

RSWM Kharigram - KAIZEN Summary Sheet June 2017

| S.N | Department | Kaizen No. | KAIZEN Description | Annualized Benefit Rs. lacs | Status after Kaizen |
|-----|---------------|--------------------|--|-----------------------------|--|
| 1 | SPG M4-6 | K - SPGM4-6 01 | Prepare a new blow room office in mill no. -4. | | Prepare new blow room office. Its good looking,attractive,,airy & 5s maintained |
| 2 | SPG M4-6 | K - SPGM4-6 02 | Make identification on Lycra Room. | | Identification on Lycra Room . Its good looking ,attractive & 5s maintained. |
| 3 | SPG M4-6 | K - SPGM4-6 03 | Install the grinder on proper place in mill no. -4. | | Make proper place & Installed the grinder & avoid the chances of fire accident. |
| 4 | SPG M4-6 | K - SPGM4-6 04 | Install the Foot paddle switch on grinder of mill no. -4. | | Putting foot paddle switch & save the power. |
| 5 | SPG M4-6 | K - SPGM4-6 05 | Make Layer mixing bin in Blow room mill no. -4. | | After prepare layer bin. We are able to prepare all type of mixing . |
| 11 | SPG M9 | K - SPG M9 01 | M9A RF 24 jail broken Dangerous during working. | | After kaizen new jail put |
| 12 | SPG M9 | K - SPG M9 02 | Trench opening jail broken may be dangerous . | | Trench jali repaired. |
| 13 | SPG M9 | K - SPG M9 03 | Cooler was not found in M9B | | Cooler placed inM9B . |
| 14 | SPG M9 | K - SPG M9 04 | Lower Wall height of mixing bin. | | Wall height increase . Bin capacity increase. |
| 15 | SPG M9 | K - SPG M9 05 | Duct broken in M9A May be dangerous. | | Duct repaired . |
| 16 | SPG M9 | K - SPG M9 06 | False ceiling broken may be dangerous . | | New false ceiling put. |
| 17 | SPG M9 | K - SPG M9 07 | IN SF 11 blower head suction nozzle not at proper place quality issue | | After kaizen suction nozzle put at proper place. |
| 18 | SPG M9 | K - SPG M9 08 | Ele wire open RF 11 panel may be dangerous. | | Ele wire covered. |
| 19 | SPG M9 | K - SPG M9 09 | Ele wire open may be dangerous | | Ele wire under floor |
| 20 | SPG M9 | K - SPG M9 10 | Fibre hanging in all ceiling groves. | | Metal sheet used. |
| 21 | SPG M9 | K - SPG M9 11 | Doffing trolley broken Poor method of material handling. | | Broken Doffing trolley repaired & material handling easy . |
| 22 | SPG M9 | K - SPG M9 12 | Safety guard absent | | Safety guard put. |
| 23 | SPG M9 | K - SPG M9 13 | NO door available . | | Door put in bin room .mix-up avoid . & conditioning improve . |
| 24 | SPG M9 | K - SPG M9 14 | False ceiling broken | | New false ceiling put |
| 25 | SPG M9 | K - SPG M9 15 | Prep. Office for CPU not proper place . | | A wooden stand put FOR CPU |
| 26 | SPG M9 | K - SPG M9 16 | Narrow tape in drum pulley running . Low TPI Yarn formed. | | After kaizen full size tape use in drum pulley |
| 27 | SPG M9 | K - SPG M9 17 | Wall separator not found Due to this house keeping affected | | Wall separator G.I sheet fit in wall as a separator. & house keeping maintain. |
| 28 | SPG M9 | K - SPG M9 18 | Top arm pressure loose .Quality problem i.e cv% count variation. | | Top arm pressure correct. Quality improve. |
| 29 | SPG SJ11 | K - SPG SJ11 01 | We observe that in RF department some tube light were not working | | So attended by Elect team |
| 30 | SPG SJ11 | K - SPG SJ11 02 | We observe that in in VIP alley some false ceiling sheets colour fade so looking bad | | So sheets changed |
| 31 | SPG SJ11 | K - SPG SJ11 03 | We observe Some cans of draw frame were damaged in various aspect | | So all damaged cans repair work done |
| 32 | SPG SJ11 | K - SPG SJ11 04 | We observe that in RF 32,34 start up breakage were high on 2/0 MS HF Rtr in 40 Poly count | | So we switch on 2/0 U1US (+) Rtr now start up breakage reduced by 1% |
| 33 | SPG SJ11 | K - SPG SJ11 05 | We observed that in RF 8 breakage level and start up breakages very high | | So ring changed by new one |
| 34 | SPG SJ11 | K - SPG SJ11 06 | We observed that in RF37 AB carter Ring high start up breakage on 7 C1 HRMT Rtr | | So we switch on 7 UTH hrw Rtr now start up breakage reduced by 2.0% |
| 35 | SPG SJ11 | K - SPG SJ11 07 | We observe that fresh roving dropping in slits by air suction | | So we modify slits and attach a perforated sheet on slits to avoid this |
| 36 | SPG SJ11 | K - SPG SJ11 08 | We observed that high roving breakage problem on RF creel | | So TPM in creased by one step in poly SF roving , now creel breakage on Rf reduced |
| 37 | SPG SJ11 | K - SPG SJ11 09 | We observed in 40 poly hazira cut level high on Licker in speed 1040 RPM | | So take a trial in line no 5 and speed increased to 1200 RPM now cut and alarm level reduced |
| 39 | POST SPG M1-3 | K - PS M1-3 01 | | | |
| 40 | POST SPG M1-3 | K - PS M1-3 02 | | | |
| 41 | POST SPG M1-3 | K - PS M1-3 03 | | | |
| 42 | POST SPG M1-3 | K - PS M1-3 04 | | | |
| 43 | POST SPG M4-6 | K - PS M4-6 01 | | | |
| 44 | POST SPG M4-6 | K - PS M4-6 02 | | | |
| 45 | POST SPG M4-6 | K - PS M4-6 03 | | | |
| 46 | POST SPG M4-6 | K - PS M4-6 04 | | | |
| 47 | POST SPG M9 | K - PSM9 01 | | | |
| 48 | POST SPG M9 | K - PSM9 02 | | | |
| 49 | POST SPG M9 | K - PSM9 03 | | | |
| 50 | POST SPG M9 | K - PSM9 04 | | | |
| 51 | POST SPG SJ11 | K - PS SJ11 01 | | | |
| 52 | POST SPG SJ11 | K - PS SJ11 02 | | | |
| 53 | QAD M 1- SJ11 | K - QAD M1-SJ11 01 | Packing material - Supplier wise performance evaluation | | To identify the scope of getting consistency between suppliers |
| 54 | QAD M 1- SJ11 | K - QAD M1-SJ11 02 | Job twisters - Performance wise evaluation | | To identify the weak link & get improved performance for consistency |
| 55 | QAD M 1- SJ11 | K - QAD M1-SJ11 03 | Shade No. 411234 Black to get improved neps in fabric appearance | | Redevelopment of shade with 1- 15 % on along with N1450 or 4385 in place of N9676 |
| 56 | QAD M 1- SJ11 | K - QAD M1-SJ11 04 | Shade No. 386820, 2/30 P/V to get improved white picky | | Redevelopment of shade with 2 denier PSF grey in place of 1.4 Denier |
| 57 | QAD M 1- SJ11 | K - QAD M1-SJ11 05 | To get improved kitty specs in IKEA quality - loffalet Beige Quality by following scouring process | | To come out from the problem of kitty in fabric appearance |
| 58 | QAD M 1- SJ11 | K - QAD M1-SJ11 06 | 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 |
| 59 | MAINT M4-6 | K - MAINT M4-6 01 | The center top Toyada tube damaged of Electrojet Simplex in mill 4, So, mc was running 50% delivery speed only. | 0.58 | we developed the spare locally in Rs 65/pc against Rs-585.And now mc running on full speed. |
| 60 | MAINT M4-6 | K - MAINT M4-6 02 | There was bottom clearer in bad condition and spares of Clearer was not available easily in market. | | We modified the bottom clearer as bottom stripper and now running ok. |
| 61 | MAINT M 9 | K - MAINT M9 01 | cam housing of jingwei speed frame top clearer not work properly due to bottom clearer modification because it drives for both top and bottom clearer . | | cam housing of If 4200 speed frame is used and now working is satisfactory . |
| 62 | ENGG M1-3 | K- Engg M123-01 | Flood led light of Badminton cort | | After Kaizen LED flood light installed of 150 watt |
| 63 | ENGG M1-3 | K- Engg M123-02 | Fire exit board in off & damage condition | | After Kaizen in house repairing of fire exit board |
| 66 | ENGG M4-6 | K- Engg M4-6-01 | There is no emergency light inblowroom section | | After that install 3 emergency light in blowroom section improve safety level . |

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| 67 | ENGG M4-6 | K- Engg M4-6-02 | In respective section the paint is looking light & old . | | After that making proper paint in respective breaker improve 5S & proper marking in respective section . |
| 68 | ENGG M4-6 | K- Engg M4-6-03 | PDB Panel having hot & warm -UP | | After install cooling fan "8" inches in PDB panel Hot air is out.proper cooling . |
| 73 | ENGG M9 | K- Engg M9 -01 | LED Lamp installation for Pinter in R/F of M-9B. | | There was indication light in pinter system having bulb, which were fusing frequently. We replace them with LED type lamp. These were laying spare inSJ-11 and not in use. |
| 74 | ENGG M9 | K- Engg M9 -02 | Upgraded Process Controller installtio in dyeing machine | | There was frequent failure of Process Controller PC-4. We explore and found a upgraded system PC-10. It help to reduce the breakdown of dyeing machine. |
| 75 | ENGG M9 | K- Engg M9 -03 | Metering Work to take actual consumption of RO and ETP | | Previous metering system was not proper. It did not give proper consumption due to lapses of un-conectivity of some pumps with its actual meter. We laid cable to take their consumption on same meter. |
| 76 | ENGG M9 | K- Engg M9 -04 | Lighting relocation in dye house colour room | | There was lighting fitted lower down in colour room. It was unsafe condition. We relocate its place at aproprate hight and make safe condition. |
| 77 | ENGG SJ11 | K - ENGGSJ11 01 | It was observed that compressed air cleaning air line was all department common found misuse & there is scope of energy saving. | | We modified the air line for separate-separate department to avoid misuse compressed air. |
| 78 | ENGG SJ11 | K - ENGGSJ11 02 | It was observed that BTS area sliver was thro in the trench . | | We made a GI mesh in house to avoid mishandling of fiver waste. |
| 79 | ENGG SJ11 | K - ENGGSJ11 03 | It was observed that wartsila penal Room in cable trench cable hole found without any safety. | | We made a GI plate and covered cable hole in house to avoid necessary tripping & unsafe condition. |
| 80 | ENGG SJ11 | K - ENGGSJ11 04 | It was observed that wartsila penal room trench in side going not any ladder & without ladder unsafe. | | We made a ladder in house to avoid any majer incident. |
| 84 | ENGG UTILITY | K - ENGG UTILITY 01 | Fix a new Cover on machine valve. | | After Kaizen We have fabricated a new cover and fix it on the valve of machine for safety purpose.. |
| 85 | ENGG UTILITY | K - ENGG UTILITY 02 | Repair Lock ring for dyeing machine | | After Kaizen we repaired this lock ring by using the welding. And saved the cost of new lock ring. |
| 86 | ENGG UTILITY | K - ENGG UTILITY 03 | Fabricated and fix a new shed. | | After Kaizen we have fabricated and fix a new shed for the safe storage of chemical for Rochem RO plant. |
| 87 | ENGG UTILITY | K - ENGG UTILITY 04 | Installed a new pump for using condense water of boiler | | After Kaizen we have installed a new pump for using condense water in over head tank for the boiler. |
| 88 | ENGG UTILITY | K - ENGG UTILITY 05 | Installed a new jumbo cooler in power house | | After Kaizen we have installed a new jumbo cooler in power house of mill no- 4 & 5.for panel cooling. |
| 88 | IT | K-IT-01 | Manual Checking of Onroll was done from Different Reports. | | Provided single report with department & designation wise On roll Position |
| 89 | IT | K-IT-02 | No data entry made by user in M3 for TFO production as well as stoppage report in Budget needs this data for MIS reporting purpose, same is available in BARCO | | We have taken this task as a kaizen and developed interface software for BARCO & M3 and make it live from 01st Jun 17, Now TFO production data is available in M3 at the end of shift automatically |
| 90 | IT | K-IT-03 | CCTV cameras were connected with common company network | | Created separate network for CCTV cameras by VLAN Now traffic of CCTV will be differentiate from remaining traffic, It will improve the network performance overall |
| Total Annualized Gain for the Month of Apr.'17 | | | | 35.40 | |