

**RSWM Kharigram - KAIZEN Summary Sheet for June 2016**

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	No hour meter on B/r line of mill no1		Hour meter install on B/r line 1
2	SPG M1 - 3	K - SPGM1-3 02	No safety guard railing in D/f area mill no. -2		Put safety guard railing on D/f area mill no. -2.
3	SPG M1 - 3	K - SPGM1-3 03	No any shift performance display mill no. -123		Installed shift performance display in mill no. -123
4	SPG M4-6	K - SPGM4-6 01	No proper identification of robot parking area Normal and Ordinary look.		Identifications & marking of robot parking area, looking attractive and 5 S maintained.
5	SPG M4-6	K - SPGM4-6 02	Normal and Ordinary look of fire almira.		Identification & marking of fire almira, Looking attractive and 5S maintained.
6	SPG M4-6	K - SPGM4-6 03	No identification Normal and Ordinary look of bobbin room of mill no. -4		Make identification Looking attractive and 5S maintained.
7	SPG M4-6	K - SPGM4-6 04	Old partition torn out at bottom & top faced contamination problem.		Put new ms partition Looking attractive, contamination problem reduces and 5S maintained.
8	SPG M4-6	K - SPGM4-6 05	Change in design in RA Grills in Carding and Ring Frame.		Return Air Suction improved and Fly deposition reduced. House keeping improved.
9	SPG M4-6	K - SPGM4-6 06	Roving Grindle products started successfully in Mill no.6 with Coarser hanks on Five Ring Frames.		Roving Grindle products started successfully in Mill no.6 with Coarser hanks on Five Ring Frames. Proper monitoring doing to get quality without Complaints
10	SPG M4-6	K - SPGM4-6 07	Roving Grindle SLUB Started with Coarser hank on SSK6 model successfully.		Roving Grindle SLUB Started with Coarser hank on SSK6 model successfully.
11	SPG M4-6	K - SPGM4-6 08	MS Partition GI sheet fixed		GI Sheet fixed above MS Partition to fill the Gap to avoid Contaminations and Fluff & Fly Problems.
12	SPG M4-6	K - SPGM4-6 09	Perforated Jali Changed in Mixing Bins in Blow room in mill no.6, which were having less perforations and fibre was out from the holes		Perforated Jali Changed in Mixing Bins in Blow room in mill no.6
13	SPG M4-6	K - SPGM4-6 10	Partition in front of Ring Frame no.12&13 creating poor house keeping and less space for working Area.		Partition removed from in front of Ring Frame no.12&13 for increasing more work space and better house keeping.
14	SPG M9	K - SPG M9 01	Sometimes light doff were taken out from RF		25% Light doff controlled with daily counter checking
15	SPG M9	K - SPG M9 02	Due to gap in bobbin room house keeping was not ok		Gap was covered due to this housekeeping, 5S improved
16	SPG M9	K - SPG M9 03	False ceiling was broken might cause an accident.		It made ok so safely ensured
17	SPG M9	K - SPG M9 04	Fire extinguisher was not properly highlighted		By marking and yellow tape it has been highlighted.
18	SPG M9	K - SPG M9 05	Grinder stone was not identified.		Done by proper labeling
19	SPG M9	K - SPG M9 06	Very high temprature in deptt.		Placed coolers at various places
20	SPG M9	K - SPG M9 07	There was no identification of mixing bins.		It has been made by marking mixing bins numberwise.
21	SPG M9	K - SPG M9 08	In RF 12 DUI 20 results in 53 gm cop contain		DUI reduced to 18 mm, thus cop contain increased upto 64 gm
22	SPG M9	K - SPG M9 09	Roving opener was in VIP alley which was hindering house keeping		It was shifted from VIP alley. 5S improved
23	SPG M9	K - SPG M9 10	At entry no any boards were there about 5'S		To educate workers about 5'S many boards has been placed at entry
24	SPG SJ11	K - SPG SJ11 01	Instruction paper pasted on wall in shift office		We introduce a notice board for instruction in shift office.
25	SPG SJ11	K - SPG SJ11 02	We observed, Numbering was not paste on flap, causing difficult to identify fault flap		Numbering done on each flap
26	SPG SJ11	K - SPG SJ11 03	Some nozzles RF OHTC air pressure was very low, causing RF cleaning of that area effected		Now some OHTC Nozzles length increases and dia decreases, causing air pressure increases RF Cleaning improve
27	SPG SJ11	K - SPG SJ11 04	B/R Weighing feeder number was not defined		Now numbering done.
28	SPG SJ11	K - SPG SJ11 05	We observed Plant slit was rusty. So housekeeping effected		Silver paint done in whole plant slit
29	SPG SJ11	K - SPG SJ11 06	We observed, Zebra crossing was not defined		Zebra crossing defined
30	SPG SJ11	K - SPG SJ11 07	We observed, Mat area not defined in B/R Office		Mat area defined & maintained 5 'S'
31	SPG SJ11	K - SPG SJ11 08	We observed, Count board letter erased in prep section		Renewed count board
32	SPG SJ11	K - SPG SJ11 09	There was no any operator performance electronic display at SJ11 Entrance		We introduce LED TV at SJ11 Entrance
33	SPG SJ11	K - SPG SJ11 10	Water glass serve with coaster during meeting		Now procure coaster for water glass
34	POST SPG M1-6	K - PS M1-6 01	Moveble nylon curtain kept between Grey & dyed to avoid cotamination		Reduction in chanches of contamination by fixing nylon curtain
35	POST SPG M1-6	K - PS M1-6 02	Fixed modified partition in place of HDEP partition		Improved 5 S and Deptt working
36	POST SPG M1-6	K - PS M1-6 03	Pressure pipe keeping on stand in place of floor.		Improve safety and 5S in Deptt
37	POST SPG M9	K - PSM9 01	In Packing M-9 place fixed for keeping key of Emergency gate with proper identification.		Now place has been fixed for keeping key of Emergency Exit gate with proper identification in Packing M-9.
38	POST SPG M9	K - PSM9 02	Way identified of Emeergency Exit in Pcking M-9		Way identified of Emeergency Exit in Pcking M-9
39	POST SPG M9	K - PSM9 03	In packing M-9 U.V.Lamp chamber & packing Line identified with proper identification & marking		Now in packing M-9 U.V.Lamp chamber & packing Line identified with proper identification & marking.
40	POST SPG SJ11	K - PS SJ11 01	In packing section we have used 224 tube light to maintan Required lux for smooth working.	0.88	Now we have use 153 tube lights with maintaining smooth working & save 0.88 lacs per annum.
41	POST SPG SJ11	K - PS SJ11 02	we have used 5 ply corner sheet on pallet packing	2.31	Now we have start to use 3 ply corner sheet on pallet packing & save 2.31 lacs./ annum
42	QAD M 1-6	K - QAD M1-6 01	Checking of exceptional FRS of R/F's		Will lead to consistency in hairiness with reduced fly generation at end use & scope of burning of Ring traveller will be reduced.
43	QAD M 1-6	K - QAD M1-6 02	Display of bad habits in checkers's meeting		Live presentation will reflect effective impact in work practices.
44	QAD M 1-6	K - QAD M1-6 03	Specific checking for core spun lycra running R/F's i.e. Cross roving working, Fly accumulation on roving guide, Damaged roving guide.		For getting enhanced consistency in quality.
45	QAD M 1-6	K - QAD M1-6 04	Identification & recognition of creative investigators		On monthly basis
46	QAD SJ11 & M9	K - QAD SJ11 01	Work Instruction board show in front of QAD Instruments.		Improve proper working by operator
47	QAD SJ11 & M9	K - QAD SJ11 02	Almirah Index show inside door for easy file searching.		Improve 5 S
48	QAD SJ11 & M9	K - QAD SJ11 03	Arrow mark insert for showing file ascending order.		Time saving and easy file searching
49	QAD SJ11 & M9	K - QAD SJ11 04	Mark by yellow strip for fix chair area.		Improve 5 S
50	QAD SJ11 & M9	K - QAD SJ11 05	Identification display mention out side of cubed.		Improve 5 S
51	QAD SJ11 & M9	K - QAD SJ11 06	Identification display mention at the place of S/F bobbin zone.		
52	MAINT M1-3	K - MAINT M1-3 01	SAVIO YARN ECONOMIZER SHUTTER DAMAGED FROM INSIDE.		WE MODIFIED IT BY SET WITH BUSH AND FIT IT IN M/C WITH ELLEN KEY SCREW, NOW IIS WORKS APPROPRIATELY.
53	MAINT M1-3	K - MAINT M1-3 02	SAVIO TENSION DISC MOTOR COVER SCREW THREAD DAMAGED.		WE MAKE A HOLE AND THREAD IN SIDE MOTOR COVER AT ANOTHER PLACE AND FIT IT WITH SCREW.
54	MAINT M4-6	K - MAINT M4-6 01	Mill no 4 Robotic doffer Lifting Bkt broken and doffer stopped.	0.27	Make robotic doffer Lifting BKT in house and started the robotic doffer and save Rs-27000, and save doff time also.

55	MAINT M4-6	K - MAINT M4-6 02	Mill no 4 PS Ch Wdg started without Ohtc.		Modified the old Ohtc creel in house and started the Ohtc in New Ps Ch wdg no1&2 in mill 4.
56	MAINT M 9	K - MAINT M9 01	Bidirectional Clutch of Jingwei Speed frame Clutch Pin gets out due to wire lock damage and Machine Side cut and 120 ends Broken .		Clutch pin modified with Lock nut .Now no out of Clutch pin and no Side cut of machine .
57	MAINT M 9	K - MAINT M9 02	M9A R/F Maintenance room , at work place all bearings , Stud , Bracket etc are get accumulated .		Kaizen done and Each bearings are sepereted with number . Stud and Brackets kept separately . Time reduced to attend break downs
58	MAINT M 9	K - MAINT M9 03	TFO no - 7 Vijay Lakshmi make , Cradle stop motion was not working due to non availability of required spares .		Some spares like Bearing Housing gets developed in house and Stop Motion started .
59	MAINT M 9	K - MAINT M9 04	Coiler Sliver guide of Card not working due to its stand damage .		Modified bracket is fixed to Stand and now Coiler Sliver guide of Card is working .
60	MAINT M 9	K - MAINT M9 05	Coiler Cover fixing Screw gets Thread slip .		Put 6 mm Screw in place of 5 mm screw with tapping .
61	MAINT SJ11	K - MAINT SJ11 01	BLOW ROOM PV LINE 2 CONDENSER & IN POLY LINE TO UNIMIX AND ONE CONDENSER IS BYE PASS WITHOUT AFFECTING THE QUALITY OF YARN.	10.00	AFTER BYPASS ALL THESE MACHINE WE SHOULD SAVE APPROX 10 LAKH / YEAR
62	MAINT SJ11	K - MAINT SJ11 02	DOFFER ARM GOING TO BEND DURING DOFFING, EXTRA MS SHEET IS WELD BOTH SIDE OF THE ARM DUE TO THIS PROBLEM IS SOLVED		
63	MAINT SJ11	K - MAINT SJ11 03	ONE SUCTION MOTOR IS CONTINUOUSLY RUN FOR SPEED FRAME OVER HEAD WASTE.MOTOR IS BY PASS NOW WE ARE USING SPEED FRAME SUCTION SYSTEM ALSO FOR OVER HEAD WASTE		ONE 3.5 KW MOTOR IS BYPASS . AND 1 YEAR SAVING IS APPROX 1 LAKH
64	MAINT SJ11	K - MAINT SJ11 04	DUE TO WRONG POSITION OF EMPTY BOBBIN IN TRAIN FULL BOBBIN WAS STRUCK WITH EMPTY BOBBIN,COLOUR CODING IS DONE FOR FULL AND EMPTY BOBBIN AFTER THIS DOFFER BREAKDOWN IS DECREASE		
65	MAINT SJ11	K - MAINT SJ11 05	DURING CLEANING OF FAN WASTE IN RING FRAME FOOT STAND WAS STRUCK WITH RING FRAME MC BODY DUE TO THIS RUBBING ACTION STRETCH MARK PRODUCED ON MC BODY,USED FALSE TWISTER IS FIX WITH FOOT STAND.AFTER THIS THE PROBLEM IS SOLVED		
66	MAINT SJ11	K - MAINT SJ11 06	WHEN TFO CHEESE WAS EMPTY TENSION MULTI DEVICE BREAK DISC WAS MISSING.IT'S A SERIOUS PROBLEM.BREAK DISC IS FIX WITH TENSION MULTI DEVICE.PROBLEM IS TOTALLY SOLVED	0.12	ONE BREAK DISC COST IS 10 /PCS ONE MONTH CONSUMPTION IS 100 PCS & FROM LAST 1 MONTH NOT A SINGLE PIECE IS PURCHASE. SAVING 1000 RS / MONTH
67	ENGG M1-3	K- Engg M1-3-01	LT Panel Heating	0.1	Heating reduce after kaizen.
68	ENGG M4-6	K- Engg M4-6-01	Previously the Power given to the camera adaptor is by loose wires which is unsafe.		Now provided the supply through proper switch socket which is now safe & good looking
69	ENGG M4-6	K- Engg M4-6-02	Machine stopped due to sliver stop motion unit defective & not available with us as spare		Replaced with another type unit with photocell & started the machine.
70	ENGG M4-6	K- Engg M4-6-03	Machine not stopping at the time of doff automatically due to dual operated relay faulty.		Installed finder make relay in parallel to stop machine at the time of doff after preset length
71	ENGG M4-6	K- Engg M4-6-04	M/C having fuses in protection of control phases which are too old & missing problem by holders.		Replaced with MCB which is more safe & will not miss phase.
72	ENGG M9	K- Engg M9 -01	There was three stablizer of 250 KVA each in circuit for auto coners		We remove those stablizer as we don't need of that now.
73	ENGG M9	K- Engg M9 -02	PLC conversion in Chinese ring frame.		We explore the solution in local market and go for conversion.
74	ENGG M9	K- Engg M9 -03	Drive installation in dryer.		We install the drive on dryer to get 10% increase speed of conveyor motor.
75	ENGG M9	K- Engg M9 -04	Junction box installation in Auto Coner DB.		There was a joint in trench of auto coner DB room, which was dangerous. So we get it above of the trench and install junction box for that
76	ENGG M9	K- Engg M9 -05	Making alteration of cabling path of ETP panel.		Water was entering in ETP panel during rain.
77	ENGG SJ11	K - ENGG SJ11 01	Drawframe LD2 Web guide choke safety sensor broken problem.		We have fixed inhouse made clamp for sensor safety & reduce down time.
78	ENGG SJ11	K - ENGG SJ11 02	H-plant SA & RA Fan running on Star Delta on 50 Hz.		We have installed VFD on SA & RA Fan & optimized the frequency with respect to Humidity & Temp.
79	ENGG SJ11	K - ENGG SJ11 03	5000 Ltr Plastic water tank damage.	0.075	We repair the Plastic tank inhouse.
80	ENGG SJ11	K - ENGG SJ11 04	Observe utility tools identification not Mentioned.		We have done identification for utility tools.
81	ENGG SJ11	K - ENGG SJ11 05	South Side Spinning RH & Temp variation problem increased.		We made a hole for exhaust air to control temperature in spinning department.
82	ENGG SJ11	K - ENGG SJ11 06	Observe RA Trenches light unless ON (When work on 1 trench remain all trench lights ON.)		We have installed separate MCB for RA Trench Lights.
83	ENGG SJ11	K - ENGG SJ11 07	Observe two street lights of wartsila not ON timely.		We have connected both street light with SJ11 Street Light timer.
84	ENGG SJ11	K - ENGG SJ11 08	Observe Identification of Emergency light not mentioned on Department Lightings		Identification of Emergency Lighting done.
85	ENGG SJ11	K - ENGG SJ11 09	Observe finish Godown Lighting ON unless.		We have fixed a timer switch on finish godoen lighting for Safety & energy saving used.
86	ENGG SJ11	K - ENGG SJ11 10	Observe LC CBF Module Dip switch not mentioned on Machine.		We have mentioned all LC CBF module setting on Machine & reduce down time.
87	ENGG SJ11	K - ENGG SJ11 11	Observe in QAD Area 2X2 Panel CFL Light fixed.	0.47	We have installed 2X2 LED Panel light for energy saving.
88	ENGG SJ11	K - ENGG SJ11 12	Observe H-plant TT Display in Unsafe Condition		We have fixed a safety guard on TT display.
89	ENGG SJ11	K - ENGG SJ11 13	Earlier EMS Cable installation work project given to Outside party.	0.13	We have installed cable by section wise inhouse team.

90	ENGG SJ11	K - ENGGSJ11 14	Xorella Display touch keypad not working & refused to repairing by Siemens.		We have found a party & repaired the display.
91	ENGG SJ11	K - ENGGSJ11 15	Air Conditioner Exhaust Fan Net Broken Problem.		We have fixed a wire mesh in front of exhaust fan for safety concern.
92	ENGG SJ11	K - ENGGSJ11 16	Observe Luwa Server identification not mentioned.		We have done identification of Luwa Server PC.
93	ENGG SJ11	K - ENGGSJ11 17	Observe Air filter of compressed air line identification not mentioned.		We have done identification for Air Filter.
94	ENGG SJ11	K - ENGGSJ11 18	Observe fork lift identification not mentioned.		We have done identification for fork lift charger for safety.
95	ENGG UTILITY	K - ENGG UTILITY 01	New NPD cooler platform Work	0	We have fabricate and erection platform for cooler And by this platform there is more safety.
96	ENGG UTILITY	K - ENGG UTILITY 02	Installed new hydraulics machine	0	we have installed a new hydraulic press machine for more Dyeing production.
97	ENGG UTILITY	K - ENGG UTILITY 03	Change the pulley of Dryer for more efficiency	0.54	We have use bigger size pulley for more Efficiency and more production
98	ENGG UTILITY	K - ENGG UTILITY 04	Robot spare is not repairable.	0	we have modified the robot spare and its working . And We are saving the new robot spare cost
99	ENGG UTILITY	K - ENGG UTILITY 05	making MS stand & fitted for pipe	0	We have making MS stand & fitted for pipe. Now the pipes are maintained for 5S
100	ENGG UTILITY	K - ENGG UTILITY 06	Repairing the base of grinder	0	we have weld it by help of MS plate. Now the grinder is working perfectly .
101	ENGG UTILITY	K - ENGG UTILITY 07	Installed Axial fan in Dye house	0	we have installed a new Axial fan on the wall and will reduced the department temp.
102	ENGG UTILITY	K - ENGG UTILITY 08	Pump is fit on the platform for saving place	0	We have installed the pump on the platform. So now there is more place for work.
103	ENGG UTILITY	K - ENGG UTILITY 09	Ash handling system improve	0.49	We have make and modified the Boiler APH Ash System and 100% use in boiler by FD air blow pipe
104	DYE HOUSE	K - Dye House 01	we have increase production of dryer by changing speed gear pully through maint		Dryer capacity increase from 7500 kg in 24 hrs to 9000 kg in 24 hours ,so that we manage increase dyeing production up to 3 ton in same dryer setup.
105	DYE HOUSE	K - Dye House 02	WE HAVE INCREASE DYE HOUSE DYED GODOWN SPACE CAPACITY BY SHIFTING SCRAP& WASTE YARD FROM DYED GODOWN TO OUTSIDE GODOWN		DUE TO INCREASE DYEID GODOWN SPACE BY SHIFTING SCRAP YARD FROM INSIDE GODOWN TO OUTSIDE ,GODOWN CAPACITY INCREASE UP TO 10 MT STORAGE AREA, WE HAVE STOP BIG MIXING BAG IN OUR GODOWN AND RELEASE AT THE TIME OF MIXING RELEASE TO SPG
106	Store & Purchase	K - S&P 01	Developed a data bank for keeping our records		Using this data bank we are saving lots of print out ,any one of store& purchase staff can see this on his desktop like -reports ,contracts,comparative etc.
107	Store & Purchase	K - S&P 02	We are maintaining a Emergency issue register in receipts section		By keeping Emergency register we are able to know the person who is issuing the material on urgent basis .
108	Store & Purchase	K - S&P 03	Develop a garbage trolley by using castor wheel in receipts section		Easy handling of garbage in stores receipts.
109	P&IR	K - P&IR 01	KAIZEN Theme : Worker's Punching Systems Improve		Worker's Punching Machine installed 13 In palce of 9 Punching Machine
110	HRD	K - HRD 01	Personal Files were not in proper place.		Proper space with marking.
111	HRD	K - HRD 02	Files was not properly placed in Almera.		We segregate the files with department wise & properly tag the file for ease of working.
112	IT	K-IT-01	Development for Production Incentive Record keeping <b>Before Kaizen:</b> All Records maintained manually in excel, there are chances of manual error <b>After Kaizen:</b> Developed new AI (Additional Informatin) in System and Updated records with proper validation and save users data maintenance time		Time saving and accuracy of data achieved
113	IT	K-IT-02	Power Saving by using Sun Light in Office Before Kaizen: Using Tube lights during office hrs. After Kaizen: Total 8 Nos of tube lights switched off and using sun light	0.03	Implemented and continue
114	IT	K-IT-03	Resolved BARCO Production issue without Cost Before Kaizen: TFO no. 1 to 28 not capturing production in BARCO system of SJ-11 After Kaizen: Now all TFO's capturing production	0.20	Implemented
115	GUEST HOUSE	K - GH 01	Proper place for Key not present.		We Made a proper stand for Key
116	GUEST HOUSE	K - GH 02	Comman Dining Hall identification Not Mentioned.		We done identification of Common Dining Hall
117	GUEST HOUSE	K - GH 03	Cleaing Sudueal deep freeeze		We Made a day of cleaning deep Freeze
<b>Total Annualized Amount</b>				<b>15.61</b>	