| LN | Department | Kalaes No. | RSWM Kharigram - KALI KAZIKN Description | Annualized Benefit | Status after March 2016 Status after Malaes | MG | вку | GB | RKS | VC | Tor |
|----------|--------------------------------|--|---|-----------------------|--|----------|----------|----------|----------|----------|---------------|
| 79 | ENGG UTILITY | K - ENGG UTILITY 01 | Air Flow Meter removing from main line for calibration | 0.25 | After Kaizen We have plan of stop the mill wise 5-10 minutes, but our technicien work on main pressure line and removed the flow meter with out shut down and after calibrated flow meter fitted on main fine. This flow meter calibrated work in all mil. | 15 | 17 | 20 | | 20 | 73 |
| 68 | ENGG SJ11 | K - ENGGSJ11 03 | Tube Cleaner touch display (Make Siemens) OP177b 4" was not work & actual cost of display is 1.14 Liacs. | 0.74 | We arraine the NH Schriftste & installed Sciences OP177 8.6" display & display and in Rs. 0.40 | 14 | 20 | 3 | 19 | 13 | H |
| 3 | | K - SPGM4-6 01 | | | Lacs. Thus saved Rs. 0.74 Lacs | | 20 | | | | 6 |
| 30 | SPG M4-6 POST SPG M0 | K - SPGM4-6 01 K - PSM9 03 | Lappet rail titing time reduce in RF G5/1 in Mill no.4. PACKING COST REDUCED IN RE ISSUE PACKING BY USING OLD HDPE BAGS | 2.30 | After keizen lappet rall firring 11 second, seving of 11 second in every dolf. WE ARE SAVING RS. 12000 / MONTH (1.44 Lacs / year) IN PACKING COST BY USING OLD HOPE BAGS IN RE - ISSUE PACKING. | 20 | 13 | 19 17 | 18 | 11 | |
| 62 | ENGG MO | K-Engg M9-05 | For Ring Rail Movement, control through Limit Switch Jt is very costly (RS.3000) | 0.48 | HDPE BAGS IN RE - ISSUE PACKING. In place of limit Switch fixed Sensor for Ring Rail Movement control is cheap in price. RS1000 | 13 | 12 | 11 | 12 | 10 | t |
| 4 | SPG M4-6 | K - SPGM4-6 02 | Removal of Ventilator Fan (Booster Fan) from blow Room line no.1 in Mill no.5. Saving of 5 KW Power Load. | 1.80 | After keizen Removal of Ventilator Fan (Booster fae) from the line ,consisting 5 KW Motor. Power savino: is there. Now feeding of material directly handled by Condenser's Fan. | 19 | | 18 | 16 | | T |
| 8 | SPG M9 | K - SPG M9 01 | Fly accumulated in gears . | | To prevent fiv into gears a cover was provided | | 19 | | 10 | 12 | t |
| 46 | MAINT M 9 | K - MAINT M9 03 K - QAD SJ11 05 | Difficult to open Take Up Roll Bearing housing of Carding machine . 2-3 hours was sequired to open it and damage of bearing Housing . | | Kaizen done to remove Bearing Hossing . Modified Disc developed in house to grip Puller linger . Now Time required = 20 min . Safe from damage of Housing . | | 7 | | 13 | 19 | L |
| 39 58 | QAD SJ11 & M9 ENGG M9 | K - QAD SJ11 05 K- Engg M9 -01 | Start online Ring Frame Breakage Study by Pinter (RYAL) . Speed frame ONOFF/INCH push Button assembly made in Chaina is very high cost. | 0.04 | Improve the efficiency, productivity, quality & reduce R/F Breakage of the R/F machines. Speed frame ON/OFF/INCH push Button assembly made by self and approx cost is 500. | 11 8 | 9 | 15 5 | 9 | 3 | H |
| 31 | POST SPG Ma | K - PSM9 04 | PACKING COST REDUCED BY USING PLASTIC HOLE SHEET & PALLETS IN RE IS | 1.80 | NOW WE ARE USING ONLY PLASTIC HOLE SHEET & PLASTIC PALLETS FOR PACKING COST SAVING . NET SAVING COMING OF RS.15000/MONTH (1.80 Lacs. / year) | 18 | | | 17 | | |
| 50 | MAINT SJ11 | K - MAINT SJ11 02 | SUCTION JAALI WEAR OUT PROBLEM: USING MODIFIED CLAMP AND SUCTION JAALI, AFTER THIS MODIFICATION PROBLEM IS SOLVED | | LIFE OF SUCTION JAALI IS INCREASED.COST OF ONE PCS IS 250 RS | | 6 | 13 | | 16 | İ |
| 23 | SPG SJ11 | K - SPG SJ11 09 | We observed 6 ceiling fan,which was operate by common connection by 1 switch | | Now each fan operate by individual switch and save electricity | | 11 | | 15 | 7 | ł |
| 26 44 | POST SPG M1-6 MAINT M 9 | K - PS M1-6 03 | In multy fold bamboo yarn fly generation is always higher, and contaminate other yarn. Duct cleaning is difficult in Ring Frame machine and it takes more time. | | arrange a permanent partition of GI sheet to avoid contaminations. With Modified cover cleaning is easy and time saving. | | 8 | 16 7 | 11 | 15 5 | ł |
| 65 | ENGG SJ11 | K - ENGGSJ11 (2 | Auto flow Palletizer Encoder cable as earlier supplied by OEM & cost of cable is Rs. 13940.09 | 0.02 | We explore the cable (Make-Igus) & cost of cable is Rs.11935.00. Thus saved Rs.2005.00 for each time replacement. | | 12 | | 18 | _ | t |
| 28 38 | POST SPG Mb QAD SJ11 & Mb | K - PSM9 01 K - QAD SJ11 04 | Valve Jopener & locking system fitted perfectly in pressure line to control wastage of compressed air. Machine calibration date board put over all QA machines. | 1.20 | Controlles lekage of compressed sir. Looking attractive. Follow 5s System. | 9 | | 2 | 14 20 | 4 | ļ |
| 45 | MAINT M 2 | K - MAINT M9 02 | Web Guide of Jingwei Draw Frame: get broken due to fall down after Front Bottom roll | 0.42 | Kalaan done to avoid damage of Web Guide of Jingwel Draw Frame. It is fied with Old Clutch wire to machine Body. Now Web Guide not fall down and no | 10 | | 14 | | | Ī |
| 64 | ENGG SJ11 | K - ENGGSJ11 01 | Auto flow unloader safety sensor as earlier supply by OEM & cost of sensor Rs. | 0.12 | damage . We explore import sensor (Make-Sick) & installed. Cost of 1 sensor is Rs. 960.00. Thus saved | 2 | 16 | | | | $\frac{1}{1}$ |
| 82 | ENGG UTILITY | K - ENGG UTILITY 04 | askn nn mill no.6 R/F ,Cdg & TFO at Rotary filter LUWA Make in H Plant. This gear box is supply by LUWA and very light duty. | 0.84 | we depose import service /nase-locky & retained. Lost on 1 service in 4. 360,00.1 http://dx.ntm.saxed. See 4.000 from any himmenship service from the first ser | 16 | | | 8 | | t |
| 91 | IT | K-IT-01 | Implemented Main Gate Entry System at Locha Plant successfully No bobbin box & Rift doffs kept on doffing basket which take maximum space in | | | 12 | | 12 | | | ļ |
| 12 | SPG M1 - 3 SPG M9 | K - SPGM1-3 02 K - SPG M9 07 | RF starting bigs were higher | | prespare bobbin boxes. Every RIf dolfs check by investigator Jooking attractive & 5a maintained. Reduced start up breaks after introducing this practice. | 5 | 15 18 | | | | ł |
| 73 51 | ENGG SJ11 ENGG M1-3 | K - ENGGSJ11 10 K- Engg M123-01 | Waste water drains chocked frequently. Electronic belance wiring proper and lying property | | We have Fixed wire mesh(1") on waste water drains. According to this kaizen improve 5s level | | Ė | | | 18 17 | ļ |
| 67 | ENGG SJ11 | K - ENGGSJ11 04 | | 0.05 | We explore & installed a supporting clamp for tube Rod. | | | 8 | | 9 | |
| 72 42 | ENGG SJ11 MAINT M4-6 | K - ENGGSJ11 09 K - MAINT M4-6 02 | broken and also holder is not available in market. Hylatet Alley Lighting manually ONOFF by operator & sometimes 15 min. delay to sealched OFF he latet. 71 T CARRIER WHEEL SHAFT DAMAGED AND NOT AVILABLE WITH US. | 0.01 | We have fixed automatic street light timer for H-plant alley lighting ONOFF timely. TAKEN DAMAGED SHAFT FROM SCRAPAND MAKE IT IN HOUSE 4 NOS. SAVE RS-1200- | 6 | | 9 | | | ł |
| 68 | ENGG SJ11 | K - ENGGSJ11 05 | Boxing Line Package counter sensor frequent damage Problem & sensor cost is Rs.3149.00 (se per lest curchase) | | We changed the sensor plate position | | | | | 14 | İ |
| 55 27 | ENGG M4-6 POST SPG M1-6 | K - Engg M4-6-02 K - PS M1-6 04 | THE OPERATOR AND DOFFER CAN'T ABLE TO STOP OR REVERSE THE OHTC. Shining, & rupture bobbins not arrest properly in ejection bobbin tray'. | | NOW BOTH SIDE PUSH BUTTON STATION INSTALLED FROM WHICH THEY CAN STOP OR REVERSE THE DIRECTION OF OHICE. Arrange a LED Bub on bobbins ejection Tray, to Essaily arrest the shiring / Rupture bobbins from earting the second tray. | | 5 | | 12 | 8 | ļ |
| 94 | P&R | K-P8IR-01 | KAIZEN Theme: Bell porvision in one place In staff colony | | Item election hav Bell porvision in four places in staff colony . Sec. Guard timeing save . Increase afficitiveness . | | 4 | 1 | 5 | | ł |
| 95 | CPPC | K-CPPC - 01 K-Engg M9 - 04 | To consume aging' non moving / overage fibre and viscose Truttachler Mechine pistor Limit Switch OEM Cost is Rs. 3000. | 1.81 | To lay the same mixing in such maner with out affected the deliveries of other material. Trustrischler Machine piston fixed Sensor it is very low cost. (RS.300) | | | | 10 | | Ī |
| 87 | ENGG M9 ENGG UTILITY | K - ENGG UTILITY 09 | Mill no.1 to 5 Cone trolley Use in Winding department | 0.05 | MB no.1 to 5 Cons trolley. Use in Winding department. We have removed the plastic cone cap by grinder from trolley used this work completed in house basen. Apps. Trolleysid0 Nos. | 7 | | • | | | t |
| 9 | SPG M9 ENGG SJ11 | K - SPG M9 04 K - ENGGSJ11 11 | Outside air come into the deptt while opening the shutter To reduce chocking of Air cooler of compressor | | PP curtain was placed to control RH & temp. | | Ļ | | | 6 | t |
| 74 13 | SPG M9 | K - SPG M9 08 | was hanged excess height and not readable | | We have fixed micron wire mesh on Air cooler of compressor. Height visis lowered and now it is readable. | | 2 | | | | t |
| 56 22 | ENGG M4-6 SPG SJ11 | K- Engg M4-6-03 K - SPG SJ11 08 | THE YARN LOCK HAVING PLAY DUE TO FIXED ON ONE SCREW. In past, projector field from conference half | | MODIFICATION DONE IN THE CUTTER ANVIL FORM OUT SIDE AND FIXED THE YARN LOCK ON TWO SCREW NOW NO PLAY. Camera install in office alley for safety of projector in conference half | | 1 | | | 2 | ŀ |
| 40 | MAINT M1-3 DYE HOUSE | K - MAINT M1-3 01 K - Dye House 01 | Bakelite Silver Guide Pulley Fly/Fiber Jam Problem Was Matter Of Course Result Low Fit Of Mar. | | We Replaced Bakelite Pulley By Iron Rollers And Iron Rod As Sliver Guide, Now Problem Solvert | | | | | 1 | Į |
| 88 | SPG M1 - 3 | K - Dye House 01 K - SPGM1-3 01 | Making of Iron stick Platform brush which is much stroger and work longer time due to per Old mechanical type weighting balance on Bit line no1 of mill no1 | 0.05 | If using of iron stick platform brush in mill level only ,we save atteast 40 thousand annually Put new type electronic balance , its show actual weight, reduce the chance of weight mistake. | 1 | | | | | ł |
| 5 | SPG M4-6 | K-SPGM46 03 | Checking of Lycra Missing Sensors by Camera of Smart phones. | | After kaizen: Checking of Lycra Missing Sensors doing: with Camera of Smart phones. | | | | | | t |
| 7 | SPG M9 | K - SPG M9 02 | hand written display board in RFSB | | Computer font pasted now it is clear and attractive . | | | | | <u> </u> | |
| 10 | SPG M9 SPG M9 | K - SPG M9 03 K - SPG M9 05 | Doff baskets place was not identified Colourwise racks for keeping SF empties was not identified | | it was identified by yellow marking tape Colourwise racks: identified | | | | | | t |
| 11 | SPG M9 SPG M9 | K - SPG M9 06 K - SPG M9 09 | Report pasted on wall Key board, mouse, monitor, printer area was not specified | | Notice board intodiced Key board, mouse, monitor, printer area specified | | | | H | | t |
| 15 16 | SPG SJ11 SPG SJ11 | K - SPG SJ11 01 K - SPG SJ11 02 | There was no any display board in depti for 5'8' activity We are using plastic token having cost. Rs. 12 Per token and durability is low | | We introduce a standing board in deptit to display 5'S' activity. Now we are using G I Sheet token having cost. Rs. 10 and durability is. high | | | | | | Ŧ |
| 17 | SPG SJ11 SPG SJ11 | K - SPG SJ11 03 K - SPG SJ11 04 | We have observed black spot on SF head stock due to touching of waste box cover. We observed in VIP alloy between RF 20 & 21 full ceiling damage very bady. It may | | Waste box cover & black spot removed We repeir fall ceiling . | | | | | | F |
| 19 | SPG SJ11 | K - SPG SJ11 05 | Desires an accident We have observed Office alley wall was being flaking due to movement of SX trolley | | Install wall guard to avoid flaking and paint work done. | | | | | | t |
| | SPG SJ11 SPG SJ11 | K - SPG SJ11 06 K - SPG SJ11 07 | We observed flaking spot in training center We observe ordinary scap case in washroom | | Repairing & paint work done We have put steel scap case | | | | | | t |
| 24 25 | POST SPG M1-6 POST SPG M1-6 | K - PS M1-6 01 K - PS M1-6 02 | We have facing contamination problem in PS ch. Wdg, in same side contrast shade. Contrast fly contaminated in other shade. We were facing contamination problem when run contrast shade on Cheese wdg. | | To social the contamination moveble partition statched in between the contrast shade. To avoid contamination. Fixed a sample stand so identify the colour code , and better understanding about the running lot | | | | H | | ł |
| 29 32 | POST SPG M9 POST SPG SJ11 | K - PSM9 02 K - PS SJ11 01 | CONE RACK HAS BEEN MODIFIED & HOUSE KEEPING IS OK. Balance condition come aris not fix. | | colour codino, also samples of chesses / comes arrange systematically. CONE RACK HAS BEEN MODIFIED & HOUSE KEEPING IS OK IN TFO SECTION Balance condition come aria fix & Name plate fix. | | | | | | ŧ |
| 33 | POST SPG SJ11 | K - PS SJ11 02 K - QAD M1-6 01 | TFO Lifter no not identify. | | The no passe on MC & Easy for indefication for all. To identify the abnormal cases if any which will support in effective checking of material in running. | | | | | | ļ |
| 34 35 | QAD M 1-6 QAD SJ11 & M9 | K - QAD SJ11 01 | Color blind test of all deptt. investigators Prepare daily card wise card samples & taking corrective action against high IPI value of card. | | crocess . Improvement of PM & poly material quality. | H | H | H | H | | t |
| 36 37 | QAD SJ11 & M9 QAD SJ11 & M9 | K - QAD SJ11 02 K - QAD SJ11 03 | Mark by yellow strip for fix area of weighing balance. Start critine abrormal drum finding by Visual manager. | | Locking attractive. Follow 5s System. Essyly finding abnormal drum , quick taking currective action against & improve yem quality. | F | F | F | H | Ξ | f |
| 41 | MAINT M4-6 | K - MAINT M4-6 01 | THERE WAS ON FOUR PLY MATERIAL RUNNING YARN BRACKAGE AGAIN AND AGAIN DUE TO HEGH BALONING | | AFTER MAKING THE BIG SIZE SAPRATORE OF G I SHEET IN HOUSE OUR PROBLEM IS SOLVED. | | | | | | t |
| 43 47 | MAINT M4-6 MAINT M 2 | K - MAINT M4-6 03 K - MAINT M9 04 | THERE WAS PRESSUREPIPE BEND PROBLEM IN VARIATOR PISTION. Earlier Cleaning is not proper. | | MODIFIED THE VARRIATOR PISTION 1' CONNECTOR IN 1' CONNECTOR, PROBLEM OF PIPE BEND RESOLVED. Cleaning is better with using modified Nozzle. | 1 | 1 | 1 | H | | Ŧ |
| 48 | MAINT M 9 | K - MAINT M9 05 | Files are not kept properly and rack was not design as per file set up | | Rack is molfed and files are kept as per 5 S System . | | | | | | t |
| 49 52 | MAINT SJ11 ENGG M1-3 | K - MAINT SJ11 01 K- Engg M123-02 | CLOTH COVER PLATE FALL DOWN PROBLEM Computer wiring proper | | FIT 4MM LN KEY BOLT TO SOLVE OUT THE PROBLEM According to this keizen we improve safety level | 1 | 1 | 1 | H | | Ŧ |
| 53 54 | ENGG M1-3 ENGG M4-6 | K- Engg M123-03 K- Engg M4-6-01 | Computer warrap proper LED Light Conversion Deservation: Before motor is starting with abnormal sound due to this gearbox was | | According to this accurate was improve a salety well. After this leaties we can salety energy. After installing the inventer now motor is starting smoothly. | F | F | F | | _ | ŧ |
| 57 | ENGG M4-6 | K- Engg M4-6-04 | damaged several times. | | AFTER CHANGE THE POSTION NO ANY SUCH STOPPAGE OBSERVED. | H | H | H | H | | t |
| 60 | ENGG M9 ENGG M9 | K- Engg M9 -02 K- Engg M9 -03 | WINDOWS POSITION TO WITCH WE ARE REQUERTED FACING WILL STOPPAGE DUE TO SHORT CKT. Cable root of linc coner is not proper way Chaina Speed frame Fault indication Lamp to very costy | | Cable not of linc corer is proper way. Chains Speed frame Fault Indication Lump Fixed local make it is low-prices. | E | E | E | H | Ē | f |
| 63 | ENGG M9 | K- Engg M9 -06 | Plant Out Side DB Panel Condition is Very Bad | | Make Properly Dressing of Cable and close DB panel. | | | | | _ | f |
| 69 | ENGG SJ11 | K - ENGGSJ11 06 | Auto flow unloader Package sensor base plate clamp broken. | | We Explore clamp in house & fixed. | | | | | _ | 1 |
| 70 71 | ENGG SJ11 ENGG SJ11 | K - ENGGSJ11 07 K - ENGGSJ11 08 | H-plant material not properly placed due shortage of space. Compressor Air Line Valve identification not mention. | | We explore stacking system & fixed in house made angle stand for placed all material properly. Compressor Air Line Valve identification done as shown in Picture. | H | F | H | H | | ł |
| 76 | ENGG SJ11 ENGG SJ11 | K - ENGGSJ11 13 | To avoids bird in compressor area. Main Incomer (5000 Amp.) Temperature Increase problem. | | We have fixed a curtain of wire mesh. We have fixed 2 additional cooling fans for cooling. | E | E | E | H | Ē | f |
| 77 78 | ENGG SJ11 ENGG SJ11 | | Difficulty during RF cloth cleaning. Sevesge Tank identification not mention. | | We have fixed a stand for RF cloth cleaning & ease of working. We have done identification for Sewage Tank. | E | E | E | H | Ē | f |
| 80 | ENGG UTILITY | K - ENGG UTILITY 02 | Dye house. Hydro water over flow from pit to Road due to jam. RO Plant pump for RO 300 cleaning. | 0.60 | We have removed the jam by high pressure and solved the problem. This was the major issue of civil department flut our negrop solved the problem with our cost | | | | | | ļ |
| 81 | ENGG UTILITY ENGG UTILITY | K - ENGG UTILITY 03 K - ENGG UTILITY 05 | RO Plant pump for RO 300 cleaning. IN Rochem RO Plant. HCL is use in Rochem RO plant for reduced the PH.HCL was coming on Plastic petin capacity. SO Liter. | 0.43 | RO Plant pump line replace by PPR with dressing work in house. Rochem.We have arrange the PVC Syntex tank Capacity 10,000 Ltr.for stock and arrange the HCL Tanker every three mortes and maintain the stock. And NO accident for handling | | | | | | t |
| 84 | ENGG UTILITY | K - ENGG UTILITY 06 | Rochem RO Feed Pump. GI Pipe was frequently rusted and leakage. | | Rochem RO Feed Pump. We make the PPR pipe and fitting on pump suction. This material is not existed and social the leakanes contains short rule. | | L | | | | t |
| 85 86 | ENGG UTILITY ENGG UTILITY | K - ENGG UTILITY 07 K - ENGG UTILITY 08 | In Air Compressor was not Air flow direction marked on pipe line Cleaning air pipe line hang with out support. | | . We have Air flow direction marked on pipe line in MII no.9 Blow Room . We have make the MS Clamp and fitting on Cleaning air pipe line. So, | F | F | F | H | Ē | f |
| 89 | DYE HOUSE DYE HOUSE | K - Dye House 02 K - Dye House 03 | Installed display board to show the meaning of colour code. | | servid the leakans from inishs Easy to indentify the chemical nature. | | | | Ħ | | ŧ |
| 20 | | K - Dye House 03 K-IT-02 | Using of measuring bucket, easy to take chemical by marking of fixed City, on bucket. Developed new report for difference between Salary Days & Attendance Days. | | easy to measure chemical and also save cost to take acurate Quantity. Its implemented and operational | \vdash | \vdash | F | H | | t |
| 92 93 | IT | K-IT-03 | Developed new report for Actual Working days details of workers | | Its implemented and operational | | | | | | |