

BASIC KNOWLEDGE

IMPROVEMENT
CASE

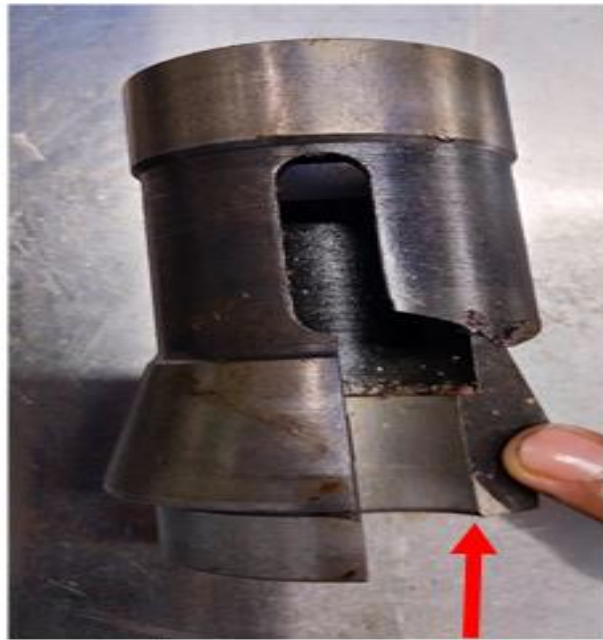
TROUBLE CASE

PREPARED BY:
Mr. Dethé Shashikant s

APPROVED BY:
Mr. Bharat D



BEFORE



Crack area

Before Collet observed in crack Conditon

AFTER



Replayes crack collet & Add new Collet

PILLAR: EDUCATION & TRAINING

TITLE: Check Point for Spindle Assy Run out in set up inspection report

DATE: 10.06.2024

Area: CNC

BASIC KNOWLEDGE

IMPROVEMENT CASE

TROUBLE CASE

PREPARED BY:
Mr. Dethe Shashikant s

APPROVED BY:
Mr. Bharat D



BEFORE

AFTER

FIRST FIVE PIECE CUM INSPECTION CHECK SHEET

S. No	Product Parameter	Spec.	Measurement Method	First Five Piece					1 Piece / 2hr					Inspection	Status	Remarks	
				1	2	3	4	5	1.00	1.00	1.00	1.00	1.00				1.00
1	Total Length	24.000	Height Gauge														
2	Coating Dia	20.000	Step Gauge / Micrometer														
3	Coating ID	24.000	Step Gauge / Gauge														
4	Coating Dia	24.000	Step Gauge														
5	Coating Dia	24.000	Step Gauge														
6	Coating Dia	24.000	Step Gauge														
7	Coating Dia	24.000	Step Gauge														
8	Coating Dia	24.000	Step Gauge														
9	Coating Dia	24.000	Step Gauge														
10	Coating Dia	24.000	Step Gauge														
11	Coating Dia	24.000	Step Gauge														
12	Coating Dia	24.000	Step Gauge														
13	Coating Dia	24.000	Step Gauge														
14	Coating Dia	24.000	Step Gauge														
15	Coating Dia	24.000	Step Gauge														
16	Coating Dia	24.000	Step Gauge														
17	Coating Dia	24.000	Step Gauge														
18	Coating Dia	24.000	Step Gauge														
19	Coating Dia	24.000	Step Gauge														
20	Coating Dia	24.000	Step Gauge														

old sheet

FIRST FIVE PIECE CUM INSPECTION CHECK SHEET

S. No	Product Parameter	Spec.	Measurement Method	First Five Piece					1 Piece / 2hr					Inspection	Status	Remarks	
				1	2	3	4	5	1.00	1.00	1.00	1.00	1.00				
1	Total Length	24.000	Height Gauge														
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19	Coating Dia	24.000	Step Gauge														
20	Coating Dia	24.000	Step Gauge														

New Sheet

Feed rate - mm/ revolution	0.16 to 0.20
Hydraulic Pressure	28* 30 Bar
Clamping pressure	18*20 kg/cm2
Spindal assy runout RH side	0.05max

Before 5 pcs inspection check sheet check point not add Spindle Assy (Specifiation) Run out .

After check point add Spindle Assy (Specifiation) Run out .