

**RSWM Kharigram - KAIZEN Summary Sheet Apr'17**

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	Put Fire extinguisher cylinders on wall in plce of floor.		We have put these cylinders on the wall & and now they are easily accessible.
2	SPG M1 - 3	K - SPGM1-3 02	Modified lap rod stand for easy ness of operator.		Now working of poerator is easy with low fatigue level.
3	SPG M1 - 3	K - SPGM1-3 03	Painted wall safety gaurd.		Now working environment is good also house keeping has been improved.
4	SPG M1 - 3	K - SPGM1-3 04	Put net partion betwn M-3 and new plant carding section.		Scattering of fly during lot change pressure cleaning has been stopped,also house keeping has been improved.
5	SPG M1 - 3	K - SPGM1-3 05	New hrs meter put on Pilot RF in M-2		Now by better monitoring this machine utilization has been improved.
6	SPG M1 - 3	K - SPGM1-3 06	Emergency window in carding section.		In case of any emergency this window may be used.
7	SPG M1 - 3	K - SPGM1-3 07	Iron sheets put in place of asbestos sheets in mixing bins in mill no-1		Fiber passing through old sheets has been reduced to minimum also safety has been improved.
8	SPG M4-6	K - SPGM4-6 01	Lap feed conversion of four cards in mill no.5		Working all products now.
9	SPG M4-6	K - SPGM4-6 02	Speeds increased in 8 poly dolphin 385 off 375	1.19	Saving
10	SPG M4-6	K - SPGM4-6 03	Lap feed line conversion in mill no.4		Working all products now.
11	SPG M4-6	K - SPGM4-6 04	Mixing Blender change for better opening of fibre		Working all products now.
12	SPG M4-6	K - SPGM4-6 05	Contractors hands engaged in mill no.4 Mixing work.	0.86	saving
13	SPG M9	K - SPG M9 01	In waste box handle is not available .		Put handle after repaired :
14	SPG M9	K - SPG M9 02	Broken SF trolley .		Trolley repaired .
15	SPG M9	K - SPG M9 03	Broken falls ceiling .		Falls ceiling repaired .
16	SPG M9	K - SPG M9 04	Broken falls ceiling .		Falls ceiling repaired .
17	SPG M9	K - SPG M9 05	Falls ceiling may be fall down .		Falls ceiling repaired .
18	SPG M9	K - SPG M9 06	H. plant duct broken .		H. plant duct repaired .
19	SPG M9	K - SPG M9 07	Identification required .		Identification done .
20	SPG M9	K - SPG M9 08	Gutter cover not fitted properly .		Gutter cover fitted properly .
21	SPG M9	K - SPG M9 09	Broken tiles .		Tiles Change
22	SPG M9	K - SPG M9 10	Floor condition poor .		Floor repaired .
23	SPG M9	K - SPG M9 11	OHTC not available .		Install OHTC .
24	SPG M9	K - SPG M9 12	Hole near cable .		Hole attended near cable .
25	SPG M9	K - SPG M9 13	Tiles broken .		Broken tiles repaired .
26	SPG M9	K - SPG M9 14	Broken count board .		Change broken count .
27	SPG M9	K - SPG M9 15	Require curtain quality change .		Curtain quality change as net curtain used .
28	SPG M9	K - SPG M9 16	Due to gap creation RF bobbin or any thing may goes under the machine.		Gap pack with wooden peace .
29	SPG M9	K - SPG M9 17	Ring Frame gearing cover protection.		Mill no. 9 RF gearing cover protected from fly and jam of fibres .
30	SPG M9	K - SPG M9 18	Before use of this clef suffer quality & short spacer availability.		After use this clef improve in quality
31	SPG SJ11	K - SPG SJ11 01	We observed that in RF display there was no any limit defined of cop dia correction so ring rail moves up ,when we feed data by mistake from required value causing produced hard waste	0.32	So new software installed to define its max and min limit and controlled hard waste
32	SPG SJ11	K - SPG SJ11 02	We observed that in RF display there was no any limit defined of initial speed so m/c get 100% side cut ,when we feed data by mistake from required value	0.1	So new software installed to define its max and min limit , controlled hard waste
33	SPG SJ11	K - SPG SJ11 03	We observed that in office block entry gate base plate missing.		So we immediate placed base plate & maintain 5'S'
34	SPG SJ11	K - SPG SJ11 04	We observe that partition between BDF No 5&6 was very dusty condition		So immediate Paint work done & maintained 5'S'
35	SPG SJ11	K - SPG SJ11 05	We observed that 24P was produce from 0.55P,Causing count cv high i.e. greater then 2% and B5 alarm were also high approx. 2000 / mc/ shift		Now we have producing 24P from 0.90poly, with cv below 1.8% & alarm with in limit i.e. B5 alarm below 1000/mc/ shift
36	SPG SJ11	K - SPG SJ11 06	We observed that in south side utility area, near RF -1,wall colour was pilling		So colour paint work done on wall
37	SPG SJ11	K - SPG SJ11 07	We observe that in 10 poly yarn ,during doffing ends not cut from spindle clutch due to high single yarn strength		So we reduce TM with maintain target CSP ,now clutch working improved and controll start up breaks

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
38	SPG SJ11	K - SPG SJ11 08	We observed that in preparatory section yellow tape marking was tear up and worn out ie looking bad apperence		So yellow tape marking renewed and maintain 5'S' also looking attractive
39	SPG SJ11	K - SPG SJ11 09	We observed that 20P was produce from 0.55 Causing high B5 alarm and cuts so problem of bobbin shortage arises and faced 20% Eff loss in 20 Poly		Now we switch on .60 poly hank off 0.55 p, now cuts and alarm level reduced with zero empties loss
40	SPG SJ11	K - SPG SJ11 10	We in poly process count channel cuts and B5 alarm were high in RF so bobbin shortage problem was arises		So switch on sliver hank 0.100 off .085 so all abnormality reduced and control bobbin short in Ring Frame
41	POST SPG M1-3	K - PS M1-3 01	We have put the trolley guards to avoid any damages.		work perfectly
42	POST SPG M1-3	K - PS M1-3 02	The wire covered by pipe		work perfectly
43	POST SPG M1-3	K - PS M1-3 03	After shifting the material on pallets Reduced the re working and about 4000 Kgs / Day extra material sieger on same cost		work perfectly
44	POST SPG M1-3	K - PS M1-3 04	. Identification board put in department to easy identification		work perfectly
45	POST SPG M4-6	K - PS M4-6 01	1.We save miss use of cartons, and also increased no of tubes in each weightings. 2. We can use this line in domesting packing also		work perfectly
46	POST SPG M4-6	K - PS M4-6 02	We are installed flexible pipe with air gun , to better house keeping and save compressed air		work perfectly
47	POST SPG M4-6	K - PS M4-6 03	Fixed a hook to hang when not in use		work perfectly
48	POST SPG M4-6	K - PS M4-6 04	We have fix the trolley guards to save the damages .		work perfectly
49	POST SPG M9	K - PSM9 01	Safety cover was not available for touch screen display of new PS assembly winder		Safety cover fixed for touch screen display of new cheese wdg.
50	POST SPG M9	K - PSM9 02	Fire Extinguisher Place Height is very Low So Chances of accident from trolley & Damage it.		Now Fire Extinguisher Place change in upper height. So it was not touch from trolley & no any damage.
51	POST SPG M9	K - PSM9 03	Pressure pipe cut and damage , due to this A/c cleaning was poor and wastage of air pressure .		Cleaning Pressure pipe change . Due to this A/c cleaning improve and no wastage of pressure .
52	POST SPG SJ11	K - PS SJ11 01	Before in content label MO no. small size .		Now we have change MO no. size Big & Bold & avoid any type of abnormalty.
53	POST SPG SJ11	K - PS SJ11 02	Before we have using 16 x 19 x 60 gauge polythene for covering full cone.	6.36	Now we have start using 16 x 19 x 50 gauge polythene & save 6.36 lacs / anum
54	QAD M 1- SJ11	K - QAD M1-SJ11 01	Twin roving guide used in middle zone of R/Frame for Roving grindle quality.		Improved uniformity in yarn & rejection in physical checking for shade variation will also be reduced. Recommending for executing in bulk production.
55	QAD M 1- SJ11	K - QAD M1-SJ11 02	Frequent checking of empty cones to avoid yarn on wrong cone tip working (U-7 empty cones racks)		Scope of passing wrong cone tip will be restricted in use / running process.
56	QAD M 1- SJ11	K - QAD M1-SJ11 03	Complete partition was provided between Dyed / Recycled yarn / fresh grey yarn working in TFO working of U-9		Restricted scope of passing dyed fibre contamination.
57	QAD M 1- SJ11	K - QAD M1-SJ11 04	Dyed / Recycled fibre running A/Coner's should be separated & not working in between A/C's (U-9A)		Restricted scope of passing dyed fibre contamination.
58	QAD M 1- SJ11	K - QAD M1-SJ11 05	To get improved loose ends appearing from out side of the pallet .		Getting improved physically with no loose end appearing from out side of the pallet.
59	QAD M 1- SJ11	K - QAD M1-SJ11 06	Damaged cartons in finished goods godown & improving the material handling during shifting		Yarn sales have been asked / discussed further not to keep damaged cartons in finished goods godown & improving the material handling during shifting ..
60	QAD M 1- SJ11	K - QAD M1-SJ11 07	Taken no replacement of Mr. Sanjeev Gupta by reallocating the work of existing staff .	4.48	To get enhanced effectiveness / responsibility with the existing staff .
61	QAD M 1- SJ11	K - QAD M1-SJ11 08	Taken no replacement of Mr. LL Gupta by reallocating the work of existing staff .	10.38	To get enhanced effectinveness / responsibility with the existing staff .
62	QAD M 1- SJ11	K - QAD M1-SJ11 09	Taken no replacement of TGT (Mr. Abhishek Mishra) by reallocating the work of existing staff .	2.32	To get enhanced effectinveness / responsibility with the existing staff .
63	QAD M 1- SJ11	K - QAD M1-SJ11 10	Dyes & Chemical testing without keeping any extra staff .	4.20	Executed
64	QAD M 1- SJ11	K - QAD M1-SJ11 11	Measuring vessel for Chemical / liquid .	0.18	Started using - Getting avoided engaged extra man for taking out sample from container .

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
65	QAD M 1- SJ11	K - QAD M1-SJ11 12	Stationary saving	0.30	Under execution
66	QAD M 1- SJ11	K - QAD M1-SJ11 13	SJ-11 Taken additional responsibility of SJ-11 QAD without replacement of Sh RK Singh (AGM)	13.68	SJ-11 Taken additional responsibility of SJ-11 QAD without replacement of Sh RK Singh (AGM)
67	MAINT M1-3	K - MAINT M1-3 01	IN LR C 1/3 CARDING MACHINE THERE WAS PROBLEM CAN ROTATING PROBLEM IN CAN CHANGER UNIT, DUE TO NO GRIP OF CAN IN SAME.		WE MAKE A CUT ON FLOOR CAN CHANGER PLATE FOR CAN GRIPPING HENCE PROBLEM SOLVED.
68	MAINT M4-6	K - MAINT M1-3 02	FANCY DOUBLING CHAIN SPROCKET WHEEL WORN OUT DUE TO THIS CHAIN BREAK WAS MATTER OF COURSE.		WE REPAIRED SPROCKET WHEEL HENCE PROBLEM HAS BEEN SOLVED.
69	MAINT M4-6	K - MAINT M4-6 01	EARLIER THERE WAS AEROFEED CARDS IN MILL 5.	2	WE MODIFIED THE AEROFEED CARDS(MC NO-1,2,3&19) IN LAP FEED CARDS IN MILL 5 INHOUSE WITHOUT PURCHASING ANY SPARE AND SAVED RS-200000.
70	MAINT M4-6	K - MAINT M4-6 02	THERE WAS METAL SHEET IN SIDE OF BOE,FIBRE STICKING PROBLEM IN SIDE OF MC.		WE PUT SS SHEET IN SIDE OF MC,AND FIBRE STICKING PROBLEM SOLVED.
71	MAINT M4-6	K - MAINT M4-6 03	THERE WAS FIBRE JAMING IN SIDE OF FEED LATTICE IN BOE.		WE MAKE SIDER WITH GI SHEER TO AVOID SIDE AMING IN FEED LATTICE IN NEW INSTALLED BOE IN MILL 4.
72	MAINT M 9	K - MAINT M9 01	Faced difficulty during winding 7s P/V SLUB Yarn on Autoconer AC X5 due to low Strength Yarn . Frequent Yarn breaks on Autoconer .		Cone winding machine is Set for rewinding of Ring bobbin with Modification in Yarn Path i.e. Tension Assembly , Bobbin Peg etc
73	MAINT M 9	K - MAINT M9 02	Spares are not kept properly in Maint room M9 due to facility not available .		Scrap Material Square Pipe used to Made Rack for Keeping Spares .
74	MAINT SJ11	K - MAINT SJ11 01	LD 2 CREEL DRIVE BELT DAMAGE.		BELT WAS NOT IN STOCK. OVERHEAD OLD BELT USE IN PLACE OF LD2 CREEL DRIVE BELT
75	MAINT SJ11	K - MAINT SJ11 02	MOST OF RTS WHEEL DAMAGE NEW WHEEL .ONE RTS WHEEL COST IS 1050 RS		REPAIR THE WHEEL IN LOCAL MARKET.REPARING COST OF WHEEL IS 300
76	MAINT SJ11	K - MAINT SJ11 03	BALCONE ASSLY BROKEN DUE TO CONE THROWING		BAL CONE ASSLY NOT IN SPARE ,IN HOUSE REPAIRED USE DAMAGE BALCONE ASSLY
77	MAINT SJ11	K - MAINT SJ11 04	SPLICER 4941 A ACTULATER THREAD DAMAGE		CLAMP IS MADE TO HOLD THE SPLICER ACTUATLER BODY
78	MAINT SJ11	K - MAINT SJ11 05	PALLETIZER GRIPPER COST FROM OEM IS 127531. GRIPPER GD-308 NC (NUENHAUSER)	0.63	SAME SPARE IS PROCURE FROM LOCAL MARKET IN RS 64718(Allied Automation Engineering Services Pvt. Ltd. )
79	ENGG M1-3	K- Engg M123-01	Auto coner printer cover		After Kaizen printer cover installed by acrylic sheet
80	ENGG M1-3	K- Engg M123-02	Cable dressing of street light pole		After kaizen cable dressing done
81	ENGG M1-3	K- Engg M123-03	Led tower light of main gate highway side		After kaizen we installed led flood light on tower
82	ENGG M1-3	K- Engg M123-04	Led tower light in front of B- mess		After kaizen we installed led flood light on tower
83	ENGG M1-3	K- Engg M123-05	PPW machine display safety cover		After kaizen we use acrylic sheet for display cover
84	ENGG M1-3	K- Engg M123-06	Fix type filler installed on savio orion		After kaizen we installed fix type filler
85	ENGG M1-3	K- Engg M123-07	PS winding display safety cover		After kaizen we installed display safety cover
86	ENGG M4-6	K- Engg M4-6-01	The Electrical supply for carpanter work area is open condition with fuses & mcb not properly fitted .		Replace with proper panel Enclosure provided with all types mcb for protection
87	ENGG M4-6	K- Engg M4-6-02	The power supply going to contractor work area is having fuse fitting ,many fuses bypass already & no protection for tripping which is unsafe		Replace with MCCB & all outgoing through 3 pole mcb which is now safe will tripped & protect futher damage
88	ENGG M4-6	K- Engg M4-6-03	The supply provided for connecting welding machines & othert equipment is very unsafe.Risk of accident or injury anytime.		After that proper wiring mcb box & industrial plug symmetrical .Risk of accident reduce.

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
89	ENGG M4-6	K- Engg M4-6-04	The pricol counter meter installed having high failure rate & obsolete declared by LMW		The pricol counter meter installed having high failure rate & obsolete declared by LMW
90	ENGG M4-6	K- Engg M4-6-05	MCB box to start the grinder & it is observed that this grinder is continuous on when not in use.		Installed foot switch to switch it on so when we need to work on it & will cut off when you left the place after work.
91	ENGG M4-6	K- Engg M4-6-06	The back side power panel cover of drums are open & unsafe due to plastic panel lock broken .		Replace with metallic panel lock like savio polar machines now all five machines panel closed .
92	ENGG M4-6	K- Engg M4-6-07	Outside lights switchoff manually by electrician & some time this lights are on upto 8 AM .Consuming more power with no need .		Installed time switch which will on/off these lights as per adjustable time.
93	ENGG M4-6	K- Engg M4-6-08	The lighting of fork lift work area is manually controlled & it is observed that during day time also these lights are kept on if not switched off timely.		Taken it controlled through street light time switch by taking help of Civil for making cable routing.Now lights cut off timely.
94	ENGG M9	K- Engg M9 -01	Sensor modification on 5 Ton electric hoist.		Some time crane deviate from its track and very difficult to take back on track. We install sensor to stop its wheel deviation.
95	ENGG M9	K- Engg M9 -02	Motor terminal box modification		There was temporary terminal box on Bharat bijli motor of 55KW. We develop in-house proper metal box and fix on motor.
96	ENGG M9	K- Engg M9 -03	Limit switch in-house repairing		All Chinese S/F safety limit switch were out of order and were by passed. We arrange to repair in house and take all them in circuit.
97	ENGG M9	K- Engg M9 -04	Switch modification for OHTC on S/F LF-4200		There was starter to operate OHTC of S/F LF-4200. We just install selector switch and remaining part of contactor placed in electric panel of S/F.
98	ENGG M9	K- Engg M9 -05	Lighting installation in R/F trench		There was darkness in M-9A R/F return air trench. We install proper lighting arrangement in trench.
99	ENGG SJ11	K - ENGG SJ11 01	Costing of Autoflow Automatic Grease Lubricator as per OEM is Rs. 108680.00	0.41	We explore from indian market with help of Purchase Deptt. & found same specification Automatic Grease Lubricator, Lubricator cost is Rs. 67500.00 thus saved Rs. 0.41 Lacs
100	ENGG SJ11	K - ENGG SJ11 02	It is observed that plant lighting power cons. Increases in summer season due to Higher usage of Fans & AC.		We Prepared an energy saving awareness note and oath was taken by all SJ11 staff members by signing on it. After that the note was converted into a flex and displayed on the plant entry gate.
101	ENGG SJ11	K - ENGG SJ11 03	It is observed that whenever TFO 24 VDC Power supply gets defective m/c doesn't stop which may deteriorate the yarn quality		We installed additional relay in panel & modified control circuit such that whenever 24 VDC power supply gets fail, m/c will stop.
102	ENGG UTILITY	K - ENGG UTILITY 01	Mill no-9B R/F dust collector room door repair	0.12	After Kaizen We have repair this gate by using g.i. sheet. By repair this door we have save the cost of new door (luwa).
103	ENGG UTILITY	K - ENGG UTILITY 02	Fix a new line for petcock.	0	After Kaizen We have fix a new line for boiler petcock. By this line the petcock is easily going to boiler and also we are maintaining 5S.
104	ENGG UTILITY	K - ENGG UTILITY 03	Shift the steam header to out side from mill no-4 &5	0	After Kaizen We have shift this steam header to the outside of mill no-n 4& 5.by shifting this header to outside there is more space to work. And increase the safety. and also maintaining 5S.
105	ENGG UTILITY	K - ENGG UTILITY 04	Installed new water tank for NPD.	0	After Kaizen we have fix a new water tank for NPD water
106	ENGG UTILITY	K - ENGG UTILITY 05	Fix a new water cooler on sajnabaad main gate.	0	After Kaizen We have fix a new water cooler for people. by this water cooler we have make a new source of water for main gate.
107	ENGG UTILITY	K - ENGG UTILITY 06	Increase the capacity of thermax RO.120 KLD to 165 KLD	2.28	After Kaizen we have increase the capacity of thermax RO 110 KLD to 165 KLD.
108	DYE HOUSE	K - Dye House 01	Safety angels for corner	0	Angels provided .to protect from wear & tear
109	DYE HOUSE	K - Dye House 02	Cable Dressing Work	0	Improves 5S
110	DYE HOUSE	K - Dye House 03	Systematic arrangement of drums	0	Angels provided .to protect from wear & tear
111	DYE HOUSE	K - Dye House 04	Display of direction	0	Improves 5S & safety of display
112	DYE HOUSE	K - Dye House 05	Improved visibility	0	Safety at work
113	DYE HOUSE	K - Dye House 06	Separate room for Hazardous chemical	0	Safety handing of chemical
114	DYE HOUSE	K - Dye House 07	Insulation on steam supply line of dryer	0	Improves work environment
115	DYE HOUSE	K - Dye House 08	Insulation for steam line	0	Improves work environment
116	DYE HOUSE	K - Dye House 09	Partition at dryer area	0	Reduce sweeping waste

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
117	IT	K-IT-01	Lot no on content sheet is written in small size, that is invisible from distance and needs to write lot no by marker pen manually		Now Lot no is printed in bigger font size, no need to write lot no. manually
118	IT	K-IT-02	Manual Checks and control placed for variance Report for P&A		Provided system generated Report for Department wise Days of Month for Checking Hands.
119	IT	K-IT-03	There is only Two Camera was installed, so that 20" Vehicle no in Slip was not readable,		After Updating the Software We are using Three Camera in the Software so that the Vehicle Slip print on Both Case is readable
120	Stores & Purchase	K - S&P 01	Tube Light arrangement		We have replaced all Tube Light with LED Lights which energy efficient and more visibility and also office looked now better instead of old.
121	Stores & Purchase	K - S&P 02	Office Chair		We have replaced all office chairs with same design and replaced cloth in one colour for better office look
122	HRD & Training	K - HRD - 01	Easy communication- We have started video presentation in our classroom.		Easy communication- we have started to show process video and motivational video in classroom
<b>Total Annualized Gain for the Month of Apr.'17</b>				<b>49.81</b>	