

RSWM Kharigram - KAIZEN Summary Sheet for October 2016

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	K - SPGM1-3 01	Old curtain chandedby new one modified curtain		Old curtain changed by new one & got improved quality
2	SPG M4-6	K - SPGM4-6 01	Identification of Mixing Board area in Mill no.5		Identifications of mixing board area looking attractive and 5 S maintained.
3	SPG M4-6	K - SPGM4-6 02	Identification of Lap stand area in B/r in Mill no.5		Identification of Lap stand area ,Looking attractive and 5S maintained.
4	SPG M4-6	K - SPGM4-6 03	Identification of mixing water tap area in Mill no.5		Make identification Looking attractive and 5S maintained.
5	SPG M9	K - SPG M9 01	Blowroom-Issued mixing area covered by motots in BR L3		Motors shifted
6	SPG M9	K - SPG M9 02	CF-Broken jali creating problem in can transportation		Jali repaired
7	SPG M9	K - SPG M9 03	Blowrrom-Hole wall near TOT1 of L1		Wall hole cemented
8	SPG M9	K - SPG M9 04	CF 27-32 Dirty fly accumulated in pressure point pits		Pits covered
9	SPG M9	K - SPG M9 05	CF-Wall broken between CFno.10 & 25		Wall repaired
10	SPG M9	K - SPG M9 06	CF Condensed water was coming with steam through pipe		Pipe insulated
11	SPG M9	K - SPG M9 07	RF 9A-Wall tiles broken		Replaced by new tiles
12	SPG M9	K - SPG M9 08	RF 9A- motor foundation broken		Foundation repaired
13	SPG M9	K - SPG M9 09	RF 9B -Floor got broken near VIP alley		Floor repaired
14	SPG M9	K - SPG M9 10	CF-Near CF 3 PP curtain hanging problem due to waste pipe		Pipe removed
15	SPG SJ11	K - SPG SJ11 01	We observed yellow mark area shortage for storage of DF cans		Yellow mark area extended and maintained 5 'S
16	SPG SJ11	K - SPG SJ11 02	We observed kota stone sheet broken in north utility area stairs		Now replaced kota stone by new sheet
17	SPG SJ11	K - SPG SJ11 03	RF Bobbin room 5 'S' system not maintained properly due to shortage of bobbin rack		Now we made patrician in two racks and maintain 5 'S
18	SPG SJ11	K - SPG SJ11 04	We observe there was no spindle number on RF 36 (Spd no 438 to 648) ,due to which we were facing difficulty to identify faulty spindle.		We put spindle number on RF 36(spd no 438-648)
19	SPG SJ11	K - SPG SJ11 05	We observe pillar corners was broken repeatedly due to movement of trolley.		Now we install pillar corner guard to avoid such type of repeated problem.
20	POST SPG M1-6	K - PS M1-6 01	Earlier we are using wooden Pallets in condition Room for conditioning. Such pallets are damaged after some time.Have to procure Plastic Pallets to		Have to procured Plastic Pallets to avoid the loss.
21	POST SPG M1-6	K - PS M1-6 02	In Cimco cone wdg EYC Gauge are not in working position since Long time. Hance Chances of passing Gucha / Bunchese.		To avoid the Bunches from cone wdg arrnge Macheanical Gauge to minimised the complaints.
22	POST SPG M9	K - PSM9 01	Place fixed for keeping drinking water in packing deptt.		Place fixed for keeping drinking water in packing deptt.
23	POST SPG M9	K - PSM9 02	Sieger trolley capacity increased for more material conditioning in one cycle		Now capacity of trolley increased with new trolleys 102 cone / trolley . 308 kgs / cycle capacity increased of YCP.
24	POST SPG M9	K - PSM9 03	Place fixed for keeping bag packing trolley		Place fixed for keeping bag packing trolley
25	QAD M 1- 6	K - QAD M1-6 01	Lea holder upper jaw broken of Cascade Wrapping Instrument .	At least Rs. 15000 /-	It was managed to normal working by developing inhouse the new alternately . It is working fine with no problem .
26	QAD M 1- 6	K - QAD M1-6 02	2/9.8's Poly For IKEA - Drums taking more time in stopping after breakage at Versa Cheese winding were identified & get attended .		It will support in restricting excess length variation for length measured yarn as well as finally reduced remnant .
27	QAD M 1- 6	K - QAD M1-6 03	Improved Co-efficient of Friction - Use of wax roll having friction Co-efficient less than 0.10		Winding deptt will place order for the wax roll having friction co-efficient less than 0.10 & wax take up 0.12 +/-0.02 . Final impact on yarn - Reduced hairiness / reduced scope of fibre ball generation
28	QAD M 1- 6	K - QAD M1-6 04	Use of Cone disc in too sensative qualities in which remnant left over in warping due to collapsing at bottom .		It will control excess breakage at bottom in last section of warping as well as in reduced remnant level .

29	QAD M 1- 6	K - QAD M1-6 05	Standard Operating procedure for Dyes Testing was made & circulated to concerned deptt..		It will support in getting consistency as well as identifying the inferior quality / deterioration .
30	QAD M 1- 6	K - QAD M1-6 06	Use of splices yarn at cheese wdg stage for IKEA - 2/9.8's Poly for weft use .		Okayed by BSL - IKEA Unit
31	QAD M 1- 6	K - QAD M1-6 07	Monitoring of drum stoppage taken time after breakage.		Drum taken time more than normal i.e. 20 seconds were attended which will support in controlling remnants .
32	QAD M 1- 6	K - QAD M1-6 08	Started taking suppliers test report for received supplies of dyes .		It will support in getting trend as well as any deviation in supplies at suppliers end .
33	QAD M 1- 6	K - QAD M1-6 09	Chemical tesing of LV-40 was started inhouse .		It will support in getting exceptional findings in supplies , if any .
34	QAD M 1- 6	K - QAD M1-6 10	Testing of Pet Coke was started inhouse with repaired / calibrated instrument .		It will support in testing accuracy .
35	QAD M 1- 6	K - QAD M1-6 11	Dyes tesing was started inhouse .		It will support in testing dyes accuracy during use in bulk & consistency in bulk use between batch to batch .
36	QAD M 1- 6	K - QAD M1-6 12	Checking of B-Grade A/Coner's by QA strengthened to get attended identified abnormalites with best efforts .		It will support in restricting the exceptional abnormal passing in final yarn .
37	QAD M 1- 6	K - QAD M1-6 13	Water pipe in centre of emergency exit gate of Blow Room Section Mill no. 1		Emergency exit gate was shifted to another place for safe exit passage .
38	QAD M 1- 6	K - QAD M1-6 14	Standard Operating procedure for Chemical Testing was made & circulated to concerned deptt..		It will support in getting consistency as well as identifying the inferior quality / deterioration .
39	QAD M 1- 6	K - QAD M1-6 15	Standard Operating procedure for Pet Coke Testing was made & circulated to concerned deptt..		It will support in getting consistency as well as identifying the inferior quality / deterioration .
40	QAD M 1- 6	K - QAD M1-6 16	Waxing of package by injecting liquid wax through syringe in critical sensitive quality for avoiding holes / breakage at final end use .		Performance under observation
41	QAD SJ11 & M9	K - QAD SJ11 01	Identification display mention at the place of glass rod.	-	Looks attractive & Follow 5s System.
42	QAD SJ11 & M9	K - QAD SJ11 02	Prepare Quality check list for yarn godown & start yarn godown checking of Unit SJ-11	-	Quality Improvement & reduce customer complaints like transit damage, cut cones , damage cones , etc also housekeeping improvement .
43	QAD SJ11 & M9	K - QAD SJ11 03	Work Instruction board show in front of QAD- 9 Instruments.	-	Follow 5s System.
44	QAD SJ11 & M9	K - QAD SJ11 04	Replace normal lights from LED Lights in QAD-9.	-	Looks attractive. Use good quality of lights use in place of normal light & Power Saving.
45	QAD SJ11 & M9	K - QAD SJ11 05	Almirah Index show inside door for easy file searching in QAD-9.	-	Follow 5s System.
46	QAD SJ11 & M9	K - QAD SJ11 06	Identification insert for Untested / Uncheck & Tested / check material area.	-	Follow 5s System.
47	QAD SJ11 & M9	K - QAD SJ11 07	Prepare Quality check list for yarn godown & start yarn godown checking of Unit - 9	-	Quality Improvement & reduce customer complaints like transit damage, cut cones , damage cones , etc also housekeeping improvement .
48	MAINT M1-3	K - MAINT M1-3 01	THERE WAS AIR PRESSURE LEAKAGE IN AUTOCONER MILL NO 1-3 AVG CFM WAS 754.6		AFTER ATTENDING LEAKAGES AVG CFM BECAME 558.76 AND THERE IS A SAVING OF 195.84 CFM (AVERAGE)
49	MAINT M1-3	K - MAINT M1-3 02	THERE WAS A PLASTIC MOUNTED DROPPER WIRE IN TFO WHICH BREAKS		DROPPER WIRE WELDED DONE AND AFTER IT IS USED AGAIN.

50	MAINT M 9	K - MAINT M9 01	Licker-in , Feed Roll Stand , Opening Roll was kept on floor , which causes chances of accident .		On wall developed Vertical Stand for Licker-in , Feed Roll , Opening Roll .
51	MAINT M 9	K - MAINT M9 02	No display board in department so more time was required to find out running fitter .		In house developed Display Board in Department for Running fitter . Every one should know position of Running fitter which reduce time to find him .
52	MAINT SJ11	K - MAINT SJ11 01	IN TOW CUTTER THERE IS NO POSSIBILITY PROVIDE TO CUT SLIVER IN 4MM LENGTH.		In house modification done by changing its DRIVE GEAR / GEAR COMBINATION / BRACKET / CHAIN. Now, m/c running successfully to cut 4mm length Fiber for NPD products.
53	MAINT SJ11	K - MAINT SJ11 02	Due to laod on Intermidate shaft bearing 6205 failure issue in DF LD2.		Using 3205 bearing instead of 6205, Life of bearing increased & breakdown reduced.
54	MAINT SJ11	K - MAINT SJ11 03	IN RF PRESUURE PANNEL EXTRA MATERIAL LIKE PIECING BAG,BOBBIN,GRIPPER I AND DOOR IS ALWAYS OPEN DUE TO THIS CHANCE OF ACCIDENT IS HIGH.		DOOR IS COMPLETELY LOCK WITH THE HELP OF PLATE AND BOLT .
55	MAINT SJ11	K - MAINT SJ11 04	CHEESE WDG EMPTY CHEESE HOLDING STOPPER WORN OUT.		WITHOUT PROCURING OF NEW STOPPER WE ARE USING BROKEN LINK CONER CADDY AS A STOPPER
56	ENGG M1-3	K- Engg M1-3-01	Chequer plate in LT Room		After Kaizen we installed chequer plate in LT room
57	ENGG M1-3	K- Engg M1-3-02	Scrap box Used For waste bin		After kaizen scrap material lying Scrap Box which is received from Skaat Slub
58	ENGG M1-3	K- Engg M1-3-03	Cable Dressing In H-plant Trench		After kaizen Cable lying properly and doing dressing by cable tray
59	ENGG M1-3	K- Engg M1-3-04	Bearing puller for brushless motor		After kaizen Bearing change due to modified puller
60	ENGG M4-6	K- Engg M4-6-01	Machine flash card having low memory which create Informator hanging.		Replaced by 1GB & purchased from local market. Programmed here & installed in 5 machines. Now no such hanging observed
61	ENGG M4-6	K- Engg M4-6-02	Slub motion setting display keypad enter key not working . Unable to change settings & spare unit not matching with PLC.		Installed one push switch for enter & now settings could be changed.
62	ENGG M4-6	K- Engg M4-6-03	machine display unit not working & obsolete declared.		Conversion done in-house which is provided by O/E/M as substitute.
63	ENGG M4-6	K- Engg M4-6-04	Bobbin sensor needs replacement to install fix type feeler in Savio Auto Coner because sensor location is differ so length is short of cable.		Recently removed damage package sensor cable used & soldered to extend length for the sensor of bobbin change.
64	ENGG M9	K- Engg M9 -01	Dilectric paint insulation in power house		Previously there was insulating mat, we replaced with highly resistive insulation paint.
65	ENGG M9	K- Engg M9 -02	Switch provide for checking light in TFO		There was no switch and directly switching with khata klight
66	ENGG M9	K- Engg M9 -03	Partition wall in Chinese ring frame PDB room.		There was no partition for that PDB room due to witch lot of fly accumulating there and drive tripping frequently.
67	ENGG M9	K- Engg M9 -04	Drive installation on Line-1 GBC for inclind latics.		That latics were directly driven by contactor supply due to that jerk was coming on that drive motor. Now working properly.
68	ENGG M9	K- Engg M9 -05	Limit switch replaced with sensor on TD-03 for door safty.		There is frequent failure of limit switch, we replaced it with sensor.
69	ENGG M9	K- Engg M9 -06	Creal sensor provide modificaton in Chinese D/F		There was Chinese OEM sensor in D/F we explre its alternate in local market and insataaled.
70	ENGG M9	K- Engg M9 -07	Cable shiftin in dye house dryer section		There was unproperly cable laying, we make it proper.
71	ENGG M9	K- Engg M9 -08	Main PDB reolacement in Dye house		There was very old, bulky and damaged main PDB. We replced it with removed and unused PDB and make every thing proper
72	ENGG SJ11	K - ENGGSJ11 01	Costing of Autoflow Lifting table Hydraulic Cyendor as per OEM is Rs. 70000.00	0.41	We explore from indian market with help of Purchase Deptt. & found same specification Hydraulic Cyendor, Cyendor cost is Rs. thus saved Rs. 28625.00
73	ENGG SJ11	K - ENGGSJ11 02	In LT Room, observe marking not done for Pinter UPS & Trolley		We have done marking for UPS & trolley.
74	ENGG SJ11	K - ENGGSJ11 03	There is chance of Electric shock in Packing fork lift Charger.		To avoid electric shock, we made a wooden plate for charger stand.

75	ENGG SJ11	K - ENGGSJ11 04	To avoids bird in compressor area.		To avoid birds in compressor area we made inhouse sliding door using 1" wire mesh.
76	ENGG SJ11	K - ENGGSJ11 05	To avoids bird in compressor area.		To avoid birds in compressor area we made inhouse door using 1" wire mesh.
77	ENGG SJ11	K - ENGGSJ11 06	BTS control voltage missing fault due to emergency circuit was taken more time.		We have installed seprate indication for emergency switch on Main control panel to identify faulty emergency switch which will reduce down time.
78	ENGG SJ11	K - ENGGSJ11 07	Pinter T-Box Heating problem due to Minimum space between RF Panel & T-box Body due to failure of T-box.		To reduce temp., we use a Spacer between T-box & RF Panel.
79	ENGG UTILITY	K - ENGG UTILITY 01	Before Kaizen in mill no-9 There is no safety cover.		After Kaizen in mill no-9 We have fabricated a new cover and fix on it.
80	ENGG UTILITY	K - ENGG UTILITY 02	Before Kaizen in sizer m/c of mill no-9B there is no safety guard on Gear motor		After Kaizen in sizer m/c of mill no-9B we have fabricated a new safety guard and put on gear motor for safety purpose.
81	ENGG UTILITY	K - ENGG UTILITY 03	In sizer m/c of mill no-9A There is no safety guard on vacuum pump.		In sizer m/c of mill no-9A we have fabricated a new safety guard and fix it on vacuum pump for safety purpose
82	ENGG UTILITY	K - ENGG UTILITY 04	In Mill no-1 there is no safety guard on kirchi machine.		In Mill no-1 we have fabricated a new safety guard and fix it on kirchi machine for safety purpose.
83	ENGG UTILITY	K - ENGG UTILITY 05	fix a new open pipe line on ETP.		we have fix a new open pipe line on 12FT height. Now the pipe line is properly working on ETP
84	ENGG UTILITY	K - ENGG UTILITY 06	Fabricated a new cover of sensor		In Mill no- 9B on D/F machine we have Fix a new cover of sensor which is fabricated by M.S. Plate. .
85	ENGG UTILITY	K - ENGG UTILITY 07	Fabricated a new Plate Form in Dye-House		In Dye house we have fabricated a new Plate Form & leader. For safety purpose.
86	ENGG UTILITY	K - ENGG UTILITY 08	Fabricated a new cover for pressure gauge meter		We have fabricated a new cover for pressure gauge mater. Its give the safety to the meter
87	ENGG UTILITY	K - ENGG UTILITY 09	Fabricated a new cover of Auto pressure switch		We have fabricated a new cover of Auto pressure switch in dyeing machine and fix it on auto pressure switch for safety purpose.
88	ENGG UTILITY	K - ENGG UTILITY 10	Fabricated a new Realign		We have fabricated a new Realign in the way of dye house work shop.
89	DYE HOUSE	K - Dye House 01	Use of safety angels for corners of piller /walls to protect from damage due to trolly		To protect corners of walls by fixing safety angels to avoid damage due to hammering by trolles during transport & thus avoid frequent civil repairing work
90	DYE HOUSE	K - Dye House 02	Use of safety covers for m/c motor at dye house to protect from fibre entrap		Safety covers on motor will protect from fibre fly & water to entrap into ,thus it also increase motors life.
91	NPD	K - NPD - 01	Material transer duct at Opener got dirty and more time is consumed to clean the duct.		Polyethene sheet has tided on the duct and replaced with new polyethene when it get dirty
92	IT	K-IT-01	Yarn godown having 4 nos of ARGOX make scanner, that is not working on New M3 Printed content labels, that needs to replace these scanners with new scanners, PR placed for new Scanners also	1.85	We have taken the project study it and increase the barcode size on labls, this modification works and now all barcode scanner able to scan this new barcode, It saved cost of four scanners (35000 x 4 = Rs 140000)and new scanners purchased same make cheaper then Datalogic @15000 x 3 = Rs 45000 /- Total Saving = 1,85,000 /-
93	P&IR	P&IR 01			
94	P&IR	P&IR 02			
95	P&IR	P&IR 03			
96	P&IR	P&IR 04			
97	Guest House	GH 01			
Total Annulized Amount				2.26	