

RSWM Kharigram - KAIZEN Summary Sheet July 2017

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M4-6	K - SPGM4-6 01	Safety guard railing repaired with alignment in r/f in mill no. -4.		Repaired railing , remove the chances of accident & 5smaintained.
2	SPG M4-6	K - SPGM4-6 02	Make identification on Blow room office M-4.		Identification on blow room office . Its good looking ,attractive & 5s maintained.
3	SPG M4-6	K - SPGM4-6 03	R/f - 9 creel covered with polythene in mill no. -5.		After covering creel with polythene creel fly problem resolved. & Contamination problem reduce.
4	SPG M9	K - SPG M9 01	RF Gear jam with fly , increase yarn CV break down		After kaizen gear box clg
5	SPG M9	K - SPG M9 02	Rain water coming at wall in M9A		Roof repaired .
6	SPG M9	K - SPG M9 03	False ceiling broken. May be dangerous		After kaizen new sheet put
7	SPG M9	K - SPG M9 04	In RF 12&13 gear box open due to screw broken ,may be dangerous.		Screw fitted
8	SPG M9	K - SPG M9 05	Gear box lock absent , May be dangerous		Lock put
9	SPG M9	K - SPG M9 06	Main motor net sheet (fly protector) split		New sheet put.
10	SPG M9	K - SPG M9 07	IN RF 7 Safety guard broken may dangerous		After kaizen safety guard repair.
11	SPG M9	K - SPG M9 08	SF Trolley broken problem in material handling.		Trolley repaired
12	SPG M9	K - SPG M9 09	Cover door handle broken.		Handle put.
13	SPG M9	K - SPG M9 10	Doffing trolley broken . Problem in handling		Trolley repair
14	SPG M9	K - SPG M9 11	Tile of wall broken in BR . S S not maintain.		New tile put .
15	SPG M9	K - SPG M9 12	Meeting hall door lock broken		New lock put.
16	SPG M9	K - SPG M9 13	Bobbin khatal separate .House keeping disturbed.		All khatal joint with nut bolt,
17	SPG M9	K - SPG M9 14	False ceiling broken.		Put new false ceiling
18	SPG M9	K - SPG M9 15	Unwanted thing put in VIP (alley .not its place) problem in material handling		Put it its proper place.
19	SPG M9	K - SPG M9 16	Blower waste box cover handle . Problem in Handling		New handle put .
20	SPG M9	K - SPG M9 17	RainWater dropping .in VIP alley		New sheet put
21	SPG M9	K - SPG M9 18	Bonda box handle broken Problem in handling		Handle repair.
22	SPG SJ11	K - SPG SJ11 01	We observe that in office alley ,wall was broken from corners		So wall guard installed
23	SPG SJ11	K - SPG SJ11 02	We observe that in RF 24 ,count 20 high start up breakage (Above 5%)		So we take trial in RF setting, now start up breakage reduced to 3%
24	SPG SJ11	K - SPG SJ11 03	We observe that in RF (5-8) 2/0 MS HF Rtr was giving high cost with compare to 2/0 U1US(+)		So we switch on 2/0 U1US RTr for trial purpose,now it gives better result so cost saving
25	SPG SJ11	K - SPG SJ11 04	We observe that in SF1 uster was higher at 1.20 draft		So take trail of break draft 1.14 and now Uster reduced to 3.25 % instead of 3.80 %
26	SPG SJ11	K - SPG SJ11 05	We observed that in RF(1-40) total 42 track wheels were damaged		So all defective track wheel replaced by new one
27	SPG SJ11	K - SPG SJ11 06	We observed that in RF(17-19) high breakage at bottom position at 1/0 MS HF and speed loss was there around 1%		So we switch on 1 MS HF Rtr now running breakage reduced at bottom and also speed loss reduced almost nil
28	SPG SJ11	K - SPG SJ11 07	We observe in PV material high cuts and alarm at 272 mmpm flat speed		So we take a trail and increase speed of flat 325 mm off 272 mmpm now cuts and alarm level reduced
29	SPG SJ11	K - SPG SJ11 08	We observed that in poly RF high cuts and alarm level so problem of bobbin shortage problem on LC		So take trial of gauge of SFD and SFL get closed by 2 thou, now cuts and alarm level normal
30	SPG SJ11	K - SPG SJ11 09	We observed that breakage level was too high at south side RF		So RH set point revised to 56 % off 52 % now breakage level reduced
31	SPG SJ12	K - SPG SJ11 10	We observed that on some spindle loose fly was passing from clearer		So all defective clearer attended by maint (67 spindles)
32	POST SPG M4-6	K - PS M4-6 01	In Autoconer during rewinding baby cones are not working properly. Cones are fallen down due to re wdg tension'.		work perfectly
33	POST SPG M4-6	K - PS M4-6 02	We have installed un used chain & Track from SAVIO Doffer. Put pipe in side the Chain like ATS. And run the manual splicer on Track Like ATS	1.5	work perfectly
34	POST SPG M9	K - PSM9 01	Wooden Tapa for U/V Lamp Room are damage, during working cones are cut		Now Wooden Tapa Repaired by carpenter for avoid cut cone problem
35	POST SPG M9	K - PSM9 02	M-9 B Sieger M/C Platform are Damage , chances of accident by sieger Trolley		Now Repair by work shop for avoid of accident
36	POST SPG M9	K - PSM9 03	Loose wiring in U/V Lamp room, chances of major accident.		Now attend by electric deptt. For avoid of accident
37	POST SPG M9	K - PSM9 04	Packing Line no one Roller chain are Broken.		Now attend by Maintainance deptt. & smooth working after attending.
38	QAD M 1- SJ11	K - QAD M1-SJ11 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
39	QAD M 1- SJ11	K - QAD M1-SJ11 02	Strip width using on carton was changed to 12 mm in place of 9 mm		To avoid damage of carton as well as breakage of strip
40	QAD M 1- SJ11	K - QAD M1-SJ11 03	Optimization of wax performance by reducing uptake 0.12 % to 0.10 %		To avoid excess cutting of wax / powder generation keeping the friction coefficient below 0.15 RM Enterprise sample trail was checked & found friction coefficient 0.13
41	QAD M 1- SJ11	K - QAD M1-SJ11 04	Optimization of carding gauge in unit SJ-11 by reducing SFL & SFD & Flat gauge in 100% polyester section detail as under SFL Gauge (Thou) 18 , 16 , 15 , 14 of 20 , 18 , 17 , 16 SFD Gauge (Thou) 10 , 10 , 10 of 14 , 14 , 14 Flat Gauge (Thou) 12 , 12 , 12 , 10 , 10 of 16 , 14 , 14 , 14 , 12		To reduce classmate faults / 100 km & winding cuts /100 km Trial was taken and result found as below Count (Ne) = 40 Poly - 100 % Classmate faults /100 km Running Trial study Obj. Fault 39 19 Total short thick 386 251 Total long thick 23 10 Total Thin 0.0 0.0 Total Faults 409 261 Winding cuts per 100 km (Avg) 114 82
42	MAINT M 9	K - MAINT M9 01	Ratchet assembly worm wheel collar of jingwei ring frame gets broken .		Cearing outer race is fitted on collar to increase strength and avoid damage .
43	MAINT M 10	K - MAINT M9 02	Frequent damage of can changer drive belts of td 03 d/f which is having high cost .		Can changer belt drive system is bypassed and s.s. plate is fixed above m.s. plate (manual creel system) to avoid frequent damage of drive belts which are having high cost . running satisfactorily .

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44	ENGG M1-3	K- Engg M123-01	Wall mounting fan at old main gate		After Kaizen safety of human due to installed of wall mounting fan.
45	ENGG M9	K- Engg M9 -01	Controller for carding flate grinder machine		The electronic controller for carding flate grinding machine was defected. We make other controller for that machine with arrangement of relays logic.
46	ENGG M9	K- Engg M9 -02	Key bord modification in Reshmi chese winding		Reshmi chise winding drum key board were getting damage they were not fixing at their place. We make saperate key board of backelite and fix on machine.
47	ENGG M9	K- Engg M9 -03	LED down light installtion in Hyper RO LAB.		Previously there were tube lights were fix in Hyper RO lab. We replace them with LED down light. It improve the look of lab.
48	ENGG M9	K- Engg M9 -04	Door limit switch modification in CTMTC S/F.		Limit switch of Ch. S/F were getting fail and were costly and time consuming to procure from China. We replace them with other make of limit switch with arrangement of key switch to use as per original system.
49	ENGG SJ11	K - ENGGSJ11 01	It was observed that compressor and tappu machine room entrance gate so many time broken. & there is scope of time and cost saving.		We fixed Cur tern in Compressor and Tappu Machine Entry Gate & to avoid broken Gate .
50	ENGG SJ11	K - ENGGSJ11 02	We observed In Tappu machine room window at a time opened due to workers did spit & jump the window .		We fixed wire mesh on tappu machine room window.
51	ENGG SJ11	K - ENGGSJ11 03	In speed frame number 03 doffer energy chin was broken so many time.		We make a GI flat Patti and joint the energy chain to avoid broken energy chain & cost saving
52	ENGG SJ11	K - ENGGSJ11 04	In Pecking godown, Rake was damage to steaker.		We repaired in - house the rake. for cost saving & safety
53	ENGG UTILITY	K - ENGG UTILITY 01	Fabricated and fix a new safety guard		After Kaizen We have fabricated and fix a new G.I. safety guard on Air monitoring meter for safety purpose.
54	ENGG UTILITY	K - ENGG UTILITY 02	Fabricated and fix a new safety guard on fire cylinder		After Kaizen we have fabricated and fix a new safety cover on fire cylinder by using wastage of G.I. Sheet.
55	ENGG UTILITY	K - ENGG UTILITY 03	Fabricated and fix a new safety cover on motor		After Kaizen We have fabricated and fix a new safety cover on motor for safety purpose in raining season.
56	IT	K-IT-01	Single screen having below observation- Search all MO except shut System messages are not user friendly Single digit drum shows incorrect Accepts extra m/c run time		We have taken this as kaizen and made necessary changes in program and addressed all above points Now new version of Single Screen is having faster performance
57	IT	K-IT-02	On creation of new item in M3 Auto IPA Generate & Send mail to concern person details but GST details are not available		After Kaizen this GST No. & Tax Rate are also available with IPA mail
58	IT	K-IT-03	Manual checks and control from Different Reports by entering employee code		Created a report for Employee today status date wise.
59	Training	K-Training-01	5s-We have replaced old almira with new wooden racks and marked items name on wooden rack.		We have replaced old almira with new wooden racks and marked items name on wooden rack.
Total Annualized Gain for the Month of Apr.'17				36.32	