

KAIZEN Summary Sheet (Jan. ,2016) - Kharigram					
S.N	Department	Kaizen No.	KAIZEN Description	Annualised Benefit Rs. lacs	Status after Kaizen
1	SPG M4-6	K - SPGM4-6 01	Yellow Lining on Aero feed Blow room Lines in Mill no.4		Deptt 5S improved
2	SPG M4-6	K - SPGM4-6 02	Clothes were kept here and there in Deptt.		Proper Area Identification for hanging Clothing
3	SPG M9	K - SPG M9 01	Wheel quality was inferior & life not more than 4 month		Wheel quality improved & life increased
4	SPG M9	K - SPG M9 02	Due to ratcheting hard waste increased & produce inferior yarn quality		Insert metal sheet & ratcheting controled
5	SPG M9	K - SPG M9 03	Hard waste increased due to long lapeta		Hard waste reduced
6	SPG M9	K - SPG M9 04	Without shutter cover .it was looking odd.		Looking attractive
7	SPG M9	K - SPG M9 05	Cable lying on floor & looking odd		Cable covered with GI sheet
8	SPG M9	K - SPG M9 06	Wall tiles are breaking by SF bobbins		GI sheet introduced to protect tiles
9	SPG M9	K - SPG M9 07	Hot steam pipe may lead accident		Hot steam pipe area covered with iron guard
10	SPG M9	K - SPG M9 08	During lot final some bobbin remain in tapa		Empty tapa keep conversely
11	SPG M9	K - SPG M9 09	Weighing balance display kept on floor & it was dangerous		Display stand fixed in wall
12	SPG M9	K - SPG M9 10	Display was hand written		Use computerised font Looking Attractive
13	SPG SJ11	K - SPG SJ11 01	Extra cable observed in RH indicator		Removed with fitting
14	SPG SJ11	K - SPG SJ11 02	Loose & open electric wiring observed in north phase filter room		Covered with plastic sheet cover
15	SPG SJ11	K - SPG SJ11 03	We have observed without covered cable in south phase filter room		Covered with GI sheet cover
16	SPG SJ11	K - SPG SJ11 04	Extra electric cable is lying in jeewan mittra house keeping office		Covered with GI sheet
17	SPG SJ11	K - SPG SJ11 05	Standing board border observed normal looking		Standing board border highlighted with radium strip.
18	SPG SJ11	K - SPG SJ11 06	We observed yellow mark area shortage for storage of CF cans		Yellow mark extended for maintaining 5 'S'
19	SPG SJ11	K - SPG SJ11 07	We observed yellow mark area shortage for storage of CF cans		Yellow mark extended for maintaining 5 'S'
20	SPG SJ11	K - SPG SJ11 08	CHECKERS Desk was not fix		Preparatory Checker Desk has been fix as per 5 's'
21	SPG SJ11	K - SPG SJ11 09	CHECKERS Desk was not fix		RF Checker Desk has been fix as per 5 's'
22	SPG SJ11	K - SPG SJ11 10	Sub staff Desk was not fix		BR Sub staff Desk has been fix as per 5 's'
23	POST SPG M1-6	K - PS M1-6 01	We were face wrong bobbin feeding problem at the time of two same colour material run on Auto coner.		To avoid lot mix up ,Red colour GI plate fixed between magazine.
24	POST SPG M1-6	K - PS M1-6 02	We were facing contamination problem when run contrast shade on Cheese wdg		Fixed permanent GI partition between tension device
25	POST SPG M1-6	K - PS M1-6 03	Due to short height separator entanglement and ply mix was facing between two running cones.		: Increased height of separator and find normal working.
26	POST SPG M1-6	K - PS M1-6 04	Breakages were running high due to wrong design and without ceramic balloon controller		: Changed modified balloon controller , breakage is running normal
27	POST SPG M9	K - PSM9 01	There was not fixed place for Checker almira in the deptt		Place fixed with yellow line for Checker almira in the deptt
28	POST SPG M9	K - PSM9 02	There were not fixed place to keep pallets in pkg deptt		Now place fixed with yellow line in pkg deptt for keeping pallets
29	POST SPG M9	K - PSM9 03	There was not fixed place for keeping weighing balance in pkg deptt		Now we have fixed place with yellow line for keeping weighing balance in pkg deptt for smooth & proper working .
30	POST SPG M9	K - PSM9 04	There was not fixed place for keeping scrap in packing deptt.		Place fixed with yellow line for keeping scrap in packing deptt.
31	POST SPG M9	K - PSM9 05	There was not any visual cone tip & print design identification board displayed in the deptt for visual training & identification of cone tip for winders . We were facing problem of using wrong cone tip by winders .		After placing visual identification of cone tip & print design in the deptt , it became very easy to understand winders & we have found significant improvement in using wrong cone tip by winders .
32	POST SPG SJ11	K - PSSJ11 01	Full cheese rack not identified.		For identification ,sticker paste on full cheese rack & looking attractive.
33	POST SPG SJ11	K - PSSJ11 02	In packing storage room material not identified.		Place fix for material & for identification sticker paste on all rack.
34	POST SPG SJ11	K - PSSJ11 03	In packing section U.V lamp not identified.		For identification sticker paste on U.V chamber.
35	POST SPG SJ11	K - PSSJ11 04	TFO doff place not fix.		TFO doff place fix & for identification mark by yellow tape.
36	QAD -M1-6	K - QAD M1-6 01	Feed roll to beater gauge - 6 off 3		Improvement in fly generation
37	QAD -M1-6	K - QAD M1-6 02	Fabric sample on small knitting m/c in the length of 15 mtrs for injection slub/ roving grindle		For assessment of effect reference
38	QAD -M1-6	K - QAD M1-6 03	Auditing of ladhiana working auto coners on the monthly basis		To get attended yarn path related abnormalities
39	QAD -M1-6	K - QAD M1-6 04	Core spun lycra to mordi on pallets		To avoid cone damage during transport
40	QAD SJ11 & M9	K - QADSJ11 01	Arrangement of filing & documtation according to 5S System.		Arrangement of filing & documtation according to 5S System.
41	MAINT M 1-3	K-MAINT M 1-3 -01	REPAIR TO DAMAGED CROSS ROLL GEAR SHAFT		REPAIR TO DAMAGED CROSS ROLL GEAR SHAFT BY DRILLING AND TIGHTEN 10 MM BOLT AND CUT HEAD OF BOLD.
42	MAINT M 1-3	K-MAINT M 1-3 -02	MAKE CARDING SLIVER GUIDE ROD BY METAL ROD.		MAKE CARDING SLIVER GUIDE ROD METAL ROD IN WORK SHOP.
43	MAINT M 1-3	K-MAINT M 1-3 -03	EXTEND RING FRAME MAGAZINE BOBBIN CREEL.		EXTEND RING FRAME MAGAZINE BOBBIN CREEL BY ADDING ONE MORE LINE OF TRIANGULAR ROD AND BOBBIN HOLDER.
44	MAINT M 1-3	K-MAINT M 1-3 -04	EXTEND TO SUCTION HOOD OF OVER HEAD BLOWER.		EXTEND TO SUCTION HOOD OF OVER HEAD BLOWER IN MODIFIED CREEL RING FRAME IN MILL NO. 3.
45	MAINT M 4-6	K-MAINT M 4-6 01	LC 300 CARD LOADING PROBLEM DUE TODELIVERED MATERIALGO BACK.		INTRODUCED GUARD TO GOBACK DELIVERED MATERIAL ON DOFFER .
46	MAINT M 4-6	K-MAINT M 4-6 02	THERE WAS HAIRNESS PROBLEM DUE TO ROUGH HOOK.		WE PUT CERAMIC RING ON HOOK .NOW HAIRNESS PROBLEM RESOLVE.
47	MAINT M 4-6	K-MAINT M 4-6 03	THERE WAS ISSUE TO KEEP CLOTHES OF FITTER IN RING MAINT ROOM.		ARRANGED HANGER FOR CLOTH IN RING MAINT ROOM.
48	MAINT M 4-6	K-MAINT M 4-6 04	THERE WAS NOT PLACE TOKEEP VARIATOR BELT /TIMING BELT IN RING RUNNING FITTEWR ROOM.		PROVIDED HOOKFOR SAME.
49	MAINT M 9		PAPER CONE HOLDER BROKEN IN AUTOCONER MURATA 21C .	0.05	BROKEN PAPER CONE HOLDER ARE REUSED AFTER DRILLING AND TIGHTENING WITH 8.0 MM BOLT . 30 PC PAPER CONER HOLDER PER YEAR DAMAGE . PAPER CONE HOLDER DAMAGE PER YEAR = 10 PC .
50	MAINT M 9	K-MAINT M 9- 02	IT WAS DIFFICULT TO GREASING IN DRUM PULLEY BEARING OF JINGWEI RING FRAME DURING MACHINE RUNNING .		NEW GREASING POINT INTRODUCED OUT SIDE IN RING FRAME AND NOW IT IS EASY TO GREASE DURING MACHINE RUNNING CONDITION .
51	MAINT M 9	K-MAINT M 9- 03	RING TRAVELLER LOADED WITHIN SHORT PERIOD OF TIME AND NEPY YARN PRODUCE BECAUSE AT SEPERATOR HOLDER POINT IT WAS DIFFICULT TO PROVIDE FLY CATCHER IN COARSE COUNT IN RF NO - 13 .		FLY CATCHER OF LR 60 MACHINE USED IN JINGWEI RING FRAME AND IT IS FIXED AT SEPERATOR HOLDER POINT AND IT IS RUNNING SUCCESFULLY . NOW NO NEPY YARN BOBBIN FOUND RUNNING .
52	MAINT M 9	K-MAINT M 9- 04	ELECTRONIC SENSORS AND ITS COVER BROKEN DUE TO DOFFING RAIL TROLLEY TOUCHES DURING DOFFING SYSTEM .	0.54	RING FRAME DOFFING RAIL GUARD IS EXTENDED OUT SIDE WITH THE HELP OF OLD COT . AFTER EXTENDED GUARD TO OUT SIDE SENSORS AND COVERS ARE NOT DAMAGE. SENSOR AND COVER DAMAGE PER MONTH 20 NOS .

53	MAINT M 9	K-MAINT M 9- 05	NEPPY YARN PRODUCE IN SOME SPINDLES IN JINGWEI RING FRAME PARTICULARLY IN COARSE COUNT IN RF NO - 13 .		IT WAS DUE TO FIBER ACCUMULATION AT SIDE OF SEPERATOR HOLDER AND ONE EXTRA AIR POINT IS PROVIDED IN OHTC TO CLEAN IT IN COARSE COUNT IN RF NO - 13 .
54	MAINT M 9	K-MAINT M 9- 06	DURING MAINTENANCE CLEANING RING FRAME MACHINE TENTER IS NOT UTILISED FOR QUALITY PURPOSE .		SUGGETION GIVEN TO GIVE SOME WORK OF CHECKING AND THESE CHECKED SPINDLES ARE GET ATTENDED BY MAINTENANCE PERSON DURING MAINT CLG. CHECK POINTS ARE :- 1.DAMAGE SPINDLE LOCK CHECKING 2. SEPERATOR MISSING 3. SPINDLE TAPE DOWN FROM JOCKY PULLEY
55	MAINT SJ11	K - MAINT. SJ1101	RING FRAME OFF END WASTE BOX GLASS DOOR COVER IS MISSING		RING FRAME OFF END WASTE BOX GLASS DOOR COVER IS MISSING SO WE ARE USING GI COVER INSTEAD OF GLASS DOOR
56	MAINT SJ11	K - MAINT. SJ1102	Wax holding device worn out problem		On house repair wax holding device is using now
57	MAINT SJ11	K - MAINT. SJ1103	Cone catcher bend problem		After using bush this problem is short out
58	MAINT SJ11	K - MAINT. SJ1104	Trolley mark on the Carding machine		After using Card flat as a stopper in bw machine cover and trolley this problem is short out
59	MAINT SJ11	K - MAINT. SJ1105	In RTS no. 9 ,10 Double drive spindle have repeated fan jam problem		After Converted in single drive spindle this problem is solved
60	MAINT SJ11	K - MAINT. SJ1106	In card LC333 suction duct acrylic sheet is fall down problem is coming		Tightenwith hex head bolt problem is solved
61	MAINT SJ11	K - MAINT. SJ1107	Observation In RSB draw frame sliver guide is completely worn out due to sliver frictional		China Speed frame spindle is used as sliver guide
62	ENGG M123	K-ENGG M123-01	In TFO Machine before kaizen machine having Fuse fitting and loose wiring		Place mark by Yellow tape & looking attractive.
63	ENGG M123	K-ENGG M123-02	Before Kaizen in Motor Winding Department not having proper place for scrap copper wire		In this machine after kaizen install MCCB for better protection and doing wiring systematic
64	ENGG M123	K-ENGG M123-03	Before Kaizen in Motor Winding Department not having proper place for scrap chindi & New Chindi		After Kaizen In Motor Winding department having proper place for scrap copper wire with safety
65	ENGG M123	K-ENGG M123-04	Before Kaizen in Motor Winding Department not having proper place for old bearing		After Kaizen In Motor Winding department having proper place for scrap chindi & new chindi
66	ENGG M123	K-ENGG M123-05	Before Kaizen in Worker Colony Street Light having low lumen .		After Kaizen In Motor Winding department having proper place for old bearing
67	ENGG M123	K-ENGG M123-06	Before Kaizen in carding LC-100 delivery speed not visible on display		After Kaizen In worker colony street light having high lumen .
68	ENGG M123	K-ENGG M123-07	Before Kaizen In Mill No. 1 carding section having Ordinary Indication lamp		After Kaizen in LC-100 Delivery speed showing in new counter meter properly
69	ENGG M4-6	K-ENGG M4-6 01	DUE TO PLAY IN THE MOVING PART PROXIMITY SENSOR FAILURE IS MORE IN PPW MACHINE.		To avoid cone damage during transport
70	ENGG M4-6	K-ENGG M4-6 02	BOBBIN CHANGE FEELER HAVING HIGH FAILURE AND HIGH COST DUE TO MOVING TYPE.		NOW M18 PROXIMITY SENSOR INSTALL BY THE HELP OF IN HOUSE MADE CLAMP . BECAUSE OF HIGH SENSING DISTANCE NO SUCH FAILURE OBSERVED .
71	ENGG M4-6	K-ENGG M4-6 03	SLIVER PHOTO SENSOR HAVING HIGH COST & HIGH FAILURE RATE DUE TO CABLE CONNECTOR PROBLEM		REPLACE WITH FIXED TYPE FEELER WHICH IS DURABLE AND ALSO HAVING LOW COST.
72	ENGG M4-6	K-ENGG M4-6 04	MITSUBISHI DRIVE FAILURE IS MORE AND ALSO HAVING HIGH PURCHASE COST.		REPLACED WITH LOW COST & WITH CABLE PHOTO SENSOR TO AVOID UN NECESSARY MACHINE STOPPAGE.
73	ENGG SJ11	K - ENGG SJ11 01	Signal Lamp for Speed frame 4200AXL as Actual cost of OEM supply lamp is approx. Rs. 7500.00	0.07	We install lamp purchase from local market is Rs . 5200.00. Total saving Rs. 2300.00 for each time replacement. 3 in a year
74	ENGG SJ11	K - ENGG SJ11 02	Heavy Material loading & unloading in unsafe condition.		Heavy Material Loading & Unloading easy with Ramp
75	ENGG SJ11	K - ENGG SJ11 03	Color Sensor of BTS Tube Cleaner if purchase from N'hauser Germany Cost is Rs.85,000	0.47	Installed new Color Sensor (Purchase from India) but origion of Germany . Actual cost of Color Sensor was Rs.38,000. Thus saved Rs. 47,000.00 on each replacement. Frequency one a year
76	ENGG SJ11	K - ENGG SJ11 04	Micro dust was falling from baffle plates in Preparatory area		Fixed wire mesh heavy duty Frame near SA Fan for control Micro Dust problem in Department.
77	ENGG SJ11	K - ENGG SJ11 05	Unloader Slider Motor Connector broken due to cone fallen from Loop.		Turning the motor direction as shown in picture to avoid breakdown and safety of equipment
78	ENGG SJ11	K - ENGG SJ11 06	Linc Coner, Linc motor m310 (between RF & Linc Coner) Cable rooting was not proper due to cable damaged by Foot Stand.		Change motor Cable rooting & done properly for reduce Breakdown.
79	ENGG SJ11	K - ENGG SJ11 07	Found Unsafe condition (Iron Rod) on Street near Packing Godown of M7		Remove Iron rod as attached pic for safe movement of vehicles and walking persons
80	ENGG SJ11	K - ENGG SJ11 08	H-plant alley Unsafe for material loading & unloading due to water pipe was laying on bottom side.		Fixed water Pipe Line Upper side as shown in picture for safe unloading & Loading
81	ENGG SJ11	K - ENGG SJ11 09	Linc Coner CBF Sensor X7DC Cable rooting was not proper due to cable Cutted by Foot Stand.		Change Sensor Cable rooting & done properly for reduce Breakdown.
82	ENGG SJ11	K - ENGG SJ11 10	Loop hanger data delete problem due to Package sensor stand move down due to stand Grip loose.		For improve grip of Loop hanger Package sensor stand make one drill on sensor stand shaft & tight the Stand for reduce breakdown & cone falling problem.
83	ENGG SJ11	K - ENGG SJ11 11	Xorella Vacuum pump overhauling work taking too much time due to pump cover problem.		We Cut the Pump Cover for easy overhauling & reduce maintenance time.
84	ENGG SJ11	K - ENGG SJ11 12	Found improper cable dressing in North Preparatory Panel Room		Done Proper dressing as shown in Picture for reduce nuisance stoppage of IT Server & Admin Block Lighting
85	ENGG SJ11	K - ENGG SJ11 13	Nomenclature of Fire Hydrant Pump Room not be there.		Nomenclature Done on Fire Hydrant Room Door as shown in Picture.
86	ENGG SJ11	K - ENGG SJ11 14	Nomenclature for Bus Bar Not be present in North H-plant Alley.		Fixed Safety Nomenclature as shown in Picture for safety.
87	ENGG UTILITY	K - ENGG UTILITY 01	There is no fitted of PVC curtain		We have fitted of PVC Curtain for Avoid contamination in TFO M/C in mill no.3
88	ENGG UTILITY	K - ENGG UTILITY 02	MS line frequently rusted and leakage in dyeing m/c 4.		MS line replaced by SS in dyeing m/c 4 to avoid breakdown,
89	ENGG UTILITY	K - ENGG UTILITY 03	MS line frequently rusted and leakage in dyeing m/c 6.		MS line replaced by SS in dyeing m/c 6 to avoid breakdown and Condense water used in boiler
90	ENGG UTILITY	K - ENGG UTILITY 04	MS Steam pipe line corrosion and Rusty from out side in mill no. 5 moisture room		Painting work of steam line in mill no. 5 moisture room to avoid rusty water dropping
91	ENGG UTILITY	K - ENGG UTILITY 05	Electric heater fitting in Moisture Room in mill no.1 to 5		Steam heater fitted in moisture room and increased the moisture achieved from 1%to 2% in mill no.1 to 5.
92	ENGG UTILITY	K - ENGG UTILITY 06	Mill no 7A autoconer pressure drop and coming the moisture in Auto conner M/C no. 1 to 4		We have extra air line lying work through Receiver in Mill no 7A autoconer to avoid water moisture with compressed air pressure drop.
93	ENGG UTILITY	K - ENGG UTILITY 07	Mill no. 1 Sieger tank leakage and Vacuum drop.		Mill no 1 Sieger machine water chamber fabricate by in house team
94	ENGG UTILITY	K - ENGG UTILITY 08	Mill no. 1 Sieger trolley platform broken and Yarn Cone fall down in platform.		Mill no 1 Sieger trolley platform fabricate and fitting by in house team
95	IT	K-IT-10	On-line Attendance correction module implemented at Ringas , Saving of Users time and stationary of Correction slips		Implemented at Ringas
96	DYE HOUSE	K - Dye House 01	Identification of colour box/cartoon in proper way in colour-room.		Easy to work during weighing colour.
97	DYE HOUSE	K - Dye House 02	Marking the use of fire extinguisher during critical situation.		Improve habit of proper use of fire cylinder .
98	DYE HOUSE	K - Dye House 03	Display/arrange the dyed viscose in systematic manner.		Improve habit of proper working and proper identification
99	DYE HOUSE	K - Dye House 04	display board of dye-house area near entry gate.		Eesy to indentify the area.
100				1.13	