

RSWM Kharigram - KAIZEN Summary Sheet for November 2016

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	Make Cleaning Gun charger stand.		Make Cleaning Gun charger stand avoid chances of accident & 5 s maintained.
2	SPG M1 - 3	K - SPGM1-3 02	Create more space in carding section mill no. -2		Create more space ,looking attractive, maintained good house keeping & 5s maintained.
3	SPG M1 - 3	K - SPGM1-3 03	Optimize the size of TPI sence gear in G5/1 R/f no. -1 of mill no. -2		Optimize the size of TPI sence gear & TPI sensed function activate like LR6S.
4	SPG M4-6	K - SPGM4-6 01	Make proper place for card can band strips in Mill no.4		Make a stand for hanging extra band strips and fix the area
5	SPG M4-6	K - SPGM4-6 02	Make a proper place for roller bonda in R/f Mill no.4		Make a Gi sheet box & fix the place for Roller bonda
6	SPG M4-6	K - SPGM4-6 03	Make a proper place & box for keeping plastic rings in Mill no.4		Make a box & fix the area for keeping S/f Rings.
7	SPG M4-6	K - SPGM4-6 04	Make a new rack for keeping s/f bobbins Mill no.6		Make new rack its 4 times capacity of keeping S/f bobbins
8	SPG M4-6	K - SPGM4-6 05	Make a new stirring tools for finish in Mill no.5		Make a new steering tools for finish .
9	SPG M4-6	K - SPGM4-6 06	Marking & identification of waste zone area in Mill no.6		Make identification & marking of waste zone area
10	SPG M9	K - SPG M9 01	BR L3 Broken Kota ston may lead an accident.		Kota ston changed.
11	SPG M9	K - SPG M9 02	Plaster wall not white wash.		White wash done.
12	SPG M9	K - SPG M9 03	Black contamination was falling from broken false ceiling .		False ceiling changed by new one.
13	SPG M9	K - SPG M9 04	Waste box hook was not available.		New hook welded.
14	SPG M9	K - SPG M9 05	Wall tiles gaurd was not available.		Wall tiles gaurd introduced.
15	SPG M9	K - SPG M9 06	Lock was open without key.		New modified lock introduced which is open by specific key only .
16	SPG M9	K - SPG M9 07	Broken wall tiles were looking bad.		Wall tiles changed by new .
17	SPG M9	K - SPG M9 08	Slub panel with out safety guard.		Put safety guard around panel .
18	SPG M9	K - SPG M9 09	Floor condition poor .		Floor repaired.
19	SPG M9	K - SPG M9 10	Safety panel rusty .		Put paint on safety guard.
20	SPG SJ11	K - SPG SJ11 01	Dust bin in B/R office was not fixed as per 5'S'		Now we fix dust bin by Yellow marking tape and maintain 5'S'
21	SPG SJ11	K - SPG SJ11 02	Initially name written in English in LED,		Now writing in Hindi for better understand to all
22	SPG SJ11	K - SPG SJ11 03	In carding north side there is no sign of zebra crossing		Now we made zebra crossing sign
23	SPG SJ11	K - SPG SJ11 04	Initially hazira fiber was running in both phase of department so chance of mix up high		Now balance machine KG by changing the sliver hank 0.085 Off 0.100
24	SPG SJ11	K - SPG SJ11 05	We observe that Rf cleaning machine late hand over (2:30 Pm - 3:00Pm) or after 3:00 pm, so department Effi Q go down	0.80	Now machine hand over time reduced to 2:00 pm to 2:30 pm,so Effi Q increases by.01 % per day
25	SPG SJ11	K - SPG SJ11 06	Found dirty wall in Jivanmitra office		After white wash found light which is reflatd from white wash wall
26	SPG SJ11	K - SPG SJ11 07	Found plant get dry in pots		Replace with new plant in pots
27	SPG SJ11	K - SPG SJ11 08	Initially only Cots and Clearer checked by sider during shift change.		Now we add spacer and aprons (top & Bottom) along with cots and clearer during shift change.
28	SPG SJ11	K - SPG SJ11 09	Initially operator check only machine Bottom and cots jam and Mention ok or not in charge register.		Now operator check also creel bobbin color and mention in charge register.
29	SPG SJ11	K - SPG SJ11 10	Bad looking during VIP round		We have repaired fall ceiling .
30	POST SPG M1-6	K - PS M1-6 01	Earlier the tension spring of PS Ch Wdg. In open mouth, the yarn is entangled with spring, after some time the springs are damaged.		To save the springs, we are closed / peste the both mouth of spring to avoid yarn entangle, and save the spring safe worn out.
31	POST SPG M1-6	K - PS M1-6 02	In TFO Section in courser count (3/6s,...)the knot / splice entengled in Treverce guide and yarn break		To avoid the Breaks we have instaled 3 MM Trevers guide for the same, and get Beter Quality of High PSS Material.
32	POST SPG M1-6	K - PS M1-6 03	In Mill no 6 conditioning Room Door was inside the Room, causing the steam / fog likages and door is jamm frequently by rust.		Door instaled out side from the conditioning Room for keeping optimum moisture.
33	POST SPG M1-6	K - PS M1-6 04	In SAVIO Autoconer workers are hank cone to up the idle drum, causing the Drum sencer sensor got damaged.		inspite of hank the cone, arrange a TEG in Red colour to issily identify the idle drum.
34	POST SPG M9	K - PSM9 01	In Packing M-9 Jung Dirty package Trolley		Now oil Paint in all package trollies due to avoid of dirty & damage cones.

35	POST SPG M9	K - PSM9 02	Over Head cleaning not proper due to damage pipe		Now change the over head pipe & nozzle for better cleaning of Auto Coner m/c
36	POST SPG SJ11	K - PSSJ11 01	In packing section wall damage.		Packing section wall repaired & white wash work completed.
37	POST SPG SJ11	K - PSSJ11 02	We have not check RF spindle in Linkconer.		Now we have start to check RF spindle in Linkconer by putting spindle no in full cops. if any spindle abnormal observed inform to Maintenance department & attend.
38	QAD M 1- 6	K - QAD M1-6 01	Dyes & Chemical testing without keeping any extra staff .	3.00	Executed
39	QAD M 1- 6	K - QAD M1-6 02	Customer Beekalene desired Brush pilling testing	0.13	Testing facility not available in India & from overseas testing , it was required to get tested from oversea which will cost Rs 13000/- was saved after discussing with marketing team .
40	QAD M 1- 6	K - QAD M1-6 03	Measuring vessel for Chemical / liquid .	0.18	Started using - Getting avoided engaged extra man for taking out sample from container .
41	QAD M 1- 6	K - QAD M1-6 04	Premier Tensomax problem (Data not transferring / m/c not operating)	0.15	Instrument was get attended by combined effort of Engg / IT Deptt.
42	QAD M 1- 6	K - QAD M1-6 05	Counter checking of Fibre GPD by other lab (From RCPF)		Got confirmed accuracy
43	QAD M 1- 6	K - QAD M1-6 06	Optimization of BLS / Badri PSF		For using in Coarser count to Ludhiana segment
44	QAD M 1- 6	K - QAD M1-6 07	Counter checking of GCV from different instrument of Adiabatic Calorimeter .		Got confirmed accuracy
45	QAD M 1- 6	K - QAD M1-6 08	Sample bag kept open in lab were started to keep in almirah .		Improved look
46	QAD M 1- 6	K - QAD M1-6 09	Air Conditioner's Stands were white washed		Improved look
47	QAD M 1- 6	K - QAD M1-6 10	Emergency gate having fire extingusher in it (U-1 R/F 15/16)		To avoid any problem in emergency - Attended
48	QAD M 1- 6	K - QAD M1-6 11	Loose wiring looking from outside in deshape from wall in U-4 QA Lab		Improved look
49	QAD M 1- 6	K - QAD M1-6 12	Loose wiring looking from outside in deshape from wall in U-1 QA Lab		Improved look
50	QAD M 1- 6	K - QAD M1-6 13	U-1 Autoconer emergency having fire extingusher near U-1 Autoconer no. 1	Not done	To avoid any problem in emergency - Pending
51	QAD M 1- 6	K - QAD M1-6 14	Loose switch of Classimat Testing m/c was set right .		Avoiding the scope of any sparking / loose fly sticking was attended .
52	QAD M 1- 6	K - QAD M1-6 15	Loose bottom plate of almirah from outside wa set right in proper way		Improved look
53	QAD M 1- 6	K - QAD M1-6 16	Apron were provided to operator working on regular testing equipments of lab		Improved look for working as professional
54	QAD M 1- 6	K - QAD M1-6 17	Zero Obj Classimat Faults made for M/s Bhaskar		1/10's PC achieved for M/s Bhaskar

55	QAD M 1- 6	K - QAD M1-6 18	Zero Obj Classimat Faults made for M/s Bhaskar		1/10's PV achieved for M/s Bhaskar
56	QAD SJ11 & M9	K - QAD SJ11 01	Prepare card samples of card no 11 & take corrective action against high IPI value of card no-11 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
57	QAD SJ11 & M9	K - QAD SJ11 02	Prepare card samples of card no 02 & take corrective action against high IPI value of card no-02 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
58	QAD SJ11 & M9	K - QAD SJ11 03	Prepare card samples of card no 05 & take corrective action against high IPI value of card no-05 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
59	QAD SJ11 & M9	K - QAD SJ11 04	Prepare card samples of card no 08 & take corrective action against high IPI value of card no-08 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
60	QAD SJ11 & M9	K - QAD SJ11 05	Prepare card samples of card no 09 & take corrective action against high IPI value of card no-09 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
61	QAD SJ11 & M9	K - QAD SJ11 06	Prepare card samples of card no 15 & take corrective action against high IPI value of card no-15 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
62	MAINT M1-3	K - MAINT M1-3 01	SLUB ATTACHMENT SSK 06 FROM MANDAPPAM SHAFT BROKEN		SHAFT WAS MADE IN HOUSE
63	MAINT M 4-6	K - MAINT M4-6 01	THERE WAS 4 HRS WELDER WORK AT THE CHANGING TIME OF WIRE MESH OF SUCTION FAN JALI.		WE MODIFIED THE SUCTION FAN JALI IN RF 11 IN MILL 4 AS NYLON MESH TYPE, AND SAVE 4 HRS OF WELDER.
64	MAINT M 4-6	K - MAINT M4-6 02	THERE WAS MATLIC BALOON CONTROLLER GUIDE IN MC , SO THERE WAS HAIRNESS PROBLEM.		WE MODIFIED THE BALOON CONTROLLER GUIDE AS CERAMIC TYPE AND HAIRNESS PROBLEM SOLVED IN PS CONE WINDING NO-2
65	MAINT M 9	K - MAINT M9 01	BACK ROLL SHAFT OF RING FRAME GET BROKEN .		DEVELOPED BACK ROLL SHAFT WITH OLD SHAFT IN WORK SHOP .
66	MAINT M 9	K - MAINT M9 02	CARD NO – 22 SHAFT OF SLIVER CUTTER BRACKET BROKEN .		OLD SHAFT OF SLIVER CUTTER BRACKET REPAIRED WITH JOINT OF ONE MORE PIN AND MACHINE STARTED .
67	MAINT SJ11	K - MAINT SJ11 01	Chance of cut sliver pass due to sliver guide hook		Modified the cover of card and remove the sliver guide and problem is solve out.
68	MAINT SJ11	K - MAINT SJ11 02	Due to heavy load of ring frame ring rail torsional spring is broken frequently.		Develop 16mm pin instead of 12mm and start using it and problem is completely solved and same is share with LMW and he had pass this
69	MAINT SJ11	K - MAINT SJ11 03	Drum Shaft Pillow intermediate bearing 6205 K is start wear out and OEM had refused to lubricate the bearing and no greasing point is provided by OEM		We had start open the pillow intermediate cover and make a device for lubricating the bearing
70	MAINT SJ11	K - MAINT SJ11 04	Splicer cover start broken and OEM supply the cover so much costly.	0.39	Develop the same cover in local market with the help of store person
71	ENGG M1-3	K- Engg M1-3-01	Nomenclature In E Lab	0	After Kaizen Nomenclature having all that places which having lab
72	ENGG M1-3	K- Engg M1-3-02	Slub Panel Safety guard	0	After kaizen Slub panel provide safety by railing
73	ENGG M4-6	K- Engg M4-6-01	No any Emergency lights available in the machine area if power fails		Now 3 nos. led tubes supply circuit given through lighting UPS & they will glow if power fails.
74	ENGG M4-6	K- Engg M4-6-02	The old FU inverter having problem due to ageing & not running at regulatory mode in the machine.		Installed New FU conversion purchased from O/E/M in house & machine running in regulatory mode now.
75	ENGG M4-6	K- Engg M4-6-03	Machine Inverter Failed & gone for repairing . So, machine running without inverter thus making less suction on coarser count running		Installed Substitute inverter which is running at required frequency therefore making desired suction. Also having low cost as compared to O/E/M

76	ENGG M9	K- Engg M9 -01	Carding Heating Lamp Installation		There was hanging heating lamp. We make modification in machine and provide attached heating lamp.
77	ENGG M9	K- Engg M9 -02	LR Ring Frame-24, Drive installation		There was require to run the o very low RPM for new kind of product. We provide inverter there for require speed.
78	ENGG M9	K- Engg M9 -03	PPW Ch. Winding Drive installtion		There was problem in OEM drive. We replace that drive with danfoss drive
79	ENGG M9	K- Engg M9 -04	21C Auto coner spindle cover		There was broken cover on 21C spindle. Procurment from OEM was very costly (3500/- 0er pice) We procure them from local market (550 /- per pice) 125 nos cover and replaced all damaged cover
80	ENGG M9	K- Engg M9 -05	Motor Lifting trolley		There was no motor lifting trolley in M-9 engg. Deppt. We procure them and provide to lift motor in time and safely.
81	ENGG M9	K- Engg M9 -06	Material tranport trolley		There was no material transport trolley in M-9 engg. Deppt. We arrange it from SJ11 and make our work easy.
82	ENGG M9	K- Engg M9 -07	Place identified for trolley		We identified to mark the place for trollys in power haouse
83	ENGG M9	K- Engg M9 -08	Plaace identified for Fire extinguisher cylinder		We identified the place for fire extigusher cylinder
84	ENGG M9	K- Engg M9 -09	KEY BOX installtion		There was no key box and regularly consume lot of time to identify the key. For that we placed key box with no. To identify the perticular key.
85	ENGG M9	K- Engg M9 -10	Switch Modification in tower		We provide the supply fan switch outside of tower to go inside by switching off the supply fan.
86	ENGG M9	K- Engg M9 -11	Store Room identification		We identified the store room by naming.
87	ENGG M9	K- Engg M9 -12	Dye House PDB panel Naming		We identify the dye house PDB panel by their naming
88	ENGG M9	K- Engg M9 -13	Dye House Machine Panel identification		We identified all dye house machine panel by their naming
89	ENGG M9	K- Engg M9 -14	Place Identification for battery charger		We identifiy the place for battery charger by their naming
90	ENGG M9	K- Engg M9 -15	Chinese Speed Frame panel naming		This panel is away from the machine. So there is requirement to identify the panel. We identify those panel by their naming.
91	ENGG SJ11	K - ENGGSJ11 01	Earlier EMS server PC was running in Engg Lab.		Shifted in the office of Engg HOD with Luwa Server PC under air conditioned environment to avoid server hang up problem.
92	ENGG SJ11	K - ENGGSJ11 02	OPEX performance was not displayed for motivation of workers.		An eye catching OPEX performance display board has been placed at south phase power house.
93	ENGG SJ11	K - ENGGSJ11 03	Palletizer Energy chain was broken due to cone falling from unloaders in packing deptt.		Fixed an acralic sheet to prevent the cone falling on palletizer track which will reduce the electrical B/D.
94	ENGG SJ11	K - ENGGSJ11 04	We were not having identified record room to keep the documents to be retain with us.		Identified the record room in north phase office block and shifted all the records there.
95	ENGG SJ11	K - ENGGSJ11 05	OEM supplied Pinter Power Spin 12VDC Relay was direct mounted on PCB which took time to replace in case of failure and PCB might be damaged.		We have fixed relay with base which will reduce the down time.
96	ENGG SJ11	K - ENGGSJ11 06	Ventilation was open in Utility store room from where birds entered.		To avoid birds entry in utility store room, we have fixed a JALI using 1" wire mesh.
97	ENGG SJ11	K - ENGGSJ11 07	Petrol, diesel & lubricants were kept in same color cans which might cause mis handling.		We have placed color wise cans for petrol, diesel and lubricants.
98	ENGG SJ11	K - ENGGSJ11 08	Electrical safety awareness display was not available in plant.		We have fixed posters of Electrical safety instructions in all departments and power house.
99	ENGG UTILITY	K - ENGG UTILITY 01	We have use the wet opener lattice type So, We are cleaning the machine 3 times in each 8 hours.		After Kaizen We have cut old peace of lattice and fix a new peace with re-alignment . After that the machine is working properly. And increase the
100	ENGG UTILITY	K - ENGG UTILITY 02	There is no safety guard on in Steam Dryer New panel.		After Kaizen we have fabricated a new safety guard and put it on panel for safety purpose.
101	ENGG UTILITY	K - ENGG UTILITY 03	There is no safety guard on Main panel.		After Kaizen we have fabricated a new safety guard and fix it on main panel for safety purpose.
102	ENGG UTILITY	K - ENGG UTILITY 04	There is no safety guard on Steam Dryer machine.		After Kaizen we have fabricated a new plate & safety guard and fix it on machine for safety purpose.

103	ENGG UTILITY	K - ENGG UTILITY 05	There is no safety Cover on motor IN Dyeing M/C		After Kaizen we have fabricated a new safety Cover and fix it on Motor for safety purpose.
104	ENGG UTILITY	K - ENGG UTILITY 06	Mill no-6 there is no clip on the pipeline for safety purpose.		After Kaizen in Mill no-6 we have fix clip on the safety purpose and maintaining the 5S.
105	ENGG UTILITY	K - ENGG UTILITY 07	There is no safety plate on steam drain point..		After Kaizen in Dye house we have fabricated a new Plate and fix it on Steam Drain point.
106	ENGG UTILITY	K - ENGG UTILITY 08	Mill no-6 there is no clip on the pipeline for safety purpose		After Kaizen in Mill no-6 we have fix clip on the safety purpose and maintaining the 5S.
107	ENGG UTILITY	K - ENGG UTILITY 09	ETP there is M.S. pipe line for chemical tank water & in this tank we was using Fresh water from Hyper.	1.18	After Kaizen we have fabricated a new pipe line of PPR for chemical tank & we are using the Permeate water of ETP And saving the fresh water of Hyper.
108	DYE HOUSE	K - Dye House 01	Cross ventilation in Dye -Hpuse		Cross ventilation in dyehouse will facilitate comfortable working ennvoinment during summer season
109	DYE HOUSE	K - Dye House 02	Old ladder of dyeing platform replaced & fabricated systemetically		New ladder will facilitate not only smooth& easy ridding but also ensure safety of labour while carrng chemicals
110	NPD	K - NPD - 01	Wooden rack has been provided with proper height for placing the wrap reel at Pilot Plant.		Earlier Wrap Wreel height is lower due to which worker face the problem during wrapping of roving or sliver. Now wrap reel is palced on compartable height.
111	NPD	K - NPD - 02	Wooden rack has designed and made for keeping the workers lunch boxes.		Earlier lunch boxes are either keep on floor or on machine. Now proper place has defined for keeping the lunch boxes. Maintaain the housekeeping and hygeine
112	NPD	K - NPD - 03	Sample Swatch has punched on the party letter along with the standard provided by the customer.		When customer gives the comment on the lab dip sample then we have to search the sample. After punching the sample on party letter, searching time of sample is Nil.
113	NPD	K - NPD - 04	Record of the Sample cones has made and maintain systematically to reduce the searching time.		Searching time has reduced and delivery of the samples has improved.
114	NPD	K - NPD - 05	Only 100 gram sample cone has kept for making the yarn strips while earlier big size samples are kept for making the yarn strips.		Save the space and time for searching the sample.
115	NPD	K - NPD - 06	Wooden loom has discarded by arrangment of making all fabric samples on the power shuttle loom.		Save the space at Pilot Plant.
116	NPD	K - NPD - 07	Machine no. are marked on all machines at Pilot Plant.		Ealier machine no. are not there at Pilot Plant machines so difficult to idenfiy the machines.
117	NPD	K - NPD - 08	Cleaning of the door curtains are not regular due to which these are found dirty most of the time. Now cleaning schedule of the door curtains has made for proper cleaning of the door curtains.		Now regularly cleaning of the door curtain has maintained.
118	NPD	K - NPD - 09	Wooden rach has mounted on the walls to save the space.		Earlier wooden racks are placed on the fllow which occupy the floor space. Now installed the rack on the wall.
119	NPD	K - NPD - 10	Loose fiber has kept in the cartoon with proper marking at Pilot Plant		Improve the housekeeping and maintain the 5S
120	NPD	K - NPD - 11	NPD Slub attachment has given for bulk production by doing the proper planning of the sampling.		Delivery of the Slub Yarn on time for bulk production without affecting the samples deliveries.
121	Store & Purchase	K - Store - 01	Purchase order attached in IDM & Share Folder	0.23	Stop day to day print out sending to accounts Now we have attached the same in IDM and Sharing folder and time to time copy the sharing folder copy to account
122	HRD & Training	K - HRD - 01	To make new policy boards. From head office		We have made it from our local vendor .
123	HRD & Training	K - HRD - 02	Training up gradation		Trainers started teaching through projector.it is easy to communicate through audio &video presentation.
124	IT	K-IT-01	Workers Hostel Coupon records maintained in Excel and it will take time and person dependent		Defined input parameters and developed new report Workers Hostel coupon information
Total Annualized Amount				6.06	