

CELL :- A215	CELL NAME:- Drum change	MACHINE / STAGE :- Grinding (Micromatic -1)	OPERATION :-Grinding.
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KAIZEN THEME –To avoid A215 Drum Gear Dia. 10-0.015 -0.03 mm undersize. actual observed 9.960---9.968 .

WIDELY/DEEPLY:-

PROBLEM / PRESENT STATUS –A215 Drum Gear Dia. 10-0.015 -0.03 mm undersize. actual observed 9.960---9.968 .



BEFORE

IDEA :- Repeatability to be corrected.

COUNTERMEASURE: 1) Repeatability to be corrected .
 2) CP ,CPK study conducted observed 0.27 .
 3) Out side operation transfer to another Machine as Microsmatic 1 to Microsmatic 2
 4)Micromatic2 - machine spc done & found ok (1.63)

BENCHMARK	70 No.
TARGET	0 No.
KAIZEN START	02.03.2015
TARGET DATE	15.03.2015
KAIZEN FINISH	

TEAM MEMBERS :-
 Ganesh Padwalkar ,vijay walunj,
 Yuvraj Desai, Someshwar Salunke

- BENEFITS :-**
1. Prevent Re-occurrence of Customer Complaint.
 2. Reduce COPQ.

KAIZEN SUSTENANCE

WHAT TO DO- Point added in PM check sheet .

HOW TO DO: By Dial
FREQUENCY : Once in month

WHY - WHY ANALYSIS :-
Why 1 – A215 Drum Gear Dia.10.0 undersize .
Why 2 – Operator Give offset 0.04 mm & machine take 0.01 mm .
Why 3 – Y axis repeatability not ok.(spec 0.006 & actual observed 0.02mm)

ROOT CAUSE- – Y axis repeatability not ok

REGISTRATION NO. & DATE:- 02.03.2015

REGISTERED BY :- Ganesh Padwalkar

MANAGER’S SIGN :- Sunil kinkar

RESULT :-

Currently Stop machining of A215 on Micromatic 1 & Transfer on Micromatic 2

COST INCURRED FOR MAKING KAIZEN		
MATERIAL COST	LABOUR COST	TOTAL COST
IN RS	IN RS	IN RS
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SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
-		NA		