



RSWM Limited
an LNJ Bhilwara Group Company



PROUD TO BE INDIAN
PRIVILEGED TO BE GLOBAL

Unit - Kharigram



BEST 5 KAIZEN

July -2016

BEST 5 KAIZEN details

RSWM Limited, Kharigram - Best Kaizen : July 2016

Sr. No.	Department	Kaizen Title	Annulized Benefits in Rs. Lacs	Benefits - Monetary / System Improvement / Time Saving	Kaizen Originator
1	MAINT SJ11	Packing T-Car movement wheel rubber coating worn out.	0.15	To replace new wheel costing Rs. 10000.00. We explored repairing with same nature coating and T-car running smoothly. Repair cost was Rs. 3300.00. Thus saving of Rs. 7500.00 per wheel.	Sh. Bharat Bhai
2	MAINT M4-6	Mill no 4,5&6 ,Toyada (FL16) simplex ,There was missing middle condensor again and again.	0.17	We modified middle condensor in house like LF1465 and middle condensor missing problem solded ,and saved Rs-17760.(Rs 4440 /Mc)	Sh. Bhanwar Singh
3	MAINT SJ11	TFO Dropper wire blade joint broken. After this no use and requires to use new one	0.11	We have started welding the broken joint and resuse the Dropper wire which saved maint cost. New Dropper wire cost – RS. 315.00. Repairing cost - 115.00 Total damage per year – 65 Pcs	Sh. Tikam Chand
4	ENGG SJ11	H-plant bleeding water was directly drain to sewage tank	Water Saving	Reused the bleded water through pipe line for utility purpose,thus saved approx. 25KL/Day and saving of Rs. 13500 / per annum	Sh. Jalam Singh
5	ENGG UTILITY	Before Kaizen there is a normal size pulley in dryer machine	0.54	After Kaizen We have use bigger size pulley for more Efficiency and more production	Sh. Laxman Singh

		KAIZEN SHEET				Unit No./Mill No.: SJ-11 Location : PACKING Date : 20-07-2016 KAIZEN No.: RSWM/L/2015/MX/Y	
		KAIZEN Theme : PACKING T-CAR WHEEL				Category : (Tick v right one)	
	BEFORE KAIZEN						
	Observation : Packing T-Car movement wheel rubber coating worn out.				1. Productivity (P)		
				2. Quality (Q)			
				3. Cost (C)	v		
				4. Delivery (D)			
				5. Safety (S)			
				6. Environment (E)			
				7. 5S			
	AFTER KAIZEN				Benefit :		
	Observation : To replace new wheel costing Rs. 10000.00. We explored repairing with same nature coating and T-car running smoothly. Repair cost was Rs. 3300.00. Thus saving of Rs. 7500.00 per wheel.				Tangible / Intangible		
				Tangible Gain Calculation (If applicable)			
				In a year approx. 2 wheel need repairing hence saving of Rs. 15000.00 per year.			
Identified By: Bharat Bhai Approved By : Sh. Virendra Chaudhary Implemented By: RAMESH KHATTRI		Sustenance Plan				Scope and plan (Horizontal Deployment)	
		SN	Activity	Resp.	Target		

KAIZEN SHEET

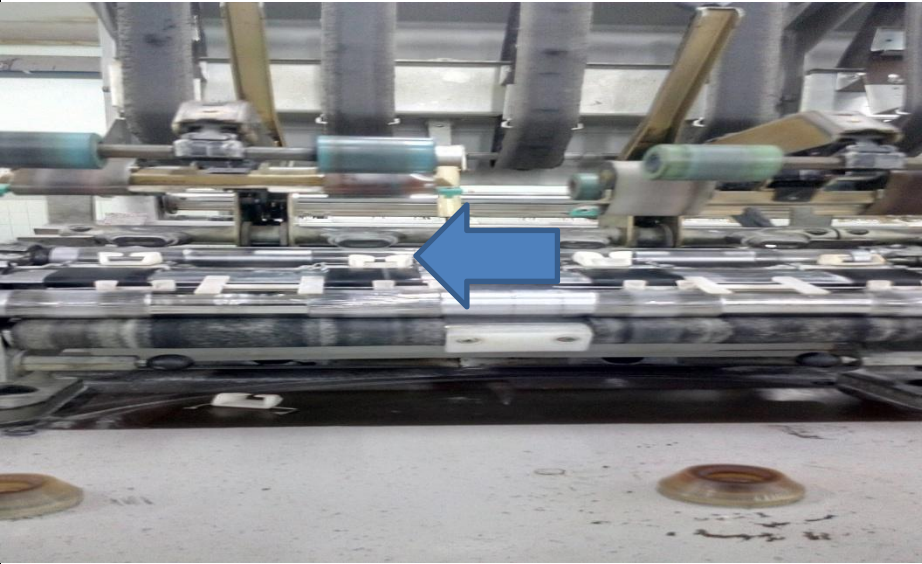
Unit No./Mill No.: 4&6

Location :SIMPLEX

Date : 24-07- 2016

KAIZEN No.: RSWM KGM 2

KAIZEN Theme :

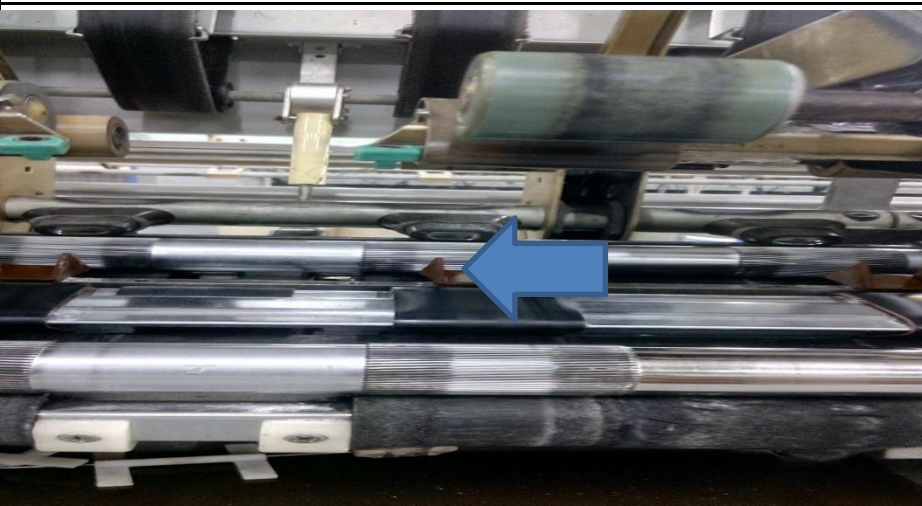


BEFORE KAIZEN

Observation:
THERE WAS MIDDLE
CONDENSOR MISSING
PROBLEM IN FL 16 S/F.

Category : (Tick ✓ right one)

1. Productivity (P)	
2. Quality (Q)	✓
3. Cost (C)	✓
4. Delivery (D)	
5. Safety (S)	
6. Environment (E)	
7. 5S	



AFTER KAIZEN

Observation :
WE MODIFIED LIKE LMW
TYPE ,AND PROBLEM SOLVED,
SAVED RS-17760 ALSO.

Benefit :

Tangible Gain Calculation (If applicable)

RS-17760.



Identified By: Bhanwar Singh

Approved by : Sh. AK Dubey

Sustenance Plan

SN	Activity	Resp.	Target

Scope and plan (Horizontal Deployment)

KAIZEN SHEET		Unit No./Mill No.: SJ-11														
		KAIZEN Theme : TFO DROPPER WIRE		Location : TFO												
		Date : 1-07-2016	KAIZEN No.: RSWM/L/2015/MX/Y													
	BEFORE KAIZEN		Category : (Tick v right one)													
	Observation : TFO Dropper wire blade joint broken. After this no use and requires to use new one		<table border="1"> <tr><td>1. Productivity (P)</td><td></td></tr> <tr><td>2. Quality (Q)</td><td></td></tr> <tr><td>3. Cost (C)</td><td style="text-align: center;">v</td></tr> <tr><td>4. Delivery (D)</td><td></td></tr> <tr><td>5. Safety (S)</td><td></td></tr> <tr><td>6. Environment (E)</td><td></td></tr> <tr><td>7. 5S</td><td></td></tr> </table>	1. Productivity (P)		2. Quality (Q)		3. Cost (C)	v	4. Delivery (D)		5. Safety (S)		6. Environment (E)		7. 5S
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	AFTER KAIZEN		Benefit :													
	Observation : We have started welding the broken joint and reuse the Dropper wire which saved maint cost.		<table border="1"> <tr><td colspan="2" style="text-align: center;">Tangible / Intangible</td></tr> <tr><td colspan="2" style="text-align: center;">Tangible Gain Calculation (If applicable)</td></tr> <tr><td colspan="2">New Dropper wire cost – RS. 315.00</td></tr> <tr><td colspan="2">Repairing cost - 115.00</td></tr> <tr><td colspan="2">Total damage per year – 65 Pcs</td></tr> <tr><td colspan="2">Saving of Rs. 55* 200 = 11000.00 per year</td></tr> </table>	Tangible / Intangible		Tangible Gain Calculation (If applicable)		New Dropper wire cost – RS. 315.00		Repairing cost - 115.00		Total damage per year – 65 Pcs		Saving of Rs. 55* 200 = 11000.00 per year		
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Identified By: Tikam Chand Approved By : VIRENDRA KUMAR Implemented By: RAMESH KHATTRI	Sustenance Plan		Scope and plan (Horizontal Deployment)													
	SN	Activity		Resp.	Target											

KAIZEN SHEET

Unit No./Mill No.: SJ-11

Location: Utility

Date : 15/07/2016

KAIZEN No.: 04

KAIZEN Theme :Optimization of H-plant waste water bleeding.



BEFORE KAIZEN

Observation:-H-plant bleeding water was directly drain to sewage tank.

Category : (Tick ✓ right one)

1. Productivity (P)	
2. Quality (Q)	
3. Cost (C)	✓
4. Delivery (D)	
5. Safety (S)	
6. Environment (E)	✓
7. 5S	



AFTER KAIZEN

Observation : Reused the bleed water through pipe line for utility purpose, thus saved Approx. 25 KL/Day.

Benefit :

Tangible / Intangible

Tangible Gain Calculation (If applicable)

Treated water used for Utility in SJ11 costs approx. Rs. 1.50 / KL means saving of Rs. 13500.00 per annum

Identified By: Sh. Jalam Singh

Approved By : Sh. AS Rathore

Implemented By: Sh. Jalam Singh

Sustenance Plan

Scope and plan (Horizontal Deployment)

S N	Activity	Resp.	Target



Kaizen there is a normal size pulley in dryer machine

2. Quality (Q)	
3. Cost (C)	
4. Delivery (D)	
5. Safety (S)	√
6. Environment (E)	
7. 5S	



AFTER KAIZEN

Observation : After Kaizen We have use bigger size pulley for more Efficiency and more production.

Benefit :

10 - 12 % Dryer production increase
 Before Dryer Production 6500 Kg and
 Now Dryer production 7500Kg=1000 Kg increased

Tangible Gain Calculation (If applicable)

Dryer production increased 1000 Kg/ Day
 @Rs.0.15 Kg=Rs150/-per day
 Rs.150.0 x 30 Days=4500/- Months
 Rs. 4500 x 12 Months=Rs 54000/-

Identified By: Sh. Laxman singh
 Approved By : Sh Sanjay Vishnoi
 Implemented By: Sh R.S. Chouhan ji

Sustenance Plan			
S N	Activity	Resp.	Target

Scope and plan (Horizontal Deployment)

Thanks

Arvind Singh Rathore
Manish Gupta