

| | | | | | | | | | |
|--------------------|-----------------|----|----|--------|----|-----|----|----|-----|
| TPM CIRCLE NO :- 3 | ACTIVITY | KK | QM | PM | JH | SHE | OT | DM | E&T |
| TPM CIRCLE NAME : | LOSS NO. / STEP | | | | | | | | |
| DEPT :- Q.A | RESULT AREA | P | Q | DEF:-A | | C | D | S | M |

| | | | |
|--------------|-----------------|---------------------------|----------------------|
| CELL :- A247 | CELL NAME:- BKT | MACHINE / STAGE :- SPM A1 | OPERATION :-Drilling |
|--------------|-----------------|---------------------------|----------------------|

KAIZEN THEME -To Avoid A247 BKT M5 tap broken

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS - A247 BKT M5 tap broken



BEFORE

IDEA :- Lock nut to be tight .

COUNTERMEASURE :

- 1)Lock nut tight.(Collet type design to be introduce)
- 2)Check point added in PM check sheet
- 3)Every Saturday spindle run out to be checked by supervisor & Maintenance will work on Sunday .
- 4)Weekly checking plan prepared
- 5)Spindle head to replaced with Auram KTK make spindle .

AFTER

WHY - WHY ANALYSIS :-

Why 1 – A247 BKT M5 tap broken.

Why 2 - 4.2 Drill not rotate concentric .

Why 3 –0.35 Play observed in 4.2 drill spindle.

Why 4 –Lock nut loose .

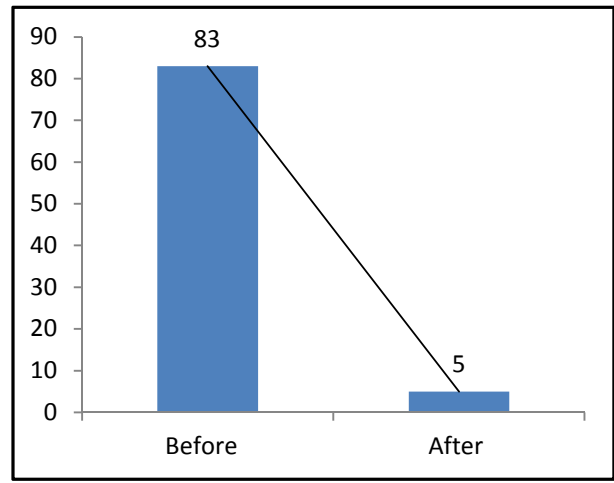
ROOT CAUSE- Lock nut loose .

REGISTRATION NO. & DATE:- 25.05.2015

REGISTERED BY :- Ganesh Padwalkar

MANAGER'S SIGN :- Sunil kinkar

RESULT :-



| | |
|----------------------|------------|
| BENCHMARK | 83 No. |
| TARGET | 0 No. |
| KAIZEN START | 25.07.2015 |
| TARGET DATE | 30.09.2015 |
| KAIZEN FINISH | 02.08.2015 |

TEAM MEMBERS :-
 Nana Ugale, Vishal Chougule.,
 Vijay Walunj, Ganesh Padwalkar

- BENEFITS :-**
1. Prevent Re-occurrence of Customer Complaint.
 2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO- Check Point added in Supervisor check sheet .

HOW TO DO: Play,runout checked with dial

FREQUENCY : Once in week

COST INCURRED FOR MAKING KAIZEN

| MATERIAL COST IN RS | LABOUR COST IN RS | TOTAL COST IN RS |
|---------------------|-------------------|------------------|
| ----- | ----- | ----- |

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

| SR. NO. | CELL | TARGET | RESPONSIBILITY | STATUS |
|---------|--------|-------------|----------------|--------|
| 1 | BKT B1 | 02.08. 2015 | Vishal | C |