Managed the production schedules, raw materials standardization and distributed work to the team for achieving monthly production targets
* Took care of HA Machine Shop R1040 **Cylinder Head Line**, HA & 4R1040 Crankshaft Line, Cam Shaft Line, DV Crank Shaft Line and FMEA & PPAP for Crankshaft
* Carried out the upgradation of Conventional Angular & Toyoda Grinder for crankshaft grinding through low cost automation projects

**Highlights**

* Essayed a stellar role in executing New Line Layout for Crankshaft of 4R1040 Series, R1040 Cylinder Head Line, Cam Shaft Line, DV Crank Shaft Line and HA Crank Case Line Engines
* Instrumental in enhancing the Crank Shaft Line Productivity by 30% i.e. from 100 to 130 Crankshaft per day
* Significantly contributed in the reduction of the rejection of Crank Shaft Line to 2600 from 5200 ppm
* Received the Excellent Performance Award for years 2002-03, 2003-04 and 2008 .
* Par Excellent Award in National Convention for Quality Circles Fourm of India at Bangalore 2009
* Won the Silver Award in International Convention for Quality Circles at Hyderabad-2010
* Dexterously designed cost reduction crank case casting
* Holds distinction in the proving of:
  + **New R1040 Cylinder Head/Crank Case & Cylinder Block.**
  + TOYODA CBN Crank Pin/Journal Two-Wheel Grinding Machine
  + Integral Balance Weight Crank Shafts & Productions Online
  + 4R810 Series Crank Shaft Online
  + DV Series Crankshaft Online
* Efficiently commissioned for Tal/Toyoda CBN Journal-Pin Orbital Grinder, Super Finishing, Oil Hole Drilling S.P.M. and Abro Dynamic Balancing
* Undertook productivity improvement techniques on:
  + JTEKT Toyoda Grinder by reducing set up time from 2.5hrs to zero
  + Crankshaft Line by layout improvements & machine clubbing
* Dexterously implemented:
  + Traverse grinding for 4/6 cylinder crank shaft grinding by modifying the programme
  + Single oil hole drilling for Crankshaft instead of short oil / long oil hole
* Resourcefully replaced the:
  + New Controller with old IFA Induction Hardening Machine to reduced breakdown & save electrical energy
  + Old Electrical Panels by new ones to avoid breakdowns & save energy
* Bagged the HA Crank Shaft/Cylinder Head Line Award and achieved ‘2S’ certification from Qualicon Services, Pune
* Effectively handled DAP for Crankshaft Cinetic Landis LT1 Grinder, Micromatic Ace Angular Wheel Head Grinder, IEPL High Frequency Induction Hardening Machine and AMS Machining Centre for DV Series Crank Shaft (please confirm)
* Developed & designed the RA Crankshaft Line in Amul Crank at Rajkot, RV 33 Cylinder Block, Menon & Menon AND Kolhapur – Kirloskar

**PREVIOUS EXPERIENCE**

**Aug’92 - Dec’95 Greaves Company Ltd., Aurangabad as Sectional Engineer**

**Aug’89-Aug’92 Bajaj Auto Ltd., Waluj as Assistant Engineer**

**Aug’85-May’86 Mahindra & Mahindra Ltd., Mumbai as Trainee Engineer**

**EDUCATION**

1989 B.E. (Production) from J.N.E.C., Aurangabad, Marathwada University in with **73%** **(Distinction)**

1985 Diploma in Mechanical Engineering from K.J. Somaiya Polytechnic, Mumbai, M.S.B.T.E. with **70.71% (Distinction)**

**CERTIFICATIONS**

* CII Six Sigma Green Belt Certification Course

**KNOWLEDGE PURVIEW**

* CNC Machining, Work on MAZAK,MAKINO,BFW, HMC/VMC, WFL MILL TURN 5 mts., NAXOS 5 mts. Orbital Grinder, Landis, Fortuna, Gendron, Fanuc, Boringer, Toyada, Mazak, NTC, New Machine Commissioning, etc.
* 5 S, Kaizen, Quality Circle Activities, TPM and JIT

**TRAINING**

* One-month Course for management training from Kirloskar Institute of Management (Harihar) for Young Executives

**IT SKILLS**

* Oracle R11i WIP Module, MS Office & Windows 2000

**PERSONAL DETAILS**

Date of Birth: 29th March, 1967

Address: Sandhya Nagari, A-2/4, Vishal Nagar, Jagtap Dairy, Pimple Nilakh, Aundh Camp, Pune – 411027

Languages Known: English, Hindi & Marathi

Salary : Negotiable.

Passport -- N9857461 From - 17/06/2016 to 16/06/2026 PUNE