

CELL :-A479      CELL NAME:- Drum Change Line      MACHINE / STAGE :- DTC-300/Machining      OPERATION :- Facing , Drilling & Tapping

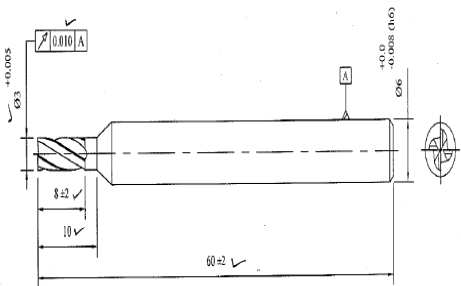
**KAIZEN THEME :** To prevent the defect of Ø3.0 Hole Over size in A479 DGS (OP#10).

**IDEA :-** Tool size to be revised Ø3.005 mm to Ø2.97 mm.

**WIDELY/DEEPLY:-**

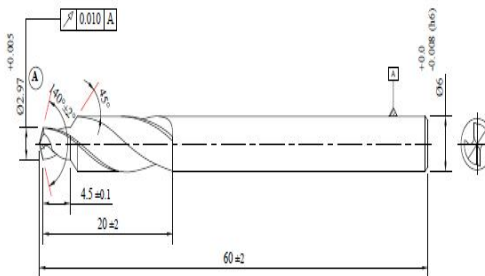
**COUNTERMEASURE:-** To Change the tool specification Ø3.0 05mm Hole mill to Ø2.97 Sc drill. & now we are achieving component hole size Ø3.0mm.

**PROBLEM / PRESENT STATUS :-** Ø3.0±0.01 mm hole size is more then specification 0.015mm.



Ø3.0+0.005 Hole Mill

BEFORE



Ø2.97+0.005 Sc Drill

AFTER

<b>BENCHMARK</b>	4%
<b>TARGET</b>	0%
<b>KAIZEN START</b>	15.05.2016
<b>KAIZEN FINISH</b>	15.06.2016

**TEAM MEMBERS :-**

**N.S.Pujari,**  
 Mr. Praveen Jannu. Mr. Chamaraj

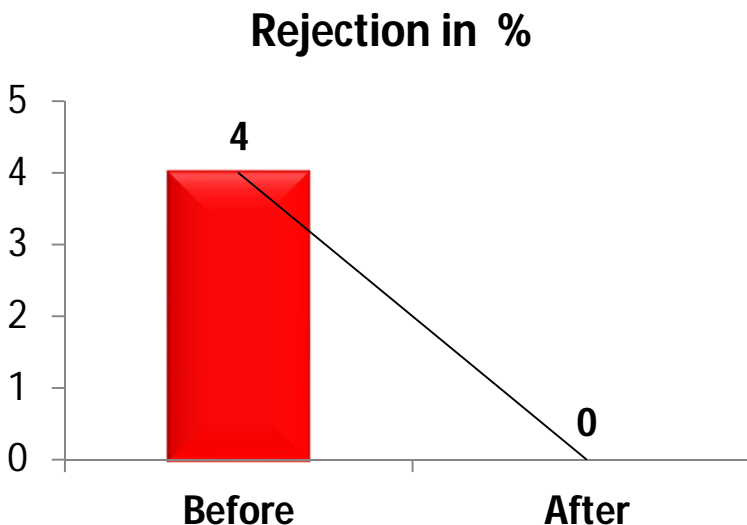
**BENEFITS :-**

1. Reduce C.T 51 Sec to 49 Sec.
2. Increase Out Put/Hour 70 Nos to 73 Nos
3. Save INR 14072/- cost /Annum.
4. Save (Ø2.99 Sc drill )Tooling Changing time 88 min /Year

**WHY - WHY ANALYSIS :-**

- Why1:** Ø3.0±0.01 mm hole size is more then specification 0.02mm.
- Why2:** Tool size is Ø3.025mm including tool run out.
- Why3:** Tool size is Ø3.005 mm .

**RESULT :-**



**KAIZEN SUSTENANCE**

**WHAT TO DO:** Revised the PCP,CP & Master list of tooling,  
**HOW TO DO:** ---  
**FREQUENCY :** Ir-reversible

**ROOT CAUSE :-** Tool size is Ø3.005 mm .

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**REGISTRATION NO. & DATE:**1162 &15.06.16

**REGISTERED BY :-** Guru Basappa

**MANAGER'S SIGN :-** N.S.Pujari

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO	CELL	TARGET	RESPONSIBILITY	STATUS
-	-	-	-	-