

RSWM Kharigram - KAIZEN Summary Sheet for July 2016

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	Put wall hanging OHTC in R/f mill no. -2 &3		Put wall hanging OHTC near R/f no. - 25 house keeping improved , Invisible fly contamination problem reduced.
2	SPG M4-6	K - SPGM4-6 01	Installed shift performance display board in R/f Mill no.4		Installed shift performance display board in R/f dept.after the same worker awareness increases about productivity.
3	SPG M4-6	K - SPGM4-6 02	Height increase of finish drum stand in Blender mill no. -4 .		After inreased height of finish drum stand house keeping improved, contamination problem reduced
4	SPG M4-6	K - SPGM4-6 03	No identification Normal and Ordinary look of bale shifting trolly place of mill no. -4 .		Make identification Looking attractive and 5S maintained.
5	SPG M9	K - SPG M9 01	Fire extinguisher was not properly highlighted		highlited with black & yellow strip(zebra marking)
6	SPG M9	K - SPG M9 02	Blow room store not proper highlighted		highlighted with board
7	SPG M9	K - SPG M9 03	VIP alley wall tile broken		It made ok so improve 5S
8	SPG M9	K - SPG M9 04	For spreypump no place identified		Place fixed with board
9	SPG M9	K - SPG M9 05	Grinder stone was not identified.		Done by proper labeling
10	SPG M9	K - SPG M9 06	Wall of corner & edge broken		It made ok so improve 5S
11	SPG M9	K - SPG M9 07	There was no identification of mixing bins.		It has been made by marking mixing bins numberwise.
12	SPG M9	K - SPG M9 08	In RF 12 New ring change with 45 mm in place of 42 mm		Increase cop weight i.e. increase utilisation 1.23%
13	SPG M9	K - SPG M9 09	Slub machine at RF 1 not occupied with safety gaurd		Occupied with safety gaurd, ensured safety
14	SPG M9	K - SPG M9 10	SF N0 11 elect. panel board not occupied with safety gaurd		Occupied with safety gaurd, ensured safety

15	SPG SJ11	K - SPG SJ11 01	Instruction paper pasted on wall in B/R office		We introduce a notice board for instruction in B/R office.
16	SPG SJ11	K - SPG SJ11 02	Card frame caster cleaning was being done by laying can on floor		Now can caster cleaning is being done through can stand.
17	SPG SJ11	K - SPG SJ11 03	Doff Top winding time in speed frame was 3 sec, causing roving warped on bobbin for top winding 1.5 mtr , which make waste in RF during creel opening	0.25	Now Doff Top winding time in speed frame is reduce by 3 sec, causing roving warped on bobbin for top winding 1.0 mtr , which make waste in RF during creel opening
18	SPG SJ11	K - SPG SJ11 04	We observed count board letter erased in prep section		Renewed count board
19	SPG SJ11	K - SPG SJ11 05	We observed yellow marking tape damage		Renewed yellow marking tape & maintained 5 'S
20	SPG SJ11	K - SPG SJ11 06	Worker incentive not maintained shiftwise so difficult to find best month checker		Now we maintaining incentive report shiftwise causing easy to find best month checker
21	SPG SJ11	K - SPG SJ11 07	Training dept was not giving training of RSB Wrapping checking to DF new promoted tenter		Now they give proper training of RSB wrapping checking during their training period ,and the promoted as tenter
22	POST SPG M1-6	K - PS M1-6 01	Earlier single yarn was transferred in SY Godown in house Mill by using Polythene Bag.	0.23	To shift single year material in SY Godown stop use of polythene bags and start shifting on Bora
23	POST SPG M9	K - PSM9 01	In Packing M-9 A siger m/c Vocume motor places was not fixed & identified..		Now Packing M-9 A Sieger m/c Vocume Motor places were fexed & identified.
24	POST SPG M9	K - PSM9 02	M-9 A Jambo m/c & Auto coner no 7 center partition was not fixed.		Now Iron sheet partition were fixed & indentified between Jambo m/c & auto coner no 7.
25	POST SPG SJ11	K - PS SJ11 01	In packing section dust bin not mark properly.		Now Packing dust bin mark by yellow tape
26	POST SPG SJ11	K - PS SJ11 02	Linkconer safety cover not paint.		Now Linkconer cover paint properly.
27	QAD M 1- 6	K - QAD M1-6 01	Made SOP for Combed sliver / Noil procurement		Will support in maintaining consistency of quality
28	QAD M 1- 6	K - QAD M1-6 02	Optimization of FD / FL setting of EYC		For clearing contamination on Polar A/Cs
29	QAD M 1- 6	K - QAD M1-6 03	Comparative evaluation of finish at mixing stage .		To optimize finish application for better performance in running process .
30	QAD SJ11 & M9	K - QAD SJ11 01	Prepare card samples & take corrective action against high IPI value of card no – 04 (Count (Ne) - 1/30s P/V)		Improvement in yarn quality.
31	QAD SJ11 & M9	K - QAD SJ11 02	Doing trial study results of count (Ne)-1/30s PV-65/35% , Grey .Prepare sample on Running setting Weighing hopper (Hopper Speed = 529 RPM, Beater Speed = 789 RPM) & After speed change setting Weighing Hopper (Hopper Speed = 438 RPM off 529 RPM , Beater Speed = 631 RPM off 789 RPM)		Improvement in yarn quality.
32	QAD SJ11 & M9	K - QAD SJ11 03	Comparative Trial Study Report of Count (Ne)-1/28s P/V 65/35 (Unwax) in case of single component dyeing material Normal Speed V/S 5% Speed down V/S 10% Speed down.		Improvement in yarn quality.
33	QAD SJ11 & M9	K - QAD SJ11 04	Replace normal lights from LED Lights.		Looks attractive. Use good quality of lights use inplace of normal light.
34	QAD SJ11 & M9	K - QAD SJ11 05	Put Testing bobbins for uster & RKM testing in plastic tray .		Looks attractive & Follow 5s System.
35	QAD SJ11 & M9	K - QAD SJ11 06	Doing Comparative yarn test study Count Ne 3/08s Poly 100% (Topaz) optimize 9% TPI increase.		Improvement in yarn quality.

36	MAINT M1-3	K - MAINT M1-3 01	SAVIO ORION AIR JOINT CAGE DAMAGED.		WE REPLACED SAVIO ORION AIR JOINT DAMAGED CAGE BY CAGE OF DAMAGED MALE CONECTOR .
37	MAINT M1-3	K - MAINT M1-3 02	SAVIO ORION BOOSTER NUT DAMAGED.		WE PULL OUT OLD DAMAGED NUT AND FASTEN IT INSIDE THE BOOSTER NOW ITS WORK SMOOTHLY.
38	MAINT M1-3	K - MAINT M1-3 03	SAVIO ORION TROLLEY CONTECT BEARING DAMAGED WAS MATTER OF COURSE.		WE REPLACED DAMAGED BEARINGS WITH OLD RING FRAME TOP COTS HENCE PROBLEM SOLVED.
39	MAINT M1-3	K - MAINT M1-3 04	SAVIO POLAR OHTC PIPE CLIP WAS LOOSE WAS MATTER OF COURSE.		WE FIX OHTC PIPE CLIP WITH SCREWS NOW PROBLEM SOLVED.
40	MAINT M1-3	K - MAINT M1-3 05	ACX-5 A/C TROLLEY SUPPORT ROD BECOME DAMAGED AND LOOSE.		WE INTRODUCED A SPRING ON THIS SUPPORT ROD NOW TENSION IN ROD INCREASE AND PROBLEM SOLVED.
41	MAINT M1-3	K - MAINT M1-3 06	IN A/C ACX-5 EMPTY TUBE CONVEYER BELT FLY WASTE JAM PROBLEM WAS MATTER OF COURSE.		WE INTRODUCED A BRUSH WITH ITS SUPPORT TO CLEAN SOFT WESTE JAM, NOW PROBLEM SOLVED.
42	MAINT M1-3	K - MAINT M1-3 07	ACX-5 A/C OHTC PIPE LOOSE AND GET DAMAGED WAS MATTER OF COURSE.		WE WELDED TWO IRON BLADES ON OHTC PIPE AND PROVIDE SUPPORT TO PIPE, NOW PROBLEM SOLVED.
43	MAINT M1-3	K - MAINT M1-3 08	ACX-5 OHTC FIBER WHEEL DAMAGED.		WE TAKE ANOTHER FIBER WHEEL AND GIVE SHAPE AS IT IS OLD ONE AND FITTED IN OHTC, NOW ITS WORKING SMOOTHLY.
44	MAINT M1-3	K - MAINT M1-3 09	IN RING FRAME AFTER ROVING STOP MOTION INSTALATION ROVING GUIDE SCREW TOUCHES TO THE WEDGE OF RSM AND JAM IT TO WORK AND ROVING GUIDE LOOSE WAS ALSO MATTER OF COURSE.		WE INTRODUCED SPRING WASHER IN ROVING GUIDE SCREW AND FITTED IN THED M/C NOW PROBLEM SOLVED.
45	MAINT M4-6	K - MAINT M4-6 01	Mill no 4, Vijay Laxmi TFO ,OHTC creel was not avilable ,and TFO started without OHTC.		Make creel in house with helpof workshop by old bend scrap angle, and started the Ohtc in New Vijay Laxmi TFO 19,20 in mill 4.
46	MAINT M4-6	K - MAINT M4-6 02	Mill no 4,5&6 ,Toyada (FL16) simplex ,There was missing middle condensor again and again.	0.17	We modified middle condensor in house like LF1465 and middle condensor missing problem solded ,and saved Rs-17760.(Rs 4440 /Mc)
47	MAINT M4-6	K - MAINT M4-6 03	Mill 6 ,LR60 RF Fly catcher gauge disturbing again and again due not suitable to produce synthetic yarn.		we replaced by suitable fly catcher for synthetic and now problem solved.
48	MAINT M 9	K - MAINT M9 01	Lock of Apron Web cover of Carding machine was damage .		In house developed lock of Apron Web cover of Carding machine .
49	MAINT M 9	K - MAINT M9 02	Flyer Cover of Speed Frame (LF 4200 A) was damage .		Screw fixed to avoid damage of Flyer Cover of Speed Frame (LF 4200 A) .
50	MAINT M 9	K - MAINT M9 03	Shim of Elite Twist attachment Front Roll Shaft Gear Box (LHS) was not available .		Old Scrap Leaf gauge o carding Machine is used for level of Gear Box of Elite Twist attachment Front Roll Shaft (LHS) . Qty - 7 pc .
51	MAINT M 9	K - MAINT M9 04	Elite Twist attachment Front Roll Shaft (LHS) was not available		In house developed Elite Twist attachment Front Roll Shaft (LHS) . Qty - 1 pc .
52	MAINT M 9	K - MAINT M9 05	Cradle lifting Bracket of TFO Vijay lakshmi machine not available .		In house developed Cradle lifting Bracket of TFO Vijay lakshmi machine . Qty - 2 pc .
53	MAINT SJ11	K - MAINT SJ11 01	MATERIAL IS JAM IN-BETWEEN FEED LATTICE AND BODY DUE TO THIS , LATTICE MAY SHIFTED FROM THEIR ACTUAL POSITION		OEM SUPPLIED LATTICE GUARD IS REMOVED AND PLACED GI TAPPER GUARD TO COMES OUT WITH THIS PROBLEM
54	MAINT SJ11	K - MAINT SJ11 02	MBO NO.3 CONDENSER MATERIAL CHOCKING PROBLEM		SIZE OF DUCT AND MATERIAL IS CHANGE INSTEAD OF 250mm MATERIAL DUCT USING 450mm SS DUCT.NOW CONDENSER
55	MAINT SJ11	K - MAINT SJ11 03	PACKING T-CAR WHEEL WEAR OUT	0.15	NEW 1 PCS OF T-CAR WHEEL COST IS COMING 10000 WE USED LOCAL REPAIRED WHEEL INSTEAD OF PROCURING NEW ONE.
56	MAINT SJ11	K - MAINT SJ11 04	TFO DROPPER WIRE BLADE WELDING IS BROKEN.AFTER BROKEN BLADE WELDING DROPER WIRE IS USELESS	0.11	START USING REPAIRED DROPPER WIRE INSTEAD OF PROCURING NEW ONE ONE PCS OF DROPPER WIRE IS COMING
57	ENGG M1-3	K- Engg M1-3-01	PLC CONVERSION Wiring IN S/F LF-1465		Replaced PLC of Siemens make & necessary wiring changes done in house & machine started and doing wiring properly
58	ENGG M1-3	K- Engg M1-3-02	INDICATION HOUSING WOODEN SUPPORT		FIXED WOODEN FIXTURE TO SUPPORT THE PLASTIC HOUSING TO AVIOD FROM BREAKING.
59	ENGG M1-3	K- Engg M1-3-03	C 1/3 CARDING MAIN SWITCH REPLACE		Fixed with three pole MCB enclosure box to cut off power & no any phase missing problem now.
60	ENGG M1-3	K- Engg M1-3-04	Over Head Sensor Protection		After kaizen sensor not getting damages because we make clamp for sensor
61	ENGG M4-6	K- Engg M4-6-01	Previously the machine PLC declared obsolete by O/E/M & failed on the machine		Replaced PLC of Siemens make & necessary wiring changes done in house & machine started.
62	ENGG M4-6	K- Engg M4-6-02	NPD machines no hour meter installed		Installed hour meters on machines to calculate running hours
63	ENGG M4-6	K- Engg M4-6-03	Machine stopping frequently in inclined lattice motor not working & control panel wiring having Zig -Zag condition.		All wiring traced through electrical manual & removed unnecessary wiring.
64	ENGG M4-6	K- Engg M4-6-04	M/C having phase indicator broken.		Replaced with the mimic light removed from muratec 7v Auto coner.

65	ENGG M9	K- Engg M9 -01	Over head switch re-location.		Before that there was MPCB behind the panel and breaking frequently. Now MPCB taken inside the panel and Give selector switch on front panel to operate easily.
66	ENGG M9	K- Engg M9 -02	Pinter Test-05 Casing fabrication.		There was need to give extra support for creel attachment. For that there is require to do some modification work in PCB casing. After fabrication it become posible to installed that support.
67	ENGG M9	K- Engg M9 -03	Inverter Shifting work in Dye House		There was an extra Panel for drive in dye house for dying machine. That was taking extra place also. We shifted all those inverter in their original panel. For that were have to do re-arranging the panel assesry to make place for that inverter.
68	ENGG M9	K- Engg M9 -04	Making GI hood on S/F panel		There is water dropping on panel during rain. We make hood over that panel to protect internal electrical goods.
69	ENGG M9	K- Engg M9 -05	Panel gap covering with GI sheet.		Before that there were space gap between panel and wall, Due to that we alsway found some unwanted things there.
70	ENGG M9	K- Engg M9 -06	Light switch relocate of tower DB room.		Before that switch was inside the room. We were have to go inside the dark room to switch on light. That was not safe.
71	ENGG M9	K- Engg M9 -07	Sensor installing on Reshmi Cheese winding machine.		There were using long sensor on Reshmi cheese winding. That was problem to procure that type of sensor. So we use matel strip to re-locate the sensor position to use regular type of small sensor.

72	ENGG SJ11	K - ENGGSJ11 01	Auto flow T-car encoder as earlier supply by OEM & cost of encoder Rs. 67000.00	0.08	We explore from indian market & found same specification encoder, encoder cost is 58935.00 thus saved
73	ENGG SJ11	K - ENGGSJ11 02	White board of Engg Lab was used in normal manner.		We have done partition of white board through radium lining to use properly to improve 7-Habit
74	ENGG SJ11	K - ENGGSJ11 03	Tube Cleaner touch display (Make Siemens) OP177b 4" was not work & declared beyond repair by Siemens India.		We explore a party (M/S Nutech) & repaired the display, by doing this we spare one display.
75	ENGG SJ11	K - ENGGSJ11 04	H-plant bleeding water was directly drain to sewage tank		Reused the bled water through pipe line for utility purpose,thus saved 25-30 KL/Day.
76	ENGG SJ11	K - ENGGSJ11 05	Unsafe condition at entry gate of compressor room.		We have fixed cheqqr plate with angle supporting.
77	ENGG SJ11	K - ENGGSJ11 06	Earlier we use 3 log books for compressor.	0.01	We have merged all 3 log books of compressor to 1 log book, thus saved stationery & 120 Rs/Month.
78	ENGG SJ11	K - ENGGSJ11 07	There was no Identification of recently installed H-plant SA & RA Fan Inverter		Identification of SA & RA Fan inverter done.
79	ENGG SJ11	K - ENGGSJ11 08	Ambient temperature of TFO DB Panel Room was high & force to remain window open.		We have fixed two exhaust fan for reduce ambient temperature & improve 5S of TFO DB Panel room.Also close the window permanently.
80	ENGG SJ11	K - ENGGSJ11 09	Cheese winding Danfos 2.2 kw inverter was damaged & declared beyond repair at OEM end due to that 18 drum stopped which cause production loss.		We have taken two inverters already lying with us in beyond repair condition & used by spliting 9-9 drums through control wiring thus started all 18 drums.
81	ENGG SJ11	K - ENGGSJ11 10	Some identification was not mentioned.		We have done identification in following areas (Lighting DBs, BTS Flap Switch) for 5s Improvement
82	ENGG SJ11	K - ENGGSJ11 11	There was chances of display damage in Ringframe by Mishandling.		To avoid chances of display damage fixed safety cover.
83	ENGG SJ11	K - ENGGSJ11 12	Observe during VIP round packing incharge has to call shift electrician to switch on the LED lights which stop in normal working.		We have fixed a separate switch for LED lights of Packing for ease of working.
84	ENGG SJ11	K - ENGGSJ11 13	There was chances of bird accident which might damage the exhaust fan.		We have fixed aluminum wire mesh in front of Exhaust Fan.
85	ENGG SJ11	K - ENGGSJ11 14	Observe Bale press machine ON some times without use		We have fixed a notice for Bale press machine for safety & enegy saving purpose.
86	ENGG SJ11	K - ENGGSJ11 15	Uncomfortable environment in SO room during Mansoon Season as having only one ceiling fan.		Used exhaust air of near by air conditoner room.
87	ENGG SJ11	K - ENGGSJ11 16	Observe BBT identification not mentioned.		We have done proper identification of BBT.
88	ENGG SJ11	K - ENGGSJ11 17	During rainy season water dropping problem on North Side Power Distribution panel from APFC Panel.		We made a stopper for cable hole for safety purpose.
89	ENGG SJ11	K - ENGGSJ11 18	Pinter RJ-45 cable as earlier supply by OEM & cost of one RJ-45 cable was Rs. 65.00	0.08	We explore OEM substitute of RJ45 cable & cost of one cable is Rs. 20.00
90	ENGG SJ11	K - ENGGSJ11 19	Earlier Sometimes we forgot to Shut Down the Desktop PC after work completion.		We have fixed a notice "Please shut down PC if Leaving for more than 1 hr" on Desktop PC for enegy saving purpose.
91	ENGG UTILITY	K - ENGG UTILITY 01	Change the pulley of Dryer for more efficiency	0.54	We have use bigger size pulley for more Efficiency and more production
92	ENGG UTILITY	K - ENGG UTILITY 02	Put a New cover of Computer		we have put a new cover of computer for safety purpose
93	ENGG UTILITY	K - ENGG UTILITY 03	Fixed a new safety guard		We have fixed new safety guard in machine side for safety purpose.
94	ENGG UTILITY	K - ENGG UTILITY 04	New Partition Between Jumbo Winding And Auto corner.		we have create a new partition between jumbo winding and auto corner.
95	ENGG UTILITY	K - ENGG UTILITY 05	Make new chamber main hole cover		We have make new chamber plate fabricated by M.S. plate 6mm. So avoid the accident.
96	ENGG UTILITY	K - ENGG UTILITY 06	Put A Net On Supply Air Fan		we have put a new net on supply air fan for safety purpose
97	ENGG UTILITY	K - ENGG UTILITY 07	Put A Cover Of Washer Pump		Kaizen we have put a new cover of washer pump for safety of raining water.
98	ENGG UTILITY	K - ENGG UTILITY 08	Put A safety guard		Kaizen we have put a m/c safety guard for safety purpose. And its maintained for 5s.
99	ENGG UTILITY	K - ENGG UTILITY 09	Make a platform for safety purpose		We have make a platform for safety purpose. And for maintained for 5s.
100	ENGG UTILITY	K - ENGG UTILITY 10	There is no proper fitting of MS Jali in main motor for R/F M/C.		We have make a new frame and proper fitting of MS Jali in main motor for R/F m/c .
101	DYE HOUSE	K - Dye House 01	Chemical Room modification as present structure is not representable to auditer		Chemical Room Modification facilitate proper material handling and safety work envoinment to workersThis also help in maintaining good house keeping,
102	DYE HOUSE	K - Dye House 02	Cleaning of Trolly wheels on regular interval for smooth transportation		Cleaning of trolly wheels will smoothen trolly movement and reduce pushing work effort
103	NPD	K - NPD - 01	Master card for new quality has send to Dye House after confirmation of the recipe in the NPD Lab. Some time there are changes in the recipe which has mention in the master card but not changed in the ERP. This has lead to mistake in dyeing.		Now the recipe has changed in the ERP before releasing the Master Card and copy of the ERP recipe has attached with the master card to ensure the effectiveness of the system.

104	NPD	K - NPD - 02	Slub and Injection Slub attachments are installed on same ringframe (R/F no. 3) due to which waiting time of slub & Inj. Slub samples are more. This lead to higher lead time of the samples.		Now Inj. Slub attachment has shifted to Ringframe No. 1. Now capable to run the Slub and Inj. Slub parallelly on separate ringframe. Reduced the waiting time of the samples.
105	NPD	K - NPD - 03	Hour meters has installed on all machines of the NPD Pilot Plant.		Working Hour of all the NPD machines has monitored on daily basis.
106	NPD	K - NPD - 04	Costing of the samples has done before dispatch of the sample and price of the samples has send to marketing along with the dispatch details.		Dispatch of the sample is not delayed due costing now.
107	NPD	K - NPD - 05	Fiber and Yarn aticles are made at the time of the release of the mixing memo daily basis. Earlier fiber and yarn articles has made at the time of the dispatch of the sample.		Rework due to wrong erp no. is nil. No delay of the samples due to fiber and yarn articles
108	NPD	K - NPD - 06	Platform has provided for keeping the fiber bales in the NPD Pilot Plant while earlier these bales are placed on the floor.		Improve the housekeeping
109	NPD	K - NPD - 07	Hard waste and soft wate has given to godown on daily basis as there is limited space in NPD Pilot Plant while earlier waste is kept in the Pilot Plant and given on monthly basis.		Improve the housekeeping and create the space
110	NPD	K - NPD - 08	Earlier daily waste is kept in the bags in a corner which looks very bad. Now space for daily waste is defined and placed in a empty conatiner.		Improving the housekeeping
111	NPD	K - NPD - 09	Simplex bobbins are kept in the empty carding cans. Now simplex trolleys has provided for keeping the simplex bobbins.		Improve the yarn quality and better housekeeping
112	NPD	K - NPD - 10	Earlier yarn lea has provided to the dyeing labb for checking with standard after final the yarn from spinning. Now the yarn lea has provided from the 1st doff from the ringframe.		Now if the sample yarn lea not matched with the standard then rematching has started immediatly which reduce the lead time of the sample.
113	NPD	K - NPD - 11	Earlier fabric samples of the PD No. (Lab Dips), P Lot (Feeler Yarn) and Bulk lots are kept in the same rack which lead to higher reterival time of the fabric sample. Now fabric samples of the PD No., P Lot and Bulk Lots are kept in separate racks with proper recording.		Reterival time for fabric sample has reduced.
114	NPD	K - NPD - 12	Different count of samples with same TPI is run on the same ringframe by adjusting the CP. One count at one side of the Ringframe while another count at the another side of the ringfame.		Improve the lead time of the samples.
115	IT	K-IT-01	Earlier there is no formats/defined system available for Audit Packs, There is no standard format for audit packs		After implementation of Audit Pack, its followed at all RSWM locations, the audit packs & balance sheet working is now improved and in systematic manner
116	IT	K-IT-02	Earlier the Promotion and increment Letters printed through Word & Excel		After development new module in RAMCO system, user is able to print directly through RAMCO
Total Annulized Amount				1.63	