

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

KAIZEN THEME –To avoid A247 BKT M8x1.25 Tapping Oversize

WIDELY/DEEPLY:-

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



Holder to key face distance 17.7mm

BEFORE

IDEA :- 1) Wood ruff key to be replaced & reduce gap

COUNTERMEASURE:

- 1) Wood ruff key replaced & reduce gap
- 2) 100 % Checking started .
- 3) After setting of holder , holder should be true .



Holder to key face distance 18.00mm

AFTER

WHY - WHY ANALYSIS :-
Why 1 – A247 BKT M8x1.25 Tapping Oversize .
Why 2 – Drill size having taper on top side 6.994 & bottom side 6.89 (Minor dia for M8 tapping require 6.647 to 6.912) .
Why 3 – Holder run out 1mm (Spec 0.02mm) .
Why 4 –Clearance between Spindle ID & Holder with key is 0.7mm.

ROOT CAUSE- – Clearance between Spindle ID & Holder with key is 0.7mm.

REGISTRATION NO. & DATE:- 03.09.2014

REGISTERED BY :- Ganesh Padwalkar

MANAGER’S SIGN :- Sunil kinkar

RESULT :-

Currently 100 % checking for M8 tapping

BENCHMARK	88 No.
TARGET	0 No.
KAIZEN START	03.09.2014
TARGET DATE	10.09.2014
KAIZEN FINISH	10.09.2014

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

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

KAIZEN SUSTENANCE

WHAT TO DO- Point added in Fixture maintenance 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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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-	BKT	12.09.14	Nana	Comp leted