

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

S.N	Department	Kaizen No.	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M4-6	K - SPGM4-6 01	Extra MS sheet adding on can changer area of D/f no. -5 of Mill no. -4.		Extra MS sheet adding on can changer area .Can falling incidents reduced.
2	SPG M4-6	K - SPGM4-6 02	PVC strips curtain hanged on preparatory gate of Mill no.4		PVC strips curtain hanged on preparatory gate of mill no. -4 Contamination and air current problem reduced.
3	SPG M9	K - SPG M9 01	Space covered by transformer in BR L3		Transformer shifted
4	SPG M9	K - SPG M9 02	Return air trench Jali broked		Jali repaired
5	SPG M9	K - SPG M9 03	Boiler water was coming from broken wall		Wall hole cemented
6	SPG M9	K - SPG M9 04	Alley blocked by RF bobbin box		RF bobbin box kept between door
7	SPG M9	K - SPG M9 05	MS Sheet partition inclined between 9B RF & Autoconer		Partition alignment corrected
8	SPG M9	K - SPG M9 06	Broken wall		Wall repaired
9	SPG SJ11	K - SPG SJ11 01	We observed there was no any dust bin in BR office		We place dust bin in BR office and maintain 5'S'
10	SPG SJ11	K - SPG SJ11 02	Dust bin in staff canteen was not fixed as per 5'S'		Now we fix dust bin by Yellow marking tape and maintain 5'S'
11	SPG SJ11	K - SPG SJ11 03	We have observed some Can spring loose, causing bad coiling can produce.		Can spring repaired. Now coiling ok
12	SPG SJ11	K - SPG SJ11 04	We observed in VIP alley ,between SF 5 & 6 fall ceiling damage very badly. It may causes an accident		We have repaired fall ceiling .
13	SPG SJ11	K - SPG SJ11 05	SF 6 was running on 0.90P and SF-10 was running on 0.60P,So unclean trains for SF 6 from RF was moving through longer rout causing RTS was bussy all the time and some time SF detained under BTS.		Now we interchnage hank of both SF i.e SF is now working on 0.60P and SF-10 is working 0.90P,Now unclean trains for SF-6 from RF is moving through shortcut route
14	POST SPG M1-6	K - PS M1-6 01	Very tight movement of A/C Troli, Always running very hard.		Arrange the Rail from scrap, like AC x5 auto coner, NOW RUNNING SMOOTHLY
15	POST SPG M1-6	K - PS M1-6 02	The cones are damaged by rough surface , facing cut cone problem due to same,		Fixed REXINE Cover to avoid the cut / damaged cones
16	POST SPG M9	K - PSM9 01	Removing of hamming stich & box type stich in all type HDPE bags which adds to extra cost of Rs. 2 / bags , with maintaining same quality of packing of material	2.90	quality of packing is ok & saved Rs. 2 / bags in domestic packing
17	POST SPG M9	K - PSM9 02	Three ply carton used in domestic packing in place of Five ply . Cost saving Rs. 7.50 / carton	0.90	Packing quality is ok , not any problem observed
18	POST SPG M9	K - PSM9 03	Safety guard fixed beside Sieger m/c of M9A		Safety provided to man , material & machine also.
19	POST SPG M9	K - PSM9 04	Safety guard fixed infront of Sieger m/c plateform of M9B		Safety provided to man , material & machine also.
20	POST SPG SJ11	K - PS SJ11 01	In packing Emergency window not as per norms.		In packing section Emergency window as per norms.
21	QAD M 1- 6	K - QAD M1-6 01	Key board of UT-3 got out of order and owing to too old model , AMC by Uster has been stopped since past years due to non availability of spares , search out trial & error subtitude and arranged solution from local source and instrument was get in running Okay .	0.54	Initial cost of Key board with adaptor in use was Rs. 90000 / - where as it has been replaced by key board of Rs. 36000 / - only
22	QAD M 1- 6	K - QAD M1-6 02	Loose wiring was kept covered		To avoid un safe working condition
23	QAD M 1- 6	K - QAD M1-6 03	Removal of water tape which is not in use .		To avoid un safe working condition
24	QAD M 1- 6	K - QAD M1-6 04	Increase specific checking of B-Grade A/Coner's .		To restrict the scope of abnormal passing in final yarn .
25	QAD M 1- 6	K - QAD M1-6 05	Classimat testing of new lot started in process on priority .		To optimize EYC setting / avoid abnormal passing of faults in significant quantity .
26	QAD M 1- 6	K - QAD M1-6 06	Optimization of remanant status in IKEA product based optimization of length measurement .		To reduce remanant status .
27	QAD M 1- 6	K - QAD M1-6 07	Specific audit of B-Grade identified A/Coner's for working as final yarn .		For arresting the scope of abnormal passing in final yarn .

28	QAD M 1- 6	K - QAD M1-6 08	Cone supplier's visit for discussing the improvement scope in future supplies .		For getting improved quality in future supplies .
29	QAD M 1- 6	K - QAD M1-6 09	Seperate Classimat record of were maintained for sensitive customer / sensitive products .		Easily for comparative trend & analysis .
30	QAD M 1- 6	K - QAD M1-6 10	Presentation of bad work practices covered from for CCTV footage / running in process .		It will support in well recognition & faster improvement .
31	QAD M 1- 6	K - QAD M1-6 11	Frequency of splice checking for sensitive customer increased .		Support in enhanced consistency by arresting low splice strength drums .
32	QAD M 1- 6	K - QAD M1-6 12	Old Ring traveller collected in R/F deptt.		To avoid neepy yarn bobbin / Hairiness problem due to old Ring / Traveller used . At the time of Ring traveller change collect all old ring traveller with the help Spg concern / deptt. and counting the same .
33	QAD M 1- 6	K - QAD M1-6 13	Keeping loose material un covered i.e. Sliver cans / roving bobbins trolleys material for maintaining covered .		Daily basis check process at all stage & ensure to keep material cover in U-6 to avoid contamination passing / customer complaint .
34	QAD SJ11 & M9	K - QAD SJ11 01	Trial Study of Scanning Roll 7.0 mm VS After Change the Scanning Roll 9.0mm off 7.0mm. In TD03 Draw frame.		Improvement in yarn quality.
35	QAD SJ11 & M9	K - QAD SJ11 02	Trial Study of Unimix No-1 Beater Speed =630 rpm, MBO No 2 Beater speed 630 off 450 rpm.		Improvement in yarn quality.
36	QAD SJ11 & M9	K - QAD SJ11 03	mark printed number inside wrapping tea box for clearly show machine no during wrapping put machine wise lea.		Looks atrective & Follow 5s System.
37	QAD SJ11 & M9	K - QAD SJ11 04	Trial Study of Card No - 04 After change Flat Speed 320 mmpm off 272 mmpm		Improvement in yarn quality.
38	QAD SJ11 & M9	K - QAD SJ11 05	Trial Study of comparison of card LC333 Vs LC361 with Hazira Poly and speed 180 MPM		Improvement in yarn quality.
39	QAD SJ11 & M9	K - QAD SJ11 06	Trial Study of Unimix -1 Beater Speed =1000 rpm V/S Unimix Beater 1 Speed =630 rpm		Improvement in yarn quality.
40	MAINT M1-3	K - MAINT M1-3 01	THERE WAS A FREQUENT WEAR OUT OF STUD WITH 176 T GE AR IN NMM DOUBLING		WE HAVE CUT BEARING SHEET AND PUT 6203 BEARING TO REDUC E WEAR OUT OF STUD IN NMM DOUBLING.
41	MAINT M4-6	K - MAINT M4-6 01	THERE WAS AIR PRESSURE LEAKAGE SAVIO AUTO CONERS IN MAIN VALVE UNIT .	0.25	WE REPLACED THE OLD TYPE NOZZEL AND PUT A THREADING TYPE SCREWD JOINT WITH THREAD MAKE IN VALVES PLASTIC BODY NOW PROBLEM HAS BEEN SOLVED.D SAVED RS-25000/
42	MAINT M4-6	K - MAINT M4-6 02	THERE WAS AIR PRESSURE LEAKAGE SCHILAFHORTHHERE WAS A PRESSURE LEAKAGE IN SOLONOIDE VALVE DUE TO HARDNESS OF PLASTIC PIPE ST AUTO CONERS IN MAIN VALVE UNIT .	0.45	WE PUT CONNECTOR AND PU TUBE IN PLACE OF VALVE REPLACEMENT AND SAVED RS-(15000*3 )=45000/
43	MAINT M 9	K - MAINT M9 01	Pnuemafile Chamber Cover of Jingwei R/F is of Plastic material and get broken frequently .		Pnuemafile Chamber Cover of Jingwei R/F is made GI Sheet material .
44	MAINT M 9	K - MAINT M9 02	Display Board in Maintenance Room not proper .		Display Board in Maintenance Room is made with wooden board and Green cloth is fixed on it .
45	MAINT SJ11	K - MAINT SJ11 01	MOUTH PIECE SUPPLIED BY OEM HAVING FREQUENTLY PIPE CHOCK PROBLEM		AFTER CHANGING THE MOUTH PIECE DESIGN NOW MOUTH PIECE CHOCKING PROBLEM IS SOLVED
46	MAINT SJ11	K - MAINT SJ11 02	GREASE WAS NOT GOING INSIDE BEARING OF SF DOFFER.		AFTER CHANGING THE DESIGN OF GREASE NIPPLE, GREASE IS GOING IN BEARING SO LIFE OF BEARING IS INCREASED
47	MAINT SJ11	K - MAINT SJ11 03	SEPARATOR CHANGING WAS TOO MUCH TIME CONSUMING AT R/F.		WE PURCHASED ON COMPLETE SET OF SEPARATOR BAR & NOW WE COMPLETE THE SET BEFORE CHANGING IT IN M/C. & SAVING
48	MAINT SJ11	K - MAINT SJ11 04	DUE TO FALL DOWN OF CONE FROM CONE HOLDER CONE, PUSHER CYLINDER ROD GOT BEND.		WE FITTED A PROTECTION PLATE ON THE HEAD OF AIR CYLINDER, AFTER THIS PROBLEM OF ROD BEND GOT SOLVED
49	ENGG M1-3	K- Engg M1-3-01	Carding C1/3 chance of fire accident		After Modification 24V ac supply given
50	ENGG M1-3	K- Engg M1-3-02	No safety of led tv		After Kaizen Safety cover installed

51	ENGG M4-6	K- Engg M4-6-01	The tube conveyor belt of the machine is having no monitoring of running in elevated belt before . So, due to this when jamm occurs motor gear box problem faced out many times.		Now installed the sensor for running monitoring which will cut off motor contactor at jamm condition.
52	ENGG M4-6	K- Engg M4-6-02	The machine is having tower light with three different colour bulbs		Replaced with dome light of all three colours in one dome.
53	ENGG M4-6	K- Engg M4-6-03	OHTC of machine is stopping again & again. PCB of the same repaired many times but malfunctioning		Replaced with PLC Based Panel which is also having current monitoring protection of both traverse & blower motor.
54	ENGG M4-6	K- Engg M4-6-04	The roller motor is running while no cartoon to run on it.		Modified the control of motor by installing one photo electric sensor which will control motor & it will not run unnecessarily
55	ENGG M4-6	K- Engg M4-6-05	There is no protective cover on the VCB Switch . It may be trip if slightly tilted to test side. Chance of Power Fail by negligence		Installed protective cover which is in house fabricated in our work shop & now no chance of mishandling.
56	ENGG M4-6	K- Engg M4-6-06	The Wiring at the stairs is very unsafe & pointed out by seniors many times.		Now properly covered by help of conduit & fixed new box. It is now safe.
57	ENGG M4-6	K- Engg M4-6-07	Machine Panel having contactor which is hanging & wiring also not looking good.		Replaced the contactor & wiring also done properly & covered in channels.
58	ENGG M4-6	K- Engg M4-6-08	Aerofeed chute feed line having problem due the old pressure switch which is malfunctioning & also having less selection scale.		Replaced with new pressure switch which is easier to set as per demand & having big selection scale.
59	ENGG M4-6	K- Engg M4-6-09	Machine having soft starter for main motor & running at same speed pattern.		Replaced with new conversion procured from LMW & installed the complete attachment with the help of our maintenance team. System having multi speed pattern.
60	ENGG M9	K - ENGG M9 01	Ring Frame Panel Lock interchange with locking type panel lock.		Previous lock can be opened by any alternate of key and panel door were opened always. So we replace those lock by special lock. They can open only by their own key.
61	ENGG M9	K - ENGG M9 02	Provide fix platform for Grinder foot step switch in prep deptt.		Grinder foot switch was lying on floor and that was moving freely. Now it is fixed with a platform and it gives protection to foot switch and cable.
62	ENGG M9	K - ENGG M9 03	Two Nos PDBs in Auto coner DB Room was installed opposite side of each other in the middle of room and utilizing more space.		Re-locate & fixed both PDbs one row in one side of the room. It create big space in room for other useful needs to keep spares under 5S.
63	ENGG M9	K - ENGG M9 04	M9A Ring Frame 1 to 12 Power cables and PDBs were creating unsafe condition in RA Trenches & Inverter Room.		New PDB Room for RF1 to 12 identified and fixed two new PDBs and shifted RF 1 to 12 from exisiting PDB Room thus improved Safe Electical Installtion under Fire prevention activity.
64	ENGG M9	K - ENGG M9 05	There were very sabby & intagled cable laying in all RA Trenches which were creating unsafe condition.		In all cable trenches, proper cable tray and cable laying with proper dressing done to improve safe electrical installtion.
65	ENGG M9	K - ENGG M9 06	Unused Cables removed from the wall.		There was lots of cable were hanging out of the wall. We remove all unwanted cable and gives proper path to usable cable.
66	ENGG M9	K - ENGG M9 07	Indication Lights of Murata 21C were found costly from OEM as need to replace on all 11 nos Auto Coner.		Explored import sustitue with good quality LED Indication and saved Rs..... ( One Time saving for all 11 Auto Coners )
67	ENGG M9	K - ENGG M9 08	PDB Rooms located in Production Deptt were not identified.		Proper Identification Board placed for all PDB Rooms in Production Deptt.
68	ENGG M9	K - ENGG M9 09	Emergency lighting supply source ( UPS ) location were not uidentified and marked.		Emergency lighting supply source (UPS) now identified with Name Plate for awarness of all.
69	ENGG M9	K - ENGG M9 10	Power House new offices identification		In Power House new offices and wardrobs were marked .
70	ENGG M9	K - ENGG M9 11	In Dye House, Main Control panel were lying in floor which were unsafe looking to use of water there in floor too.		Wall mounted frames were fixed and relocate control panel on that for safety and ease of working.
71	ENGG M9	K - ENGG M9 12	Compressed Air uses in Autoconer were not monitored		Installed Kalki Flow compressed air flow meter and arrange its daily report to all concerned to monitor and control wastge of compressed air.
72	ENGG M9	K - ENGG M9 13	Old Energy meters are not compitable with EMS system		Installed new energy meters for online EMS.
73	ENGG M9	K - ENGG M9 14	There were lot of cables laid on AC Sheets roof sheetign causing unsafe condition.		Removed all unsed cables which helped in new sheet metal roof sheeting and improve safe installation.
74	ENGG M9	K - ENGG M9 15	Mobile Jammer supply board was having temp. connection which were unsafe.		Modified Supply Board and improve safe electrical installtion.
75	ENGG SJ11	K - ENGG SJ11 01	North side carding H-plant VFD cable dressing not proper.		Looking to safety we have done proper cable dressing.

76	ENGG SJ11	K - ENGG SJ11 02	South side LT room Emergency Light UPS cable dressing not proper.		To improve 5s in LT room, done proper cable dressing.
77	ENGG SJ11	K - ENGG SJ11 03	Blow Room VIP Cascade AC water dropping problem.		To avoid water dropping problem done insulation of Copper tube.
78	ENGG SJ11	K - ENGG SJ11 04	Barco DU-10 is not available on New carding due to online monitoring not possible.		We removed ok DU-10 from Ch. Wdg & fixed on all 4 new carding to analyse the production parameters.
79	ENGG SJ11	K - ENGG SJ11 05	In ADM Block, COO Sb office AC water drainage not proper.		We have used PVC pipe with proper routing for AC water drainage.
80	ENGG SJ11	K - ENGG SJ11 06	North side spining H-plant Rotary Filter Flat belt damage problem & aprox 1 belt broken in every two months.	0.25	We have repair the belt inhouse.
81	ENGG SJ11	K - ENGG SJ11 07	North side TFO H-plant Rotary Filter Nozzle Bend damage problem.	0.06	We try to repair inhouse & success.
82	ENGG SJ11	K - ENGG SJ11 08	Fire extinguisher not available at Finish Godown no 4A.		Looking to safety we have fixed make fire extinguisher at finish godown no. 4A
83	ENGG SJ11	K - ENGG SJ11 09	At 11 VCB room (Old wartsila panel room) cleaning not proper.		Looking to 5s & safety we have done proper cleaning at 11 VCB room.
84	ENGG SJ11	K - ENGG SJ11 10	Harvesting Line overflow problem.		We have modified the Pipe Line to avoid overflow.
85	ENGG SJ11	K - ENGG SJ11 11	Sewage line choke problem.		We created a bypass line by inhouse team for sewage line to avoid choking problem.
86	ENGG SJ11	K - ENGG SJ11 12	Store, AC water drainage not proper & spread on floor.		Looking to 5s, used a drum for drainage water.
87	ENGG SJ11	K - ENGG SJ11 13	Observe Ladder identification not mention.		Looking to 5s, we have done identification & marking.
88	ENGG SJ11	K - ENGG SJ11 14	For RA Trench cleaning operator no any safety instruction in LT room.		We have fixed a Safety instruction for all RA Trench cleaning contractors & instructed to all for mentioned their name on board when go for cleaning in trench..
89	ENGG SJ11	K - ENGG SJ11 15	In Packing area observed moisture in compressed air.		To avoid moisture, fixed additional auto drain valve in Air Line.
90	ENGG SJ11	K - ENGG SJ11 16	No any notification for when Fire Hydrant pump started in automatic.		Looking to safety, fixed a 1 km range Syrun for hydrant pump starting to alert the security guard.
91	ENGG SJ11	K - ENGG SJ11 17	Earlier Fiber godown shutter directly controlled with Up & Down Push button & easily operated by anyone which is unsafe.		Looking to safety, we fixed a controlled key switch and which is operated by authorized person.
92	ENGG SJ11	K - ENGG SJ11 18	Eralier there was MCB for grass cutting machine which is unsafe.		We have fixed an industrial plug socket for safe operation.
93	ENGG SJ11	K - ENGG SJ11 19	Fire extinguisher were not properly placed in North Carding filter room due to door glass broken many times.		We have properly fixed all the fire extinguisher.
94	ENGG SJ11	K - ENGG SJ11 20	Luwa Rotary Air Filter Sealing Tape as earlier supply by OEM & cost of one belt was Rs. 12414.00	0.15	We explore OEM substitute of RA Filter Sealing tape & cost of one cable is Rs. 8406.00
95	ENGG SJ11	K - ENGG SJ11 21	LT Room, Transformers technical details not mentioned.		We fixed technical details of all 4 transformer with last maint. date.
96	ENGG UTILITY	K - ENGG UTILITY 01	there was panel which was fix on the platform		We have fix this panel on the wall for more space of work & also for safety purpose.
97	ENGG UTILITY	K - ENGG UTILITY 02	there is Stool piece cooler brocken.	0.75	we have installed and modified of new stool flange and cooler made by new one flange welding..
98	ENGG UTILITY	K - ENGG UTILITY 03	there is simple street line of steam in steam Dryer & The condense water of steam is coming with the steam in the Steam dryer machine.	0.55	We have fabricated a new band and fix it on the line. By this band the condense water of steam is not coming in the machine
99	ENGG UTILITY	K - ENGG UTILITY 04	there is a small size Star coupling size 275 in the motor and it was not working properly.		we have increasing the size of the coupling for properly working of motor
100	ENGG UTILITY	K - ENGG UTILITY 05	there is G.I. Line for chemical dosing		We have fabricated a new PPR line for chemical dosing for long life of line.
101	ENGG UTILITY	K - ENGG UTILITY 06	there was the old hydrant pipe line which was underground & its was leakage from many point so the pump was continuously running.		we have fabricated a new overhead hydrant pipe line for safety purpose & by this new pipe line the pump is running on Auto mode
102	ENGG UTILITY	K - ENGG UTILITY 07	there is ring size 40 MM		there is ring size 40 MM -2000 Pcs in house team.
103	ENGG UTILITY	K - ENGG UTILITY 08	there is no safety guard for safety purpose on steam heater for water drain.		After Kaizen we have fabricated a new safety guard on steam heater for water drain.
104	ENGG UTILITY	K - ENGG UTILITY 09	there is no pipe stand of hygrometer..		fabricated a new M.S. Pipe stand of hygrometer for safety purpose.
105	DYE HOUSE	K - Dye House 01	Leakage of the water from hydro extractor		After maint of hydro no.2 water leakage stop during m/c running helps to works smoothly and minimise change of hydro motor burn.
106	DYE HOUSE	K - Dye House 02	Vibration in the motor at Steam Dryer No. 2		Provided safety guards for motor helping safety for worker

107	NPD	K - NPD - 01	Fiber sample conatiners in dyeing lab sticker up with their Proper denier , length & Name.		Searching time of Fibre durg matching reduced.
108	NPD	K - NPD - 02	Mix colour tip is used on same count , Shade & blend but different Lot Sample .		Implemented Proper Identification of each Sample lot .
109	NPD	K - NPD - 03	Meeting scheduled on a fixed time ,at the time of meeting all marketing sample enquires have been discussed on daily basis.		Improve the lead time of the samples.
110	NPD	K - NPD - 04	Sample approval register is maintained ,sample will dispatch only after getting approval from concern person.		No wrong sample dispatch in the market.
111	NPD	K - NPD - 05	Proper area is identified in Office by label marking ,so that all things (Files etc.) put on their specific place.		Reducing searching time & Improvement in house keeping.
112	IT	K-IT-01	Millwise Maintenance & Blow Room Workers Attandance Done Manually in Excel and it will take time		Provided new fields in HRM & Create a Hands Report dept. Shift date wise Worker On roll.
113	P&IR	P&IR 01	Safety & Awarenwss in Health Centar by proper medecine identification.		Identification & Marking of Medicians
114	Guest House	GH 01	Back Storage of water for Cooler is using by manual		We use motor for back storage of water thorough pipe at the place of manully feeding
115	Guest House	GH 02	Stone as a tabble top for keeping Steel Glasses and plates in Bachelor dinninh hall.		We us stone for table top for keeping glass plates and other pots at place of wooden table.
<b>Total Annulized Amount</b>				<b>6.81</b>	