RSWM Kharigram - KAIZEN Summary Sheet for April 2016					
S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	Mill no. -1 S/f no. -1 (LF -1400) spindle capacity -108.		Addition of 12 spindles in Simplex no.1 and making the machine with 120 spindles in place of 108spindles.
2	SPG M1 - 3	K - SPGM1-3 02	Mill no. -1 Shift officer office not maintain as per 5S.		Mill no. -1 Shift officer office maintain as per 5S & good looking .
3	SPG M1 - 3	K - SPGM1-3 03	Mill no. -3 Contamination problem due to old type mixing bins.		Mill no. -3 Mixing bins modify & prepared new type . No cotamination due to mixing bins , good looking & 5 S maintained.
4	SPG M4-6	K - SPGM4-6 01	Identification of different type finish/Antistaics in Blow room Mill no.4		Identifications of finish looking attractive/5 S maintained.No Chances of Mistakes.
5	SPG M4-6	K - SPGM4-6 02	Identification of dropping box as per 5S in Blow room Mill no. -4		Looking good and 5S maintained
6	SPG M4-6	K - SPGM4-6 03	Identification of shift incharge's office in Mill no.4		Identification done and Looking attractive/ 5S maintained.
7	SPG M4-6	K - SPGM4-6 04	Identification of store room in Mill no.4.		Identification done and Looking attractive/ 5S maintained.
8	SPG M4-6	K - SPGM4-6 05	Empty bobbins racks kept behind simplex in mill no.5		Department become Spacious for movement/Good looking
9	SPG M4-6	K - SPGM4-6 06	Wall Opening in front of Ring Frame no.10 in mill no.6		Department become Spacious for movement/Good looking
10	SPG M4-6	K - SPGM4-6 07	Side box at Off End removed from LF1400 Simplex		Working Space available in the depatment
11	SPG M4-6	K - SPGM4-6 08	MS partition in mill no.5 between ring farme no.12 and 13		Relief in Contamination problem.
12	SPG M4-6	K - SPGM4-6 09	MS partition in mill no.5 between simplex no.4 and ring frame no.1		MS Partition Put in between Simplex no.4 and Ring Frame no.1 which is looking attractive and 5 S maintained. Contamination problem also reduced in this Area.
13	SPG M4-6	K - SPGM4-6 10	Wall removed in between Simplex no.1 and simplex no.2 in mill no.6		Wall removed from the front side of Simplex no.1 and Space availability which helping in routine working at shop floor.
14	SPG M4-6	K - SPGM4-6 11	Increase in height for Water and antistatic stand in Blow room Mill no.5		Drum Stand's height increased which is looking attractive and 5 S maintained.
15	SPG M9	K - SPG M9 01	Electric cable trench was open .It may lead an accident.		Electric cable trench covered with MS sheet cover.
16	SPG M9	K - SPG M9 02	Contamination sucking by TOT1		GI sheet jali introduced to contrle contamination
17	SPG M9	K - SPG M9 03	DF cans band strips got loose.		Band strips restiched.
18	SPG M9	K - SPG M9 04	Notice were pasted on wall directly.		Notice board introduced in production office.
19	SPG M9	K - SPG M9 05	Fly coming through broken false ceiling.		False ceiling replaced by new one.
20	SPG M9	K - SPG M9 06	Second quality area was not identified.		Second quality area identified with yellow marking tape.
21	SPG M9	K - SPG M9 07	Grinder stone cover was breaking frequently.		Cover fixed with an extra nut-bolt.
22	SPG M9	K - SPG M9 08	Grinder running idle because its switch was always on.		Foot press switch introduced.
23	SPG M9	K - SPG M9 09	Fire extinguisher area was not identified in 9B.		Fire extinguisher area identified withn yellow marking tape in 9B.
24	SPG M9	K - SPG M9 10	Fly accumulated on pinter cable.		Pinter cable cover introduced.
25	SPG SJ11	K - SPG SJ11 01	SF OHTC waste collection system was operate by separately 4 kw * 2 motor	2.43	Now OHTC waste collecting by , machine fan waste collecting motor
26	SPG SJ11	K - SPG SJ11 02	We observed yellow marking tape damage		Renewed yellow marking tape & maintained 5 'S'
27	SPG SJ11	K - SPG SJ11 03	We observed C/F and D/F yellow mark area was not align as per 5'S'		Now Maintained as per 5 'S'
28	SPG SJ11	K - SPG SJ11 04	We observed SF trolley was not fix as per SF no.		Put trolley nos on each trolley as per SF no & maintained 5 'S'
29	SPG SJ11	K - SPG SJ11 05	We observed Fire extinguisher area was not defined		Area defined as per 5 'S'
30	SPG SJ11	K - SPG SJ11 06	We observed there was no any bobbin colour identification in deptt.		We use scraped display board & for RF bobbin identification & maintaining 5 'S'
31	SPG SJ11	K - SPG SJ11 07	RF OHTC waste collecting boy forget to start switch after removing waste from waste bag		Now we paste instruction paper near switch .
32	SPG SJ11	K - SPG SJ11 08	We observed Unit name not defined on entrance gate		Now paste unit name in front of entrance gate & maintaining 5 'S'
33	SPG SJ11	K - SPG SJ11 09	Machine number was not defined in B/R section		Now defined as per 5 S
34	SPG SJ11	K - SPG SJ11 10	There was no any monitoring system for RF bottom roll cleaning by sider		Now we introduce sider charge register to monitor shift wise RF bottom roll cleaning
35	POST SPG M1-6	K - PS M1-6 01	We were facing poor house keeping and material handling in Doubling and Auto coner		After started tapa system house keeping and material handling has been improved
36	POST SPG M1-6	K - PS M1-6 02	On Peass cheese wdg.there was a problem to keep extra cheeses.		Modify the creel system by adding one extra creel.
37	POST SPG M9	K - PSM9 01	In Packing M-9 waste / scrap box place fixed & identified with yellow line.		Waste / scrap box place fixed & identified in packing M-9.
38	POST SPG M9	K - PSM9 02	Packing office table marked with yellow line		Packing office table marked with yellow line
39	POST SPG M9	K - PSM9 03	In packing M-9 checker table place fixed & identified with yellow line		In packing M-9 checker table place fixed & identified with yellow line
40	POST SPG M9	K - PSM9 04	In Yarn conditioning room M-9 A steam line given to increase moisture gain in yarn.	2.19	Now we have fixed steam line in yarn conditioning room M-9A & taking extra moisture gain in final product. Gain in Rs. 219780 / year @ 0.01% moisture gain.
41	POST SPG SJ11	K - PS SJ11 01	In Linkconer usable wax aria not idenfied.		Usable aria fix & identified.
42	POST SPG SJ11	K - PS SJ11 02	Scrap aria not fix.		Scrap aria fix.
43	QAD M 1- 6	K - QAD M1-6 01	Auditing of all R/F's for identifying damaged seperators .		To control abnormal variation in hairiness / fly generation / goli formation
44	QAD M 1- 6	K - QAD M1-6 02	Identification of TFO / Dbg winders for TPI variation at knot .		To control bullets (TPI variation) related complaints
45	QAD M 1- 6	K - QAD M1-6 03	Critical NPD products fabric sample will be get knitted from out side agency .		It will support in providing corrective steps taken at plant .
46	QAD M 1- 6	K - QAD M1-6 04	VIP lot detail tracking separately .		It will help in analyzing the process history sheet at a glance .
47	QAD M 1- 6	K - QAD M1-6 05	Customer feed back / inputs will be discussed completely on forthnightly basis in coordination meeting .		To take corrective steps timely .
48	QAD M 1- 6	K - QAD M1-6 06	Presentation on Bad habits / Major system lapses to staff covering Prodn / Mtc / QA / IR / Training jointly.		To create enhanced awareness as well as understanding of inter related issues for marching towards Quality Year - 2016 .
49	QAD SJ11 & M9	K - QAD SJ11 01	Test length, Testing time, Testing speed mention in front of UT5 & UT4 instrument.		Reduce chanceage of testing Error & Follow 5s System.
50	QAD SJ11 & M9	K - QAD SJ11 02	Std. TPI Chart show in front of TPI Machine.		Reduce chanceage of testing Error & Follow 5s System.
51	QAD SJ11 & M9	K - QAD SJ11 03	Trial Study between different type of finish in mixing CRODA finish VS Lakeland finish. For count (Ne) – 1/30s P/V 65/35		Improvement in yarn quality.
52	QAD SJ11 & M9	K - QAD SJ11 04	Reduce IPI value in Ne- 1/18sVIS. Bamboo material .		Reduce IPI value & improve in yarn quality.
53	QAD SJ11 & M9	K - QAD SJ11 05	Prepare card samples & take corrective action against high IPI value of card no – 21 (Count (Ne)- 1/30s P/V)		Reduce IPI value & improve in yarn quality.
54	QAD SJ11 & M9	K - QAD SJ11 06	Prepare card samples & take corrective action against high IPI value of card no-32 (Count (Ne)- 1/30s P/V)		Reduce IPI value & improve in yarn quality.
55	MAINT M1-3	K - MAINT M1-3 01	OLD YARN PRE CLEARER OF AUTOCONER PRESSURE PIPE CONNECTOR DAMAGED.		WE MODIFIED YARN PRE CLEARER DILL AT ITS BACK SIDE AND FIT PRESSURE PIPE , CLOSE OLD HOLE BY M-SEAL.
56	MAINT M1-3	K - MAINT M1-3 02	IN SAVIO AUTOCONER YARN TRAP SHUTTER BLADE GOT DAMAGED.		WE REPLACED YARN TRAP SHUTTER BLADE BY G.I. SHEET BLADE.
57	MAINT M1-3	K - MAINT M1-3 03	IN AUTOCONER SAVIO ORION HEAD STOCK FILTER SCREEN JAM AND DAMAGED.		WE REPLACED DAMAGED AND JAM SCREEN BY METAL SCREEN.
58	MAINT M1-3	K - MAINT M1-3 04	IN ACX-5 M/C BODY GET DAMAGED BY TOUCHING TROLLEY WAS MATTER OF COURSE.		WE FITTED A PVC SHEET AT RHS MACHINE AT WHICH PROBLEM WAS HIGHER.
59	MAINT M4-6	K - MAINT M4-6 01	THERE WAS AIR PRESSURE LEAKAGE INBLOWWROOM SCTURE LAP REGULATING UNIT IN BRASS PIPE.		WE REPLACED TO THE BRASS PIPE BY PU PIPE NOW PROBLEHAS BEEN SOLVED.
60	MAINT M4-6	K - MAINT M4-6 02	MISSING SPARE PARTS AND GEARS IN RING FRAME DURING GENERAL CLEANING WAS MATTER OF COURSE.		WE INTRODUCE A G.I. SHEET TRAY FOR PLACING GEARS AND OTHER SPARE PARTS OF RING FRAME AND NOW PROBLEM HAS BEEN SOLVED TIME SAVING.
61	MAINT M 9	K - MAINT M9 01	Bal cone Body cover gets loose due to it is not fix and it gets jerk because of Piston jam during operation .So because of this Jali cone produce and Ring bobbin rejection increased due to tension break . Drum Efficiency will reduce . Chances of Bal cone Body damage .		Bal Cone Body fixed with Screw so it is not loose and hence no jerk of Bal cone body and free movement of Piston . Jali cone and Ring Bobbin rejection reduced and Tension break reduced and drum Efficiency increased . Avoided Bal cone body damage .
62	MAINT M 9	K - MAINT M9 02	Berkolizing machine inside rollers are not move due to Chain loose running because of Chain Slippage . Because of poor Cots Berkolizing quality found poor machine working performance .		Chain Slippage is avoided with Tension Pulley is provided . Now no Slippage of Chain and hence rollers are move freely . Because of good Cots Berkolizing quality found improved machine working performance .
63	MAINT M 9	K - MAINT M9 03	In Ring Frame LR 60 A , at Off End fly gets accumulated on Gears due to open . Chances of Breakdown due to gear teeth damage .		Scrap Rexine sheet is fixed on Gear Box . So Fly accumulation is avoided . Breakdown due to gear teeth damage is avoided .
64	MAINT M 9	K - MAINT M9 04	Blow room line no 2 Condenser is running in line .		Blow room line no 2 Condenser is bypassed . Now running without Condenser .

65	MAINT SJ11	K - MAINT SJ11 01	Before this rack type arrangement all card wire is placed on floor. Due to this arrangement some time wire catch moisture and get rusted.		In house rack is made and due to this arrangement wire is protected to get rusted
66	MAINT SJ11	K - MAINT SJ11 02	Fiber is pass in b/w opening roll and machine frame due to this frequently opening roll jam problem in Card LC-333		Metal Cap is placed both of end of opening roll. So frequency of opening roll jam is reduced
67	MAINT SJ11	K - MAINT SJ11 03	Spindle tape joining is very time consuming process in ring frame deptt.		Provide power switch in Ring frame. Due to this patrolling time of running fitter is reduced.
68	MAINT SJ11	K - MAINT SJ11 04	In house tool trolley is made with the help of unusable scarp		Trolly made from Scrap and using
69	ENGG M1-3	K- Engg M1-3-01	Creative Bearing Puller	0.10	We have Financial Benefit in this kaizen because motor life increase due to this kaizen
70	ENGG M1-3	K- Engg M1-3-02	Created Motor Coil Rewinding Option	0.05	Due to this kaizen we can improve productivity and also save man power .
71	ENGG M1-3	K- Engg M1-3-03	Motor Rewinding Insulation Varnish Re-use	0.15	Due to this kaizen we have financial benefits because we can re-use motor insulation varnish in motor
72	ENGG M4-6	K- Engg M4-6-01	Previously the enclosure is not attractive & good looking .Also wires are visible .		Replace with good & attractive enclosure with all wires covered properly & good for safety .
73	ENGG M4-6	K- Engg M4-6-02	No any facility to cut off power in carding c1/3 due to main switch regular single phasing & missing & by passed electrician.		Fixed with three pole MCB enclosure box to cut off power & no any phase missing problem now.
74	ENGG M4-6	K- Engg M4-6-03	The drive having very unsafe condition & wires are in zig zag condition.		Inverter install in a proper panel box provided with proper ventilation & cooling fan. Now Safe condition.
75	ENGG M4-6	K- Engg M4-6-04	M/C having five no. lamp for different functions .Frequently lamp fusing problem.		Replaced with new dome light having five colour effect .
76	ENGG M9	K- Engg M9 -01	Line-3 WCS PLC was doing malfunction.		Explore in local market to devlop program and replace the PLC
77	ENGG M9	K- Engg M9 -02	There was open fitting of tube light.		Replace with LED street light.
78	ENGG M9	K- Engg M9 -03	10 nos. Halogen light of 250W were in daye house which were aslo doing problem lit up.		We replace them with LED light.
79	ENGG M9	K- Engg M9 -04	There was Lenze drive for DFK feed.		Replace with danfos drive and make it in circuit.
80	ENGG M9	K- Engg M9 -05	We were facing side cut during power fail.		We explore the solution in local market and go for conversion of drive and UPS.
81	ENGG SJ11	K - ENGGSJ11 01	After 2 No's Unimix stopped in North Side Blow room Line, we observe Pascal of MA Fan increase as per requirement.	6.42	We optimized the inverter frequency with respect to Pascal of MA Fan and department requirement.
82	ENGG SJ11	K - ENGGSJ11 02	We Observe South Blow room & Carding H-plant SA & RA fan was generating Higher Air consumption as per Luwa Engineer Report.	5.13	We optimized the blade angle of SA & RA fan without effecting of RH % & Temperature in department.
83	ENGG SJ11	K - ENGGSJ11 03	Observe Barco DU-10 Antenna Broken Problem & due to this communication failed between DU-10 Module & WDL server. Due to Production parameter not show on computer.		We have fixed a safety guard for Antenna of DU-10 module.
84	ENGG SJ11	K - ENGGSJ11 04	Observe Birds & Pigeon entered from Fresh & Exhaust air dampers of H-plant.		We fixed 1" wire mesh on fresh & exhaust air damper of H-plants to avoids birds in H-plant rooms.
85	ENGG SJ11	K - ENGGSJ11 05	Observe wall damage due to Vibration DC fan motor which was mount on wall of TFO-south phase filter room.		We make in-house stand & fixed motor on stand
86	ENGG SJ11	K - ENGGSJ11 06	Observe during maint of xorella we used ladder for work which is unsafe.		We used flat wooden Ply board for safe working.
87	ENGG SJ11	K - ENGGSJ11 07	Observe TFO Main motor cooling fan choke with fly & due to motor temp. increase.		We covered the Main motor cooling fan Net with wire mesh & observe motor temp. reduce.
88	ENGG SJ11	K - ENGGSJ11 08	Observe difficulty in BTS Travelling motor wheel.		We made in-house puller with help of workshop person for wheel replacing of BTS Travelling motor & reduce down time.
89	ENGG SJ11	K - ENGGSJ11 09	Observe compressor identification not mentioned.		Compressor identification done.
90	ENGG SJ11	K - ENGGSJ11 10	Observe difficulty in H-plant Pump disassemble.		We made in-house puller for Pump disassembling.
91	ENGG SJ11	K - ENGGSJ11 11	Found Iron rod in DC fan room of TFO South phase filter room which was unsafe.		We cutted the Iron rod.
92	ENGG SJ11	K - ENGGSJ11 12	Observe Boxing Line Printer fault reset push button not proper position due to difficulty in working.		We shifted the position of fault reset push button.
93	ENGG SJ11	K - ENGGSJ11 13	Observe Telephone cable cutted problem in utility area.		We shifted the position of Telephone from table to wall.
94	ENGG SJ11	K - ENGGSJ11 14	Observe UPS stand not available.		We made in-house stand for UPS.
95	ENGG SJ11	K - ENGGSJ11 15	Observe desert cooler identification not mentioned.		Desert cooler identification done.
96	ENGG SJ11	K - ENGGSJ11 16	Observe Drinking water tank & water cooler cleaning schedule identification not mentioned.		Cleaning Schedule Identification done.
97	ENGG SJ11	K - ENGGSJ11 17	Observe identification of HT Panel room not mentioned at Wartsila.		Panel room Identification done.
98	ENGG UTILITY	K - ENGG UTILITY 01	RO rinse water use in raw water RO Plant.	3.41	We have Re-use of rinse water in raw water RO Plant. This water is stopped in ETP and Rinse water re-use in RO Plant.
99	ENGG UTILITY	K - ENGG UTILITY 02	RO Plant pump suction line replaced by PPR		RO Plant pump suction line replace by PPR with dressing work in house team.
100	ENGG UTILITY	K - ENGG UTILITY 03	Fitted a closed plug made		We have fitted of closed plug made by GI Sheet.
101	ENGG UTILITY	K - ENGG UTILITY 04	Insulation Work on Drinking water line.		Drinking water line insulation work and drinking water is coming cold.
102	ENGG UTILITY	K - ENGG UTILITY 05	Fixed a sheet for avoid Fiber in department		Fiber shorting area. We have fixed the Sheet in side .So , avoid the Fiber is not spread in department mill no.9
103	ENGG UTILITY	K - ENGG UTILITY 06	Tank capacity increase		Drinking water capacity is low And tank capacity is increased from 1 KL to 2 KL.
104	ENGG UTILITY	K - ENGG UTILITY 07	Installed high efficient cooler in NPD		NPD. We have installed the high efficient Air Cooler in NPD for maintain the Temp. and RH.
105	ENGG UTILITY	K - ENGG UTILITY 08	Installed the Air receiver for maintain the pressure		Mill no.9 B. We have installed the Air receiver for maintain the pressure in uniformly.
106	ENGG UTILITY	K - ENGG UTILITY 09	Fixed main hole cover		Mill no. 9 B. We have fixed the main hole cover made by MS Sheet.
107	ENGG UTILITY	K - ENGG UTILITY 10	Make the Jali and avoid the drain jam.		Mill no.9.Fiber shorting area. Make the Jali and avoid the drain jam
108	ENGG UTILITY	K - ENGG UTILITY 11	Minimize the excess supply of High air pressure	4.49	We have supplied the high air pressure uniformly distribution by pipe line in all mills and also arrest some leakages .
109	DYE HOUSE	K - Dye House 01	we have increase grey godown capacity from 30mt to 50 mt by arranging systematic manner (using paliot system).By using this system we have finanicial gain as the truck unloaded directly to dye- house godown.	1.18	By using this system we have financial gain as the truck unloaded directly to dye-house godown.we have save transport fair from RMG to dye-house godown.(one truck cpacity 34 bale&transport charge 11Rs for one from Rmgto D/H.) monthly required bale 1000 Bale.
110	DYE HOUSE	K - Dye House 02	FiLING system OF SHADE -CARDchange in systematic manner and repair to increase life of files.		Easy to finding shade cards with categorywise for working and looking god in office.
111	NPD	K - NPD 01	Yarn article and line of the Feeler sample has made in ERP after packing of the sample. If there is any mistake in shade and Lot No. then whole material has to be rechecked and labels of the cones has to be changed. This not only lead to rework but also lead to delay in sampling.		Now yarn article has made before releasing the mixing memo to the Pilot Plant. All clerical mistakes has checked and corrected before packing of the material.
112	NPD	K - NPD 02	Customer name has provided in the ERP for which sample to be dispatch. But dispatch person did not get the idea for which depo sample has been made from the customer name.		Now depo name has mention in the ERP for better communication and record.
113	NPD	K - NPD 03	all letter received from the party/customer for sample development has keep in one file for all depo. It take time to search the letter for one depo from this file.		Party standard file has made depo wise due to which we can easily trace the party letter depo wise.
114	P&IR	K - P&IR 01	Worker's Personnel Detail kept in flat file.	0.28	Worker's Personnel Detail kept in Index file.
115	HRD	K - HRD 01	Before kaizen no any racks identification.		Identification on racks. looking good & 5s maintained.
116	IT	K-IT-01	There added new fields of Approver profile, approved date and time on the Printing of MRN Bill Passing, Now there is no need to check manually, its printed on MRN It saves time and improve quality of work		Its moved on live and working on order in M-9 Packing
117	IT	K-IT-02	MRN Quantity part printed without User profile, If find any mistake in MRN, its was not traceable that who has prepared this particular MRN		Now after Kaizen its make the person accountable who has printed,
118	IT	K-IT-03	Earlier the CCTV of M9 Female canteen covers only two table of canteen, to cover whole canteen area, we have taken initiative and identify new place from where camera covers whole are of canteen, This saved cost of one camera		After re-allocation of this camera, It cover complete area of female Canteen of M9 that's visible in image
119	IT	K-IT-04	**PF Interest on Intranet with Arrear** Its required to update arrear on last PF balance, its take lots of time to compile in Excel		For this working we have develop the Additional Information Program & updated all raw data from Excel, It saved time of operator and having all data on system instead of excel
120	IT	K-IT-05	Developed Report for Function wise shift wise male-Female On roll Hands, **Before Kaizen:** Earlier it was maintaining in Excel sheet		Developed new report for Function wise shift wise male female on roll hands
121	IT	K-IT-06	Report for Monthly Higher Attendance **Before Kaizen:** User taken data from different sources and manually compile in excel		Developed report for Number of Working days of Workers in system and provided to user
122	CPPC	K - CPPC 01	Inter Unit Mix Container Stuffed & seal at plant	1.38	
123	GUEST HOUSE	K - GH 01	Alley Lights ON in Day Times.		We Switched off the Alley Lighting due to Good illuision & use Natural light.
124	GUEST HOUSE	K - GH 02	Water Cooler identification Not Mentioned.		We done identification of Water Cooler
125	GUEST HOUSE	K - GH 03	Proper place for Telephone instrument not present.		We Made a proper stand for Telephone instrument.
Total Annulized Amount				**27.21**	