

**CELL:-** Oil pump      **CELL NAME:-** A206 Body      **MACHINE / STAGE :-** VMC brother      **OPERATION :-** face milling, reaming

**KAIZEN THEME :** To eliminate A206 body chatter mark

**IDEA :-** Resting bolt to be locked top eliminate chatter mark .

**Problem present status :-** A206 Body chatter mark

**COUNTERMEASURE:-**  
1. Resting bolt to be changed as locking to be provided to eliminate chatter mark defect .

<b>BENCHMARK</b>	45 no's
<b>TARGET</b>	0 no
<b>KAIZEN START</b>	15.03.2016
<b>TDC</b>	20.04.2016
<b>KAIZEN FINISH</b>	



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

**BENEFITS :-**  
1) In-house rejection eliminated.

**WHAT TO DO:-** Check point added in Sustenance audit check sheet . .

**HOW TO DO:-** Check visually.

**FREQUENCY :-** Alternate day .

**WHY - WHY ANALYSIS :-**

**Why1 :-** A206 body chatter mark.  
**Why2 :-** Part get vibrate during machining .  
**Why3 :-** Gap observed between resting bolt face & part face  
**Why4 :-** Resting bolt loose  
**Why5 :-** No locking of bolt.

**RESULT :-**

Currently adjust bolt height & check 100 %

**KAIZEN SUSTENANCE**

**ROOT CAUSE :** No locking of bolt.

**REGISTRATION NO. & DATE :** 15.03.2016

**REGISTERED BY :-** Sachin Kadnar

**MANAGER'S SIGN :-** Sunil Kinkar

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1	A260	20.4.16	Nitin Sutar	Pending