

KAIZEN Summary Sheet (Feb. 2016) - Kharigram					
S.N	Department	Kaizen No.	KAIZEN Description	Annualised Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	Put identification board on B/r line no. - 1 in mill no. -1		Deptt 5S improved,Identification maintain
2	SPG M1 - 3	K - SPGM1-3 02	Lap Rods kept vertically in the new stand in Mill no.-3		Deptt 5S improved, Lean management
3	SPG M4-6	K - SPGM4-6 01	Yellow Lining on bales storage area in Mill no.4		Deptt 5S improved,Safety improved
4	SPG M4-6	K - SPGM4-6 02	Place indentified for keeping loose fibre stocks in Mill no.6		Deptt 5S improved, Avoiding Mix up of fibres\
5	SPG M4-6	K - SPGM4-6 03	Hanger Fitting in Blow room department for hanging Clothing of Workers in mill no.6		Deptt 5S improved,Proper Area Identification for hanging Clothing
6	SPG M4-6	K - SPGM4-6 04	Lap Rods kept vertically in the new stand in Mill no.6		Deptt 5S improved, Lean management
7	SPG M4-6	K - SPGM4-6 05	New Khatal Boxes fabricated to keep ring frames doffs in Mill no.6		Deptt 5S improved, Lean management, Checking of Yarn become better
8	SPG M4-6	K - SPGM4-6 06	Support Partition extended on Blender no.2 in Mill no.6		Deptt 5S improved, No Spreading of fibres on Floor.
9	SPG M9	K - SPG M9 01	Bobbins were kept in PP bags		: Bobbins kept in MS Sheet racks
10	SPG M9	K - SPG M9 02	Pigeon were sit on pillar & doing wall dirty		Pillar top area covered with GI sheet
11	SPG M9	K - SPG M9 03	Panel back space was covered with separator ,it was looking odd.		Looking attractive
12	SPG M9	K - SPG M9 04	Uni spray cable hanging unnecessary ,it was looking odd.		Looking attractive
13	SPG M9	K - SPG M9 05	Eire diversion pipe not paint		Fire diversion pipe painted with red paint
14	SPG M9	K - SPG M9 06	Hot & cold water lines were not identified		Hot & cold water lines identified
15	SPG M9	K - SPG M9 07	Pneumafil duct cover used to go in duct during duct cleaning.		Pneumafil duct cover fixed & modified sliding cover implemented .
16	SPG M9	K - SPG M9 08	Stop motion gripper centre out		Stop motion gripper centralised
17	SPG M9	K - SPG M9 09	Display was hand written		Computerized font looking Attractive
18	SPG M9	K - SPG M9 10	Mill name was not properly visible .		Now Mill name painted clear and visible
19	SPG SJ11	K - SPG SJ11 01	Cleaning m/c name display on paper		Name display on standard name plate
20	SPG SJ11	K - SPG SJ11 02	We have observed Office alley wall was being damage due to movement of SX trolley		Install wall guard to avoid flaking
21	SPG SJ11	K - SPG SJ11 03	We have observed doffer clg waste was putting in plastic bags		Now putting waste in defined box.
22	SPG SJ11	K - SPG SJ11 04	We have observed fibre sample was kept anywhere in B/R office		Now fixed fibre sample area with yellow line as per 5 'S' System
23	SPG SJ11	K - SPG SJ11 05	We have observed Napco was keeping without defined area in BR office		Now Neppo area defined with yellow line as per 5 'S' System
24	SPG SJ11	K - SPG SJ11 06	Broken bobbin was keeping in loose form in rack		Now we have place a tapa with proper name plate
25	SPG SJ11	K - SPG SJ11 07	There was no any check list system		Now we introduce check list for maintain housekeeping with proper monitoring
26	SPG SJ11	K - SPG SJ11 08	There was no any pre cleaning checking system		Bobbin holder,creel rod,OHTC track,cleaning improved
27	SPG SJ11	K - SPG SJ11 09	Cleaning instrument area was not defined.		Now defined as per 5 S
28	SPG SJ11	K - SPG SJ11 10	2 nd Quality material location was not defined		Now defined as per 5 S
29	POST SPG M1-6	K - PS M1-6 01	House keeping was not good and also space short .		House keeping is looking v. good and working space is also more.
30	POST SPG M1-6	K - PS M1-6 02	workers are doing stop overhead again and again hence		If overhead will stop then machine will also stop automatically House keeping improved
31	POST SPG M1-6	K - PS M1-6 03	Poor house keeping and space problem.		House keeping is looking good and more space in worker galary.
32	POST SPG M1-6	K - PS M1-6 04	To improve moisture		Increased 1.7 % moisture after used nozzle on out side of conditioning room.
33	POST SPG M1-6	K - PS M1-6 05	To save packer time		Save time of Packer increase production
34	POST SPG M1-6	K - PS M1-6 06	House keeping disturb.		House keeping is looking good.
35	POST SPG M9	K - PSM9 01	On 21C autoconer there wee gaps between joint of two section. Lot final bobbin ,cone was found in these gaps.		Now these gaps have been packed by modified GI sheet to avoid accumulation of lot final bobbins & cone there.
36	POST SPG M9	K - PSM9 02	IN TFO SECTION CHEESE RACK IDENTIFIED		CHEESE RACK IDENTIFIED FOR BETTER COMMUNICATION IN THE DEPTT.
37	POST SPG M9	K - PSM9 03	WASTE BOX FIXED WITH PROPER IDENTIFICATION		WASTE BOX FIXED WITH PROPER IDENTIFICATION FOR BETTER COMMUNICATION
38	POST SPG M9	K - PSM9 04	Empty cheese box identified		Empty cheese box identified for better communication to the operator
39	POST SPG M9	K - PSM9 05	Cone tip & print design identification board placed in the deptt for visual training of winders		After Placing visual identification of cone tip & print design in the deptt , it became very easy to understand winders & we have found seignificant improvement in using wrong cone tip by winders.
40	POST SPG M9	K - PSM9 06	PLACE FIXED FOR KEEPING EXPORT CARTON WITH PROPER IDENTIFICATION		Place fixed in packing area for keeping EXPORT CARTON with proper identification.
41	POST SPG M9	K - PSM9 07	PLACE FIXED FOR KEEPING HDPE BAGS WITH PROPER IDENTIFICATION		Place fixed in packing area for keeping HDPE BAGS with proper identification.
42	POST SPG M9	K - PSM9 08	IDENTIFICATION OF KEEPING PACKING MATERRIAL		Now all packing material has been storage in almrah with proper identification .
43	POST SPG M9	K - PSM9 09	Display board identification of cone tip		After placing visual identification of cone tip & print design in the deptt , it became very easy to understand winders & we have found seignificant improvement in using wrong cone tip by winders.
44	POST SPG M9	K - PSM9 10	IDENTIFICATION OF KEEPING PACKING MATERRIAL		Now all packing material has been storage in almrah with proper identification .
45	POST SPG SJ11	K - PSMSJ11 01	Use old carton for dust bin.		New plastic dust bin use for scrap material.
46	POST SPG SJ11	K - PSMSJ11 02	Packed carton place wood broken & not looking Good.		New wood ply fix on floor & looking Good.
47	QAD M 1- 6	K - QADM1-6 01	Counter checking of corrected quantity lots after taking action		To assess right disposal
48	QAD M 1- 6	K - QADM1-6 02	Training of deptt. investigators for separating abnormalities during checking of material		Will support in controlling / arresting the abnormalities appearing in physical visibility.
49	QAD SJ11 & M9	K - QADSJ11 02	Fix the space for material handling trolley.		Follow 5s System & sefty.
50	QAD SJ11 & M9	K - QADSJ11 03	Make wrapping lea box for put m/c wise lea for wrapping checking & fix the space of lea box near wrapping machine.		Reduce chances of error during wrapping checking & save time also looks attractive.
51	QAD SJ11 & M9	K - QADSJ11 04	Marking over power switches.		Looking attractive. Follow 5s System.
52	QAD SJ11 & M9	K - QADSJ11 05	Machine name , machine calibration & next due date of machine calibration printed tag put over all QA machines.		Looking attractive. Follow 5s System.
53	QAD SJ11 & M9	K - QADSJ11 06	Cable covered with wooden cover.		Cable lying on floor & looking odd so that cover it & make it attractive & cost saving.
54	QAD SJ11 & M9	K - QADSJ11 07	Arrangement of filing & documtation according to 5S System.		Filing & doumtnation place is fix & looking attractive. Follow 5s System.
55	QAD SJ11 & M9	K - QADSJ11 08	Repair cubed damage.		Looking attractive with respect to safety.
56	QAD SJ11 & M9	K - QADSJ11 09	Covering Printer with cardboard cover.		Printer safe from dust & fly& save cost.
57	QAD SJ11 & M9	K - QADSJ11 10	Put Identification display board near wrapping machine which show the name of the QA wrapping boy & his shift & contact no .		Easy identification & Follow 5s System.

58	QAD SJ11 & M9	K - QADSJ11 11	Stool of Computer table for sitting replace by chair.		Improve comfort of Computer boy as well as safety.
59	QAD SJ11 & M9	K - QADSJ11 12	Identification display put at the place of bobbin zone.		looking attractive . Follow 5s System.
60	QAD SJ11 & M9	K - QADSJ11 13	Fit wooden stand for CPU.		Looking attractive with respect to safety.
61	QAD SJ11 & M9	K - QADSJ11 14	QAD mention in entrance of QAD		Looking attractive, easily identified & Follow 5s System.
62	QAD SJ11 & M9	K - QADSJ11 15	Set area of dust bin by yellow mark also dust bin mention over dust bin.		Looking attractive. Follow 5s System.
63	QAD SJ11 & M9	K - QADSJ11 16	Replace all damage chair cover of chair of QA lab.		Looking attractive.
64	MAINT M1-3	K - MAINT M1-3 01	IN LC-100 CARD THERE WAS MOTOR AND WORM GEAR ARRANGEMENT FOR DRIVE OF FLAT BRUSH SO WE REPLACE MOTOR AND WORM GEAR ASSEMBLY BY A PULLEY AND GIVE IT DRIVE FROM CYLINDER PULLEY.		FLAT BRUSH MOTOR REPLACED BY PULLEY.
65	MAINT M1-3	K - MAINT M1-3 02	THERE WAS NO ANY OVER HEAD BLOWER ON PS CHEESE WINDING M/C. WE HAVE 1 SET OF OVER HEAD BLOWER OF OLD CHEESE WINDING M/C SO WE SET IT ON PS CHEESE WINDING M/C BY ADJUSTING A RAIL ON IT.		OVER HEAD BROWER FITTED ON PS CHEESE WDG. M/C.
66	MAINT M1-3	K - MAINT M1-3 03	IN AC-X5 DAMAGE OF PURSUER METER WAS MATTER OF COURSE SO WE COVERED IT BY IRON SCREEN NOW PROBLEM HAS BEEN SOLVED.		PRESSURE METER COVERD BY IRON SCREEN IN AC-X5.
67	MAINT M1-3	K - MAINT M1-3 04	SPLICER NOZZLE OF SAVIO ORION DAMAGED. PROBLEM IN PRESSURE PIPE FITTING SO WE OPEN DAMAGED MAIL CONNECTOR OF RING FRAME AND PUT GRIPPER WASHER OF MAIL CONNECTOR IN SPLICER NOZZLE AND IT WORKS SMOOTHLY AS BEFORE.		SPLICER PRESSURE NOZZLE REUSED.
68	MAINT M4-6	K - MAINT M4-6 01	THERE WAS NOT PROPER PLACE TO KEEP CLEANING PRESSURE PIPE IN AUTOCONER MILL 4. SO PIPE DAMAGING MORE.		INTRODUCE PROPER PLACE FOR WRAPPING THE PRESSURE PIPE ON ROLL.IMPROVED HOUSE KEEPING & INCREASEAD LIFE
69	MAINT M4-6	K - MAINT M4-6 02	THERE WAS 50 NOS CHUTE SUPPORT WAS DAMAGED IN 338 AUTOCONER.	0.5	REPAIRED IN HOUSE THE DAMAGED CHUTE SUPPORT AND SAVE RS-50000
70	MAINT M4-6	K - MAINT M4-6 03	THERE WAS SHORTAGE OF 3 NOS LYCRA ROLL DRIVE ASSEMBLY.		MAKE IN HOUSE 3 NOS LYCRA ROLL DRIVE ASSEMBLY AND STARTED THE MACHINE
71	MAINT M 9	K - MAINT M9 01	OPERATOR TROLLEY WHEEL GET FALL DOWN AND MISSING .		LOCK NUT IS REPLACED WITH CIRCLIP .
72	MAINT M 9	K - MAINT M9 02	BLACK CONTAMINATION FALL DOWN ON SPEED FRAME BOBBIN ON RING FRAME MACHINE .		ONE EXTRA AIR BLOW POINT PROVIDED TO CLEAN TRACK AND AVOID IT FROM FIBER / DUST ACCUMULATION .
73	MAINT M 9	K - MAINT M9 03	AT SOME SPINDLS END BREAKAGE DUE TO ROVING JAM AT PINTER STOP MOTION DURING TRAVERSE MOVEMENT .		FIND OUT PROBLEM AND SOLVED THIS WITH PINTER STOP MOTION STRIP SETTING DONE ACCORDINGLY .
74	MAINT M 9	K - MAINT M9 04	TRAY OF COTS ARE KEPT ON FLOOR IN BUFFING ROOM AND NO SPACE FOR WORKING		STAND FOR KEEPING TRAY MADE FROM OLD MATERIALS . MORE SPACE AVAILABLE NOW .
75	MAINT SJ11	K - MAINTSJ11 01	Chance of Gear mix up during count change process.Make patrician bw the trolley so fitter can manage gear during count change process		Make patrician bw the trolley so fitter can manage gear during count change process
76	MAINT SJ11	K - MAINTSJ11 02	During removing of lapping on cots chance of cots fall down and increase the chance of cots eccentricity.With the help of stand on the machine chances of cots fall down and chance of cots eccentricity is minimize		With the help of these stand on the machine chance of cots fall down and chance of cots eccentricity is remove
77	MAINT SJ11	K - MAINTSJ11 03	Extra Pneumatic air Clg point provide for cleaning buffing stone.		Extra Pneumatic air Clg point provide for cleaning buffing stone.
78	MAINT SJ11	K - MAINTSJ11 04	Target Sheet - Web Collector TARGET SHEET material is not so good. Every time target is disturb and machine is stop.: First on house develop Target sheet and also recommended to LMW to make changes in this		First on house develop Target sheet and also recommended to LMW to make changes in this
79	MAINT SJ11	K - MAINTSJ11 05	Damage Web Collector Holder Assy.On hose repair Damage Web Collector Holder Assy		On hose repair Damage Web Collector Holder Assy
80	MAINT SJ11	K - MAINTSJ11 06	2 times Pigeon was suck with air when 2 way distributor Sutter is open. Due to this all material is converted in to the waste. Wire Mesh Jaali is used in front of sutter. Due to this problem is solved		Wire Mesh Jaali is used in front of sutter. Due to this problem is solved
81	MAINT SJ11	K - MAINTSJ11 07	Damage cradle opener is not for use. Cost of new cradle opener is approx. 500 rs.; On house repair cradle opener with the help of MS sheet and again use in process		On house repair cradle opener with the help of MS sheet and again use in process
82	ENGG M1-3	K-ENGG M123-01	Carding Doffer motor controlling switch put on outside		Carding Door Panel Lock Damage rate very Low
83	ENGG M1-3	K-ENGG M123-02	Blow Room Gear Motor Run With Drive	0.08	Blow Room Motor Run Smoothly and gear not damage
84	ENGG M1-3	K-ENGG M123-03	Carding Main motor protection improve		Carding Main motor not trip on torquing time due to on delay timer
85	ENGG M4-6	K-ENGG M4-6 01	Provided off end m/c on off switches as per production requirement to increase m/c eff. By decreasing doff time of ring frame m/c no. 17 to 25 in m4.		Eff. Improved in these machines
86	ENGG M4-6	K-ENGG M4-6 02	Provided sliver stop motion in two speed frame machine of mill 6 with the help of in house fabricated clamp in our work shop.		Will improve the roving formation productivity and quality.
87	ENGG M4-6	K-ENGG M4-6 03	Fixed wooden fixture in all Auto Coner 338 drums below operation section.	0.25	Will give better & long life due to less damage .
88	ENGG M4-6	K-ENGG M4-6 04	Converted one no. C-50 Card from DC to AC in aero feed system	0.10	Will improve productivity due to less stoppages
89	ENGG M9	K-ENGG M9 01	Stop motion not properly placed at position.		After modification of it comes in position .
90	ENGG M9	K-ENGG M9 02	Cooling fan blowing direction was up ward side due to witch CPU did not cooling properly.		After reversing of its direction CPU being cooled and breakdown related CPU reduce up to 80%. It will also reduce failure of CPU
91	ENGG M9	K-ENGG M9 03	Display original push button not working. It have to repalced with new touch board.		We installed separate push button on touch board avoid replacing of new touch board.
92	ENGG M9	K-ENGG M9 04	Transformer are in irregular manner in M-9 power house, confusing to identify.		Transformers are now easy to identify by their name plate.
93	ENGG M9	K-ENGG M9 05	There was four no. of tube light on VIP gate of M-9.		We reduce it by removing two no. of tube light which was unnecessary
94	ENGG M9	K-ENGG M9 06	Control panel was on the crane, so we have go on crane to attend any breakdown, which was very risky.		Now we have replaced the panel near track which is easy to go or attend the break down and to do maintenance
95	ENGG M9	K-ENGG M4-6 03			
96	ENGG SJ11	K - ENGGSJ11 01	If ring frame main motor belt break at that time cable damaged through belt.		We done spiral insulation for safety purpose to avoid above problem.
97	ENGG SJ11	K - ENGGSJ11 02	LR9 Ring frame drafting motor side net used by OEM is very thin due to which motor take more temperature and failure rate high.		Fixed thick net and we found temperature reduced up to 6 degree.
98	ENGG SJ11	K - ENGGSJ11 03	Nitrogen slender standup of unsafe condition.		Fix by proper clamping
99	ENGG SJ11	K - ENGGSJ11 04	Unsafe water drain near YCP out side and mouse enter through pipe and damage cable of automation system.		Fixed net for avoid above problem.
100	ENGG SJ11	K - ENGGSJ11 05	In transformer room and utility areas cable open and unsafe in cable tray which was damaged by mouse.		Fixed proper cover to avoid above problem.
101	ENGG SJ11	K - ENGGSJ11 06	Drinking water inlet line hanging unsafe condition and water line temp increase also		Make proper root in line, insulated line by G.I. scrap pipe.
102	ENGG SJ11	K - ENGGSJ11 07	Reducer cost Rs 800/ piece and we have no spare.	0.19	Prepare in house reducer for cost saving .Save Rs.600 per piece.
103	ENGG SJ11	K - ENGGSJ11 08	Unsafe cable near YCP out side and mouse enter through pipe and damage cable of automation system		Hole pack for avoid above problem.

104	ENGG SJ11	K - ENGGSJ11 09	No any identification of lighting D.B.		Marking of lighting D.B
105	ENGG SJ11	K - ENGGSJ11 10	LT Insulation coating was not marked to use high movement		LT Insulation coating marked to do not move heavy parts to safegaurd
106	ENGG UTILITY	K - ENGGUTILITY 03	Kaizen in Dye House . Again and again air pipe leakage. In M/C No.5 &6 due to Length of pipe high.		Kaizen in Dye House . We have make the support of Air pipe in m/c no.5&6.
107	ENGG UTILITY	K - ENGGUTILITY 04	Steam Dryer work in Dye House .Motor pulley guard fixed on Chamber		After Kaizen We have make the motor pulley cover at steam dryer for smooth working and using in safe.
108	ENGG UTILITY	K - ENGGUTILITY 05	Before Kaizen in Dye House . This MS jail fitted in floor for Dyeing M/C no. 8 and Gape size is over between two flat.		Kaizen in Dye House .We have make the MS Jail and fitted on floor for NO accident
109	ENGG UTILITY	K - ENGGUTILITY 06	Kaizen in Dye House in Steam Dryer No.1. Handling support and steam chamber door is damage.		Kaizen in Dye House in steam Dryer No.1.We have made the new make the chamber door and handling support work for maintenance purpose and avoid the heat loose.
110	ENGG UTILITY	K - ENGGUTILITY 07	Kaizen in Dye House.Fiber out let chamber was not proper .		Kaizen in Dye House. Fiber out let chamber .We made the fixed the sheet by welding and avoid the fiber contamination
111	ENGG UTILITY	K - ENGGUTILITY 08	Kaizen in Mill no.9 Blow Room. Water use in Unisprey for Fiber mixing. And wastage of water		Mill no.9 Blow Room . We have provide the locking system on valve because avoid the wastage of RO water.
112	ENGG UTILITY	K - ENGGUTILITY 09	Kaizen in Mill no.5 Packing for Sieger M/C . Cooling hot water not use in any place.	0.54	Kaizen in Mill no.5 Packing for Sieger M/C . We have used of cooling hot water for jet spray for moisture room packing mill no.4 &5
113	ENGG UTILITY	K - ENGGUTILITY 10	Before Kaizen in Dye House in Steam Dryer No.1. Handling support and steam chamber door is damage		Kaizen in Dye House in steam Dryer No.1.We have made the new make the chamber door and handling support work for maintenance purpose and avoid the heat loose.
114	STORE & PURCHASE	K - S&P 01	Developed a software for Main Gate Entry , Misc.Bill passing ,Transport registrar ,Panalty,Advance Payment etc.		Using this software we are not doing the above work manually , Using this software we are able to get records easily .
115	STORE & PURCHASE	K - S&P 02	Stores godwan has allotted to each staff for proper house keeping		We are able to maintain our godwans in proper way
116	STORE & PURCHASE	K - S&P 03	Tagging in each Godwan		We are able to trace the material easily
117	STORE & PURCHASE	K - S&P 04	Parking infront of Store godwan		Vechicals are parked on proper place
118	IT	K - IT 01	New Report developed for Analysis of Packing net weight and configured with Auto mailing to deliver on mail of concern persons of Post Spinning / Packing on daily basis		Implemented and mail delivered on daily basis to respective user of Post Spinning
119	NPD	K - NPD - 01	Lot of time has been consumed for searching the Fiber PD Cards from the files and file of the PD Cards when needed. Lot of time has been wasted due to this		All PD files has been marked with file no. including the PD No. and stored systematically.
120	NPD	K - NPD - 02	Lot of time has been consumed for material transfer from Innovation centre to Pilot Plant and vice versa.		To reduce the material handling time, a bicycle has been issued and used for material handling from Innovation Centre to Pilot Plant & Vice Versa.
121	NPD	K - NPD - 03	Quality running in the Fancy Doubling has found disturbed from the panel and due to which there are chances of the wrong quality. Lock of the panel is out of order and not repairable.		New lock system has been made with the help of the engineering team due to which simple pad lock can be used for lock of th epanel.
122	NPD	K - NPD - 04	Material is placed in the bags which not only create the quality issue but also not look good as per SS		Excess tapas from the Mill No. 6 has been taken for keeping the material.
123	NPD	K - NPD - 05	NPD Ringframe count has been checked in the QA Mill No. 1,2,3 which takes time and R/F has been stopped for longer time due to this.		Scrap wrap reel has get repaired with the help of Engineering Team and that wrap reel has been replaced with the new wrap reel of the Innovation Centre. Now new wrap reel is available for wrapping in the Pilot Plant.
124	NPD	K - NPD - 06	Utilization of the R/F machine of NPD machines is low due to waiting time of the fitter for changing the gears at count change.		Fitter has been appointed for NPD for reducing the change over time.
125	NPD	K - NPD - 07	Renovation work in the NPD Pilot is going on and for floor work simplex machine has to be shifted which takes time. (Expected more than 2 days)		Rather than shifting the simplex machine one section of the simplex machine has been removed for creating the space for flooring work which has done with in 16 Hour.
126	DYE HOUSE	K - Dye House 01	display board of Dryer-section area .		Easy to indentify the area.
127	DYE HOUSE	K - Dye House 03	display board of Dryer-section area .		Easy to indentify the area.
128	DYE HOUSE	K - Dye House 04	Installed tap with drum to take chemical accurate & neatly.		improved habit to take chemical accurate& neatly
Total Annualized Amount				1.66	improved habit to take chemical accurate& neatly