

RSWM Kharigram - KAIZEN Summary Sheet Dec 2017

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG SJ11	K - SPG SJ11 01	WE observed that in 0.60 Poly hazira fibre poor working and low csp at RF satge		So we go for lot changed of RF36-40 and take hosiarpur fibre,now working and CSP improved
2	SPG SJ11	K - SPG SJ11 02	WE observed that in 0.60 Poly hosiarpur fibre cut and alarm were high in LC		So we reduced TPM on SF satge by 1 step,now cuts alarm reduced
3	SPG SJ11	K - SPG SJ11 03	We observed that in 10 Poly high start up breakage on alternate day clutch cleaning		So clutch cleaning done per day of each machine
4	SPG SJ11	K - SPG SJ11 04	After maint cleaning of RF,there was not cross check system of abnormality in cleaning machine		So make a sytem to cross check cleaning machine after hand over
5	SPG SJ11	K - SPG SJ11 05	Water dropping problem in VIP alley as like drain		So repair work done by civil hands,now water dropping reduced
6	SPG SJ11	K - SPG SJ11 06	In 36 PV high running breakage on 3/0 U1US(+) Rtr		So we switch on 3/0 MSHF Rtr ,breakge reduced
7	SPG SJ11	K - SPG SJ11 07	In 12 poly hosiarpur breakge were high on 9.8 TPI		So we take trial and incresed TPI to 10.0,Breakge reduced
8	SPG SJ11	K - SPG SJ11 08	In 36 Poly running brakage were high on 5.2 winding length,44 mm chase length		So we take trial and go for 5.5 winding lenth ,42 mm chase length,now working improved
9	SPG SJ11	K - SPG SJ11 09	There is no system to check deparment house keeping section wise		So introduce a new system of 2 hourly check department house keeping
10	SPG SJ11	K - SPG SJ11 10	In VIP alley false ceiling was damaged due to rain water		So repair work by civil hands
11	POST SPG M1-3	K - PS M1-3 01	:: TROLLY OF PACKING IS VERY LARGE N HEAVY ,,,,AND ALSO FACING THE PROB OF LIGHT WEIGHT ETC ... AFTER KAIZEN WE HAVE USE THE RACT-ANGLE TROLLY FOR PACKING MATRIAL AND NOW WE HAVE FOUND NO ANY DIFFRANCE IN WEIGHT OF CONES & ALSO HOUSE KEEPING MAINTAIN GOOD.....		work perfectly
12	POST SPG M1-3	K - PS M1-3 02	WE HAVE OBSERVED THAT WHEN EVER WE HAVE TAKEN MATRIAL FROM THE MOISTURE GODOWN IN TROLLY ,,IT BECOMS TOUCHD WITH WALL & FRICTION WITH TROLLY CAUSING WALL BROKEN ,,WALL SCRATCH & WALL DAMEGED!! AFTER KAIZEN WE ARRANGED A SAFTY GUARD ON THE WALL NOW WE HAVE FOUND NO ANY DAMGED IN WALL & SCRATCH....		work perfectly
13	POST SPG M1-3	K - PS M1-3 03	THE CONES OF MOISTURE GODOWN FOUND DIRTY DUE TO SAFTY ANGLE NOT PROVIDE THE COLOUR PAINT ...& INCREASE THE REWNDG OF DEPT DUE TO ABOVE SAME AFTER KAIZEN WE HAVE PUT THE PAINT ON SAFTY ANGLE E....& NOW WE HAVE FOUND THE CONES COND IS WEELL AND GOOD & REDUCE THE REWNDG ALSO		work perfectly
14	POST SPG M4-6	K - PS M4-6 01	VL TFO running on twisting Lycra. Due to poor visibility , sinning & Rupture note visible clearly.		work perfectly
15	POST SPG M4-6	K - PS M4-6 02	After Installed TL on TFO no need of ceiling TL..		work perfectly
16	Maint 4-6	K-Maint456-01	THERE WAS NOT AVILABLE THE COVER ON FEED ROLL MOTOR IN CARD NO-1,2,3&19 IN MILL 5.		WE MADE IN HOUSE THE FEED ROLL MOTOR COVER AND PUT ON CARD NO-1,2,3&19 IN MILL 5.
17	Maint 4-6	K-Maint456-02	THERE WAS MATERIAL JAMMING PROBLEM IN ALL NEW INSTALLED BOE NEAR MOUTH PIECE ,DUE TO NARROW MOUTH PIECE.		WE MADE IN HOUSE NEW MOUTH PIECE 5NOS AND CHANGED THE ALL MIXING OPNER(BOE),AND JAMMING PROBLEM SOLVED.
18	Maint 4-6	K-Maint456-03	THERE WAS COMING THE DOFFER CHAIN OUT FROM THE RAIL IN POLAR AUTOCONER IN MILL 4.		WE PUT THE SUPPORT PATTI IN RAIL AND NOW PROBLEM SOLVED.
19	Maint 4-6	K-Maint456-04	THERE WAS NOT SEAFTY COVER ON DOFFER IN POLAR AUTOCONER IN MILL 4.		WE PUT ACHERALIC SHEETCOVER AND PUT ON MACHINE.
20	Maint 9	K-Maint9-01	Reshmi Cheese Wdg Drum Gets wear out and damage at both Corner due to Metal Adopter touches to Drum .		Supporting Bolt is fixed at Cradle RHS Side . Now Metal Adopter is not touching to Drum .
21	Maint 9	K-Maint9-02	TFO – Vijay lakshmi machine Gearing Cover Open Frequently during trolley handling and it is dangerous for safety reason .		In house made Door Lock is provided on Both side of Cover at Gear Cover .
22	ENGG SJ11	K - ENGGSJ11 01	It was observed that harwasting tank pump choking problem was day by day increase.		We have made a water filter and fixed on harwasting drainage to avoid choking and time .
23	ENGG SJ11	K - ENGGSJ11 02	It was observed that in utility store chindi not properly placed and consume more space in store .		We have made a sliding box for cotton chindi and covered the place.
24	ENGG SJ11	K - ENGGSJ11 03	It was observed that rotary filter cloth was hanging on H. plant wall looking bad.		We have made a stand in-house for Rotary filter cloth improve to 5s.
25	ENGG SJ11	K - ENGGSJ11 04	It was observed that IR compressor was break down increase day by day due to inlet valve coupling shift beck side.		We have made a bush in-house and fixed on shaft between motor and coupling avoid to coupling shift.
26	QAD	K - QAD -01	Total monthly saving continue from April - 2017 by taking no replacement of left / Shifted staff Saving in stationary Saving in Dyes/ Chemical testing by adopting revised work practice after making Kaizen	34.82	Monthly Benefit - Rs. 290137

27	QAD	K -QAD -02	taking no replacement of knitting executive saving start from Aug 2017	4.80	Monthly Benefit - Rs. 40000
28	QAD	K -QAD -03	5S scoring to be maintained 95 + (Unit -9)		November scoring = 98
29	QAD	K -QAD -04	5S scoring to be maintained 95 + (Unit -SJ 11)		November scoring = 97
30	QAD	K -QAD -05	Broken tiles of unit - 1 floor near entry gate		Replace by new one
31	QAD	K -QAD -06	Broken tiles of unit - 1 floor near alley		Replace by new one
32	QAD	K -QAD -07	Broken tiles of unit - 1 floor near wrap reel		Replace by new one
33	QAD	K -QAD -08	Dirty spot due to water chocking from AC		Was got attended
34	QAD	K -QAD -09	Rusty spot at main entry gate of unit - 1 Lab		Was got attended
35	QAD	K -QAD -10	Chemical Damage tile looking rough in surface		Was got attended
36	QAD	K -QAD -11	Damage Wall tile required maintained		Was got attended
37	QAD	K -QAD -12	In knitting room looking rough in appearance Trolley damage spot in wall		Was got attended
38	QAD	K -QAD -12	False ceiling of knitting room fall down		Was got attended
39	IT	K-IT-01	Before Kaizen There is no M3 report exists for Cone Label Printing, user needs to get report from AS400 session, Its on different platform and user needs to login into AS400 to get Cone Label report		After Kaizen We have developed new report for Cone Label Printing (ZMS256PF) in M3, Now user can get report from M3 in PDF format without change his login account
40	IT	K-IT-02	Before Kaizen Previously Attendance Master can't Launch Department wise, Its launched based on Worker Category only		After Kaizen Added Two new Parameters in Report for run attendance master report from Department, to Department

Total Annualized Gain for the Month

39.62