

TPM CIRCLE NO :- 02	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME:	LOSS NO. / STEP								
DEPT :-	RESULT AREA	P	Q	A		C	D	S	M

**CELL:-** CELL NAME:- Bracket SPM      **MACHINE / STAGE :-** A247 Bracket      **OPERATION :-** Drilling 4.2mm

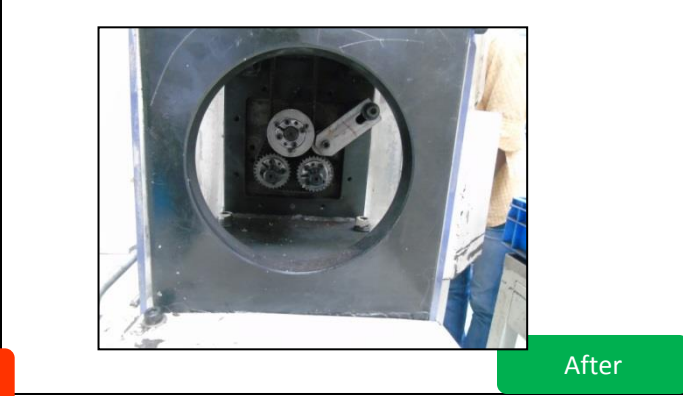
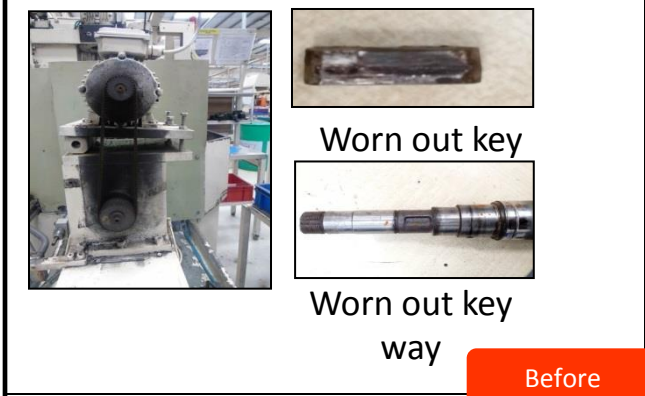
**KAIZEN THEME :** To eliminate spindle breakdown on Bracket SPM machine – A1

**IDEA :** No metal to metal contact

**Problem present status :-** 4.2 mm drilling Spindle breakdown. Occurrence 4nos / month

**COUNTERMEASURE:-**  
Replacing gear drive & key mechanism with modified Shaft & Taper locking pulley

<b>BENCHMARK</b>	B/d 4 nos/ month
<b>TARGET</b>	0
<b>KAIZEN START</b>	20.02.2016
<b>KAIZEN FINISH</b>	30.05.2016



**TEAM MEMBERS :**

- Prakash Harihar
- Sujit Zirpe

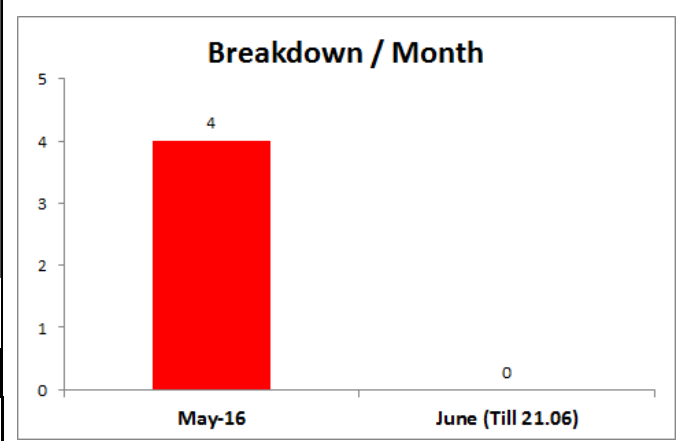
**BENEFITS :-**

- MTBF increased from 7.5 Days to life time (PM planned @ 1 Year)
- Breakdown cost saved

**WHY - WHY ANALYSIS :-**

Why 1 – 4.2 mm drilling spindle break down  
 Why 2 – Drill broken  
 Why3 – Interruption in cutting speed  
 Why 4 – Play in transmission gear  
 Why 5 – Key between shaft& gear wear and tear.  
 Why 6 – Forced deterioration due to metal contact.

**RESULT :-**



**KAIZEN SUSTENANCE**

**ROOT CAUSE :** Metal to Metal contact

**WHAT TO DO:-** Bearing replacement.

**REGISTRATION NO. & DATE :**

**HOW TO DO:-** During PM

**REGISTERED BY :-** Prakash & Sujit

**FREQUENCY :-** @ 12 months

**MANAGER'S SIGN :-** SNC

Scope & Plan for Horizontal Deployment				
Sr no	Model	Target Date	Responsibility	Status
1	B1	10.08.16	prakash & Sujit	In-process