

CELL :- A247 CELL NAME:- BKT MACHINE / STAGE :- SPM B2 OPERATION :- Tapping.

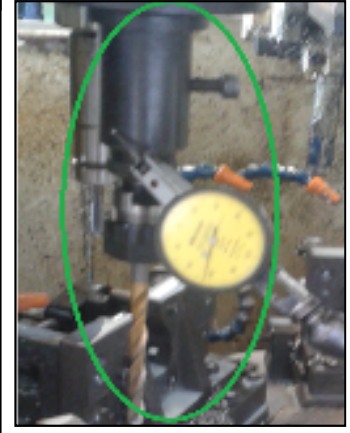
KAIZEN THEME –To avoid A247 BKT M8x1.25 Tapping oversize (SPM B2)

IDEA :- 1)Spindle to be change .

WIDELY/DEEPLY:-

COUNTERMEASURE:
1) Spindle changed .

PROBLEM / PRESENT STATUS –A247 BKT M8x1.25 Tapping oversize



BENCHMARK	88 No.
TARGET	0 No.
KAIZEN START	03.09.2014
TARGET DATE	15.04.2015
KAIZEN FINISH	26.04.2015

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

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

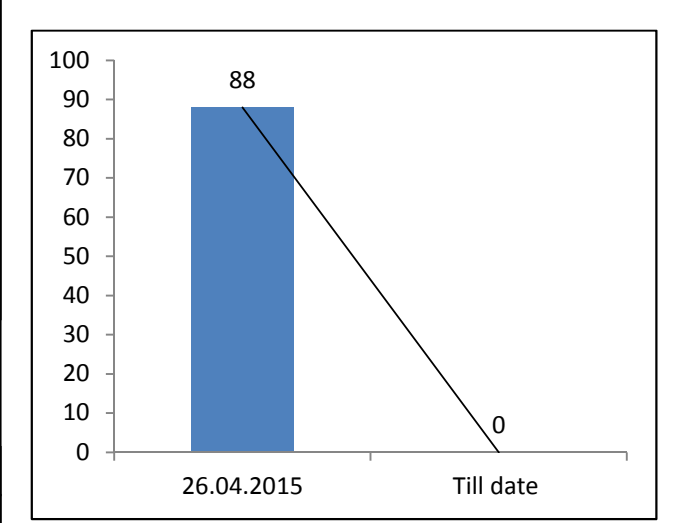
BEFORE Spindle Inside dia maintained 15.99-16.01 **AFTER**

KAIZEN SUSTENANCE

WHY - WHY ANALYSIS :-

- Why 1** – A247 BKT M8x1.25 Tapping Oversize .
- Why 2** – Drill size having oversize 6.994 (Minor dia for M8 tapping require 6.647 to 6.912) .
- Why 3** – Play between spindle & holder .
- Why 4** – Spindle inside dia oversize spec 16.01 actual 16.1mm.

RESULT :-



WHAT TO DO- Check point added in PM check sheet .

HOW TO DO:-Check with vernier

FREQUENCY : Once in month

COST INCURRED FOR MAKING KAIZEN

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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REGISTRATION NO. & DATE:- 03.09.2014

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

REGISTERED BY :- Ganesh Padwalkar

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-	A2 BKTSPM	20.05.15	Vishal choughule	Inprocess

MANAGER'S SIGN :- Sunil kinkar