

## RSWM Kharigram - KAIZEN Summary Sheet May-17

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M4-6	K - SPGM4-6 01	Put safety guard worker alley side on New rieter D/f in Mill No.-4		Put safety guard It is good looking , avoid chances of accident & 5s maintained .
2	SPG M4-6	K - SPGM4-6 02	Paint & identification on Checker almira of Ring frame mill no 4.		Paint & identification on checker almira. Its good looking ,attractive & 5s maintained.
3	SPG M4-6	K - SPGM4-6 03	Install side partition on blender no -1 &2 of Mill no. -4		Install side partition & avoid material spread problem on floor & maintained house keeping.
4	SPG M4-6	K - SPGM4-6 04	:Paint & identification on cloth / tiffin almira.in Ring frame Mill no. -4		Paint & identification on cloth /tiffin almira. Its good looking ,attractive & 5s maintained
5	SPG M4-6	K - SPGM4-6 05	Make proper arrangement for creeling roving bobbin to resolve lap linking problem.on Blow room Line Mill no.- 4		Make proper arrangement by making stand for creeling Roving bobbins & resolve lap linking problem.
6	SPG M4-6	K - SPGM4-6 06	identification of Ring frame bobbin room of mill no 4.		Make identification Its good looking ,attractive & 5s maintained.
7	SPG M4-6	K - SPGM4-6 07	identification of shift officer room ring frame mill no. 4.		Make identification of shift officer room. Its good looking ,attractive & 5s maintained.
8	SPG M4-6	K - SPGM4-6 08	Make identification of R/f maint room of Ring frame mill no 4		Make identification on R/f Maint.Room. Its good looking ,attractive & 5s maintained.
9	SPG M4-6	K - SPGM4-6 09	Install side partition on blow room line-1 &2 of Mill no. -4		Install side partition & avoid material spread problem on floor & maintained house keeping
10	SPG M4-6	K - SPGM4-6 10	Use of Licra room AC for cooling of DGM office through exhaust fan.	yes	Install exhaust fan in wall of licra room for cooling purpose & maintained comfort feeling.
11	SPG M9	K - SPG M9 01	Doffing trolley wheel broken due to this problem in doffing		Put wheel after repaired
12	SPG M9	K - SPG M9 02	Trench opening jail broken may be dangerous .		Trench jali repaired.
13	SPG M9	K - SPG M9 03	Doffing trolley broken		Doffing trolley repair
14	SPG M9	K - SPG M9 04	Bonda box cover handle broken ,handing not proper.		Bonda box cover handle put after repair .5S & safety maintain.
15	SPG M9	K - SPG M9 05	Allmeraha door handle broken .		Allmeraha door handle put after repair .safety improve
16	SPG M9	K - SPG M9 06	Breaker D/F 8 stand out		Breaker DF 8 stand tight with bolt in floor
17	SPG M9	K - SPG M9 07	Elect wire open		Elect. Wire cemented.
18	SPG M9	K - SPG M9 08	Scrap material was put in VIP alley proper place		Scrap material replaced from VIP alley 5S maintain
19	SPG M9	K - SPG M9 09	In RF 09 spindle break absent		Spindle break put. Safety improve .
20	SPG M9	K - SPG M9 10	NO Information board are any type like this not available for information of RF fitter in department .		Information board of RF fitter in department .
21	SPG M9	K - SPG M9 11	Wall tiles broken in VIP alley .of RF 13		After kaizen Wall tiles repair In VIP alley .of RF 13
22	SPG M9	K - SPG M9 12	Wide slots of trench opening cover Due to this RF bobbin to goes tendency in trench.		Change the cover with narrow slots.
23	SPG M9	K - SPG M9 13	Machine safety guard Broken OF RF 13		After kaizen ; Machine safety guard repairOF RF 13
24	SPG M9	K - SPG M9 14	Floor broken		Floor repair
25	SPG M9	K - SPG M9 15	Top arm handle broken		After top arm handle put safety & easy working improve.
26	SPG M9	K - SPG M9 16	Due to G.I . Sheet open near roving opener . May be dangerous .		Due to G.I . Sheet open near roving opener . Safety improve .
27	SPG M9	K - SPG M9 17	OLD type of curtain quality was not good.		Quality is good of new curtain.
28	SPG M9	K - SPG M9 18	fluff protector not available		After Kizen fluff protector available
29	SPG SJ11	K - SPG SJ11 01	We observe that in conference hall mica was replace by new one but police work pending		Police work done
30	SPG SJ11	K - SPG SJ11 02	We observe that in RF 39,40 RA slit was very narrow		Narrow slit repaired
31	SPG SJ11	K - SPG SJ11 03	We observe in between LD2 3,4 & RSB 6,7 A ordinary curtain was place which is also moveable		Now we fix grill in between LD2 3,4 & RSB 6,7
32	SPG SJ11	K - SPG SJ11 04	We observe RF Slit was very dirty		So we paint RF slit
33	SPG SJ11	K - SPG SJ11 05	In our plant there is no arrangement to sharp sider's knife		So a bench grinder installed
34	SPG SJ11	K - SPG SJ11 06	We observed that in poly 0.90 hank high strength above 80 LB so problem of undrafted in RF		So TM reduced
35	SPG SJ11	K - SPG SJ11 07	We observed that high breakage in hazira 30 poly machines		So increased TPI,now breakage reduced
36	SPG SJ11	K - SPG SJ11 08	We observe that high cuts and alarm level on LC		So trial taken of finish in poly hazira line no -5
37	SPG SJ11	K - SPG SJ11 09	We observed that high roving breakage on SF of poly hazira fibre in 0.60 hank		o TPM in creased by one step,now machine working improved
38	SPG SJ11	K - SPG SJ11 10	We observed that on RF22 LHS high start up breakage due to ring rail position was out		So height setting and homing done of ring rail
39	POST SPG M1-3	K - PS M1-3 01	On PULSAR Auto coner informater installed safty cover to avoid any damages.		work perfectly
40	POST SPG M1-3	K - PS M1-3 02	Installed rake system for packing material and arrange systematically		work perfectly
41	POST SPG M1-3	K - PS M1-3 03	We have installed a Printed board for moisture study cones.		work perfectly
42	POST SPG M1-3	K - PS M1-3 04	We have installed cover on informater in PS Ch Wdg. for safety point		work perfectly
43	POST SPG M4-6	K - PS M4-6 01	We have cover by safety guard around the machine		work perfectly
44	POST SPG M4-6	K - PS M4-6 02	We have installed industrial switch for extension the electric line.		work perfectly
45	POST SPG M4-6	K - PS M4-6 03	We have cover by safety guard around the machine		work perfectly
46	POST SPG M4-6	K - PS M4-6 04	After hank the tube light on stand save 8 tube lights power		work perfectly
47	POST SPG M9	K - PSM9 01	PVC Curtain changed for better look of deptt & to avoid dirty cone through it.		PVC Curtain replaced for better look of deptt. & avoid dirty cone through it .
48	POST SPG M9	K - PSM9 02	Wall tiles guard was not available		Wall tiles gaurd introduced.
49	POST SPG M9	K - PSM9 03	To increase pressure flow nozzle fixed in pressure pipe .		Pressure nozzle fixed in pressure pipe , due to this m/c cleaning improve .
50	POST SPG M9	K - PSM9 04	In M-9A THERE WAS LEAKAGE IN COMPRESSED AIR DUE TO VALVE / OPENER WAS NOT WORKING PROPERLY		Now valve /opener & locking system fitted perfectly in pressure line to control wastage of compressed air.
51	POST SPG SJ11	K - PS SJ11 01	Sleet of Post Spinning department not looking good rasty.		Now we have Paint sleet & looking nice.
52	POST SPG SJ11	K - PS SJ11 02	Before in packing section too much Pallet broken.		Now we have repair all broken wooden pallet & use as fresh.
53	QAD M 1- SJ11	K - QAD M1-SJ11 01	2/40's PV shade no. 948572 - Problem White spcs in physical fabric appearance		Shade was redeveloped with 2.0 Den PSF in place of 1.4 Denier PSF , Sample has been sent to customer for getting approval.
54	QAD M 1- SJ11	K - QAD M1-SJ11 02	Up to 10 % Own dyed fibre (PSF) in grey melange yarn will be card open		To avoid neps / unopen fibre clustures.
55	QAD M 1- SJ11	K - QAD M1-SJ11 03	Identification of high end breakages R/F of SJ -11 - R/F- no. 3 , 8 , 13 , 15 , 19 , 35 , 3 , 37 , 38 , 39 , 40		To make working normal / less winding cuts / Obj CMT Faults
56	QAD M 1- SJ11	K - QAD M1-SJ11 04	Identification of poor cleaning of R/F of SJ-11 Unit		To reduce exceptional winding cuts / less fly / Obj Faults passing in yarn
57	QAD M 1- SJ11	K - QAD M1-SJ11 05	Identification of low efficiency R/F's of SJ-11 Unit		For getting address the related issue to get standard efficiency.
58	QAD M 1- SJ11	K - QAD M1-SJ11 06	Optimization of D/F Breakaer bottom roll gauge for Poly yarn in SJ-11 Unit		Drastic improvement in IPI after changing Bottom roll gauge to 50/54 off 54/60 . Before changing gauge COP IPI 60.8 , After changing gauge COP IPI 38.1
59	MAINT M4-6	K - MAINT M4-6 01	AT THE DOFFING TIME CONE FALL DOWN AND SENSOR NOT SENSING THE CONE SO PACKAGE CONVEYORNOT STOP		WE MODIFIED THE PLATE BY MAKE A CUT ON PLATE THEN PROBLEM SOLVED.
60	MAINT M4-6	K - MAINT M4-6 02	THERE WAS BOBBIN CONVAYOR SUPPORT PATTI BROKEN.		WE MAKE IN HOUSE THIS PATTI AND PUT ON MACHINE.

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
61	MAINT M 9	K - MAINT M9 01	FRONT COVER OF SPEED FRAME BOBBIN GET BROKEN DURING WORKING BY TENETER .		EXTRA SCREW FIXED AT 3 POINT TO AVOID DAMAGE OF COVER . NOW WORKING IS SATISFACTORY AND NO DAMAGE OBSERVED .
62	ENGG M1-3	K- Engg M123-01	Flood led light of sajnabad main gate	0	After Kaizen LED flood light installed
63	ENGG M1-3	K- Engg M123-02	Flood led light of High way main gate	0	After Kaizen LED flood light installed
64	ENGG M1-3	K- Engg M123-03	Safety cover pf PS versa winding machine	0	After kaizen we installed safety cover
65	ENGG M1-3	K- Engg M123-04	Safety cover of Savio informantor	0	After kaizen we installed safety cover
66	ENGG M4-6	K- Engg M4-6-01	All wiring are unsymetrical & chances of accident .		After that proper wiring & fixed the modular switch socket reduces the risk of accident .
67	ENGG M4-6	K- Engg M4-6-02	There is dark zone in bin room area		After that installed 9 watt tubelight proper lux level maintain in bin room.
68	ENGG M4-6	K- Engg M4-6-03	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
69	ENGG M4-6	K- Engg M4-6-04	Machine equipped with mechanical based counter & which is not working properly as compliant by production deptt		Installed digital based counter meter including with sensor & sensor wheel . Now proper hank is coming shift wise .
70	ENGG M4-6	K- Engg M4-6-05	In moisture room wiring is not proper then unsymetrical .		Proper fixing pvc casing capping & tubelight the reduces risk of accident .
71	ENGG M4-6	K- Engg M4-6-06	There is dark zone in mill no 6 area		Installed street light proper fixed then is no dark zone area of mill no 6 .
72	ENGG M4-6	K- Engg M4-6-07	Machine having 100 AG servo amplifier in which failure rate is very high .		Installed mafe drive conversion without calling service engineer from sheltronics .
73	ENGG M9	K- Engg M9 -01	Blender panel modification to run Reiter BOE.		There was shifting of Reiter BOE from mill no.4, which don't have any panel. We make modification in exiting LMW blender panel and start the machine
74	ENGG M9	K- Engg M9 -02	75 KW drive panel shifting in power house.		Previously that drive was in WCS room and that room was very hot, due to that inverter was tripping frequently. So we replaced its place in power house. Now tripping problem solve.
75	ENGG M9	K- Engg M9 -03	LED light Street light replacement near yarn godown of M-9.		We got some removed LED street light from SJ-11. We replace the CFL street light with these LED light near M-9 yarn godown and make better luminance there.
76	ENGG M9	K- Engg M9 -04	Coal cresher panel Re commissioning		Coal cresher panel giving regular problem. Circuit was not proper. We remove all part from that panel and again recomsion in proper manner and start the system.
77	ENGG SJ11	K - ENGGSJ11 01	Earlier observed that Linc Coner 21C Balcon PCB 2-Pin Connector Broken problem (Total 10 Nos Defective)	0.035	We use 3 Pin Connector of defective PCB & repaired 5 Balcon PCB from 10 PCBs.
78	ENGG SJ11	K - ENGGSJ11 02	Total 20 Nos LED Street Lights defetive.	0.18	We try to repair street light inhouse & got repaired 4 street light.
79	ENGG SJ11	K - ENGGSJ11 03	Earlier it was observed that 1.5 kw Danfoss inverter is lying us with Long time due to wrong supply. (Dead inventory)		We installed 1.5 Kw inverter on Ch. Wdg no. 3 (on 6 drums) in place of 2.2 Kw inverter & spare 2.2 Kw inverter.
80	ENGG SJ11	K - ENGGSJ11 04	Packing Department Temperature increased problem & not comfortable environment to worker.		To improve Human comfortability, installed one additional exhaust fan in packing.
81	ENGG SJ11	K - ENGGSJ11 05	Packing Department Temperature increased problem & not comfortable environment to worker.		To improve Human comfortability, installed three additional pedestal fan in packing.
82	ENGG SJ11	K - ENGGSJ11 06	Drinking water cooling not proper problem.		Looking to summer season to improve water cooling, installed water chiller by inhouse material.
83	ENGG SJ11	K - ENGGSJ11 07	Earlier observed that Bench Grinder not available for Production deptt worker.		Installed bench grinder with safety instruction for Knife making for use of production deptt
84	ENGG UTILITY	K - ENGG UTILITY 01	Fix a new double PVC curtain in moisture room	0.00	After Kaizen We have fix a new double PVC curtain in moisture room due to this avoid moisture losses.
85	ENGG UTILITY	K - ENGG UTILITY 02	Fix a new water cooler near store	0	After Kaizen we have fix a new water cooler near store.
86	ENGG UTILITY	K - ENGG UTILITY 03	Fix a new G.I. cover on wet opener machine	0	After Kaizen we have fabricated and fix a new G.I. cover on wet opener machine due to this after fixing safety cover the fiber is not going in this gap.
87	ENGG UTILITY	K - ENGG UTILITY 04	:Fabricated a new platform for syntax water tank	0	After Kaizen we have fabricated a new platform for syntax water tank. Due to this increase the life of tank and maintaining 5S.
88	IT	K-IT-01	Reason wise stoppage report not having item code, item name and description fields, due to this user needs to get it through pivot table in excel and that's time consuming job for him		We have taken this task as a kaizen and added these fields in report itself, Now there is no need to get these fields in excel It saves user time 15 min/day
89	IT	K-IT-02	Manual Checks & control for on roll of deptt. Like Engg and Maintenance from different Reports		Provided AI (additional information) program with Department & designation Combo Box Entry so that User can Add Employee for on roll position
90	IT	K-IT-03	As we know that GST will be Implement in all Division from Jul-2017, for this we required complete details of all vendor, earlier its communication through e-mail		We have developed online form on intranet to Update the vendor Records on it, due to this all data receive on System directly, It avoid duplication of work and save time
91	HRD & Training	K - HRD - 01	Productivity-We have started to check lapetta of 2 R/F siders daily and motivated them to control hard waste.		Productivity-We have started to check lapetta of 2 R/F siders daily and motivated them to control hard waste
<b>Total Annualized Gain for the Month of Apr.'17</b>				<b>0.22</b>	