

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

**KAIZEN THEME** –To Avoid A247 BKT Inside dia 5 Counter hole face damage

**IDEA :-** Gear box to be restore .

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:** 1) Gear box changed.2) Provide air purging to avoid coolant entry into bearing.

**PROBLEM / PRESENT STATUS** –A247 BKT Inside dia 5 Counter hole face damage



Play in spindle 0.35 mm

**BEFORE**

Play in spindle 0.005 to 0.008 mm

**AFTER**

<b>BENCHMARK</b>	128 No.
<b>TARGET</b>	0 No.
<b>KAIZEN START</b>	08.12.2014
<b>TARGET DATE</b>	02.02.2015
<b>KAIZEN FINISH</b>	01.02.2015

**TEAM MEMBERS :-**  
Vishal chowghule , Nana Ugle ,  
Vijay Walunj ,Nitin sutar

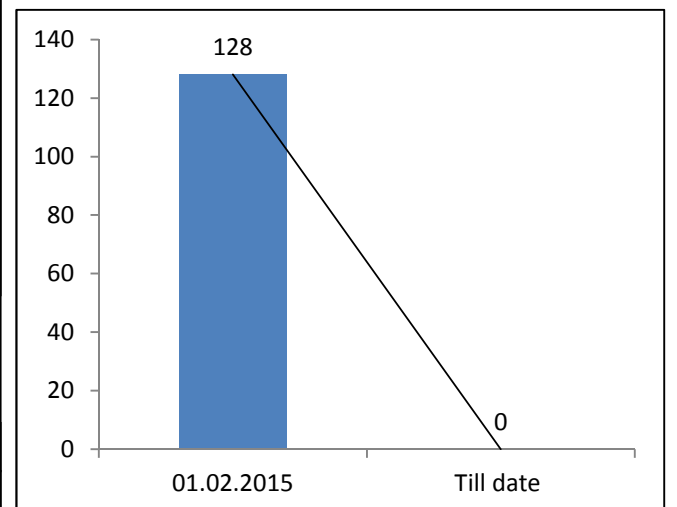
- BENEFITS :-**
1. Prevent Re-occurrence Defect.
  2. Reduce COPQ.

**KAIZEN SUSTENANCE**

**WHAT TO DO-** Check point added in fixture maintenance check sheet .  
**HOW TO DO:** By checking  
**FREQUENCY :** Once in month

**WHY - WHY ANALYSIS :-**  
**Why 1** – A247 BKT Counter hole face damage.  
**Why 2** - 4.2 Drill not rotate concentric  
**Why 3** –0.35 Play observed in 4.2 drill spindle (Req.20 mic).  
**Why 4** –Gear box housing wear out ( Gear box ID required 47 & actual 47.5mm ) .

**RESULT :-**



**ROOT CAUSE-** –Gear box housing wear out

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**REGISTRATION NO. & DATE:- 08.12.2014**  
**REGISTERED BY :- Ganesh Padwalkar**  
**MANAGER'S SIGN :- Sunil kinkar**

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	BKT SPMB1)	03.02.15	Nana ugle	Completed