

CELL:- oil pump CELL NAME:- A372 Body MACHINE / STAGE :- VMC brother OPERATION :- face milling, reaming

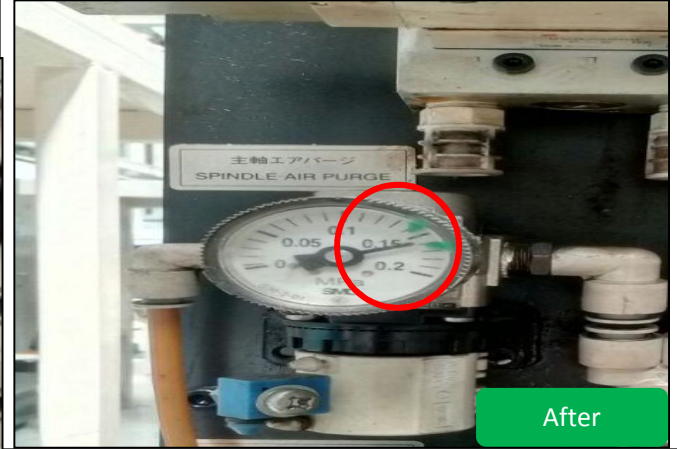
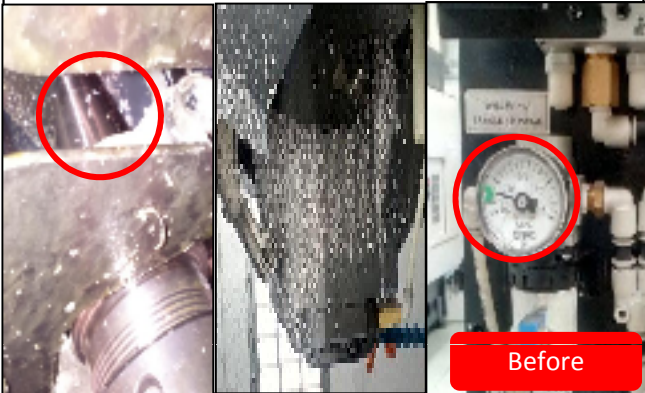
KAIZEN THEME : To eliminate A372 body depth u/s 7+0.03/+0.06 actual found 6.980 mm.

IDEA :- Spindle air pressure to be increased 0.05 bar to 0.15 bar

Problem present status :-A372 Body 7+0.03/+0.06 depth u/s, actual-6.980

COUNTERMEASURE:-
1. Spindle air pressure to be increased

BENCHMARK	48 no's
TARGET	0 no
KAIZEN START	16.03.2016
TDC	18.03.2016
KAIZEN FINISH	18.03.2016



TEAM MEMBERS : Ganesh Padwalkar, Ashish Jagtap, Navnath Karanjkhile, Umesh pimple, sachin kadnar

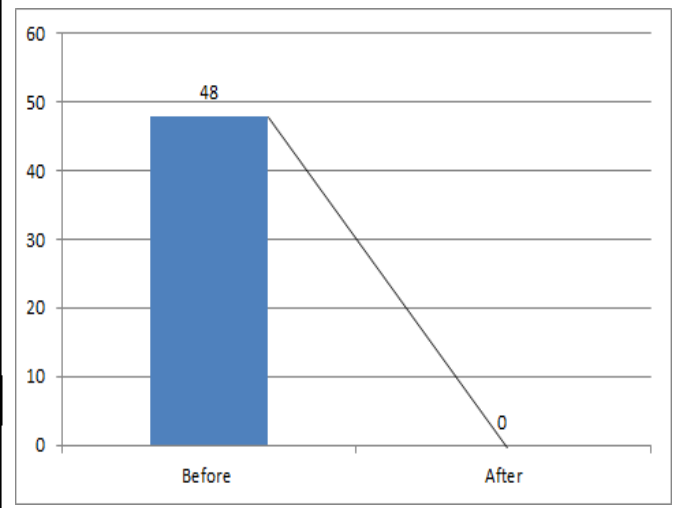
BENEFITS :-
1) In-house rejection eliminated.

WHY - WHY ANALYSIS :-
Why1 :- A372 body depth u/s.
Why2 :- Excess milling face cut
Why3 :- Milling cutter clamp in holder towards downwards direction
Why4 :- Burr present on milling holder taper area.
Why5 :- Burr not cleaned at current spindle air pressure .

RESULT :-

KAIZEN SUSTENANCE

ROOT CAUSE : Burr not cleaned at current spindle air pressure .



WHAT TO DO:- Check point added in JH check sheet . .

HOW TO DO:- Check visually.

FREQUENCY :- Daily .

REGISTRATION NO. & DATE : 16.03.2016

REGISTERED BY :- Sachin kadnar

MANAGER'S SIGN :- Sunil Kinkar

SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	All VMC	TARGET	YUVRAJ Desai	Completed