

Unit - Kharigram

**BEST 5 KAIZEN**

**June -2016**

**RSWM Limited, Kharigram - Best Kaizen : June 2016**

Sr. No.	Department	Kaizen Title	Annulized Benefits in Rs. Lacs	Benefits - Monetary / System Improvement / Time Saving	Kaizen Originator
1	MAINT. M4-6	Robotic Doffer of Ring Frame went in breakdown as its Bracket broken and supposed to receive from CTMTC China which leads long time to start again.	0.27	We have explored in house arrangement, design the same and with help of workshop developed and started stopped Doffer. It saved cost of spares as Rs. 27000.00 one time.	Sh. Sardar Singh
2	ENGG UTILITY	Boiler APH Ash handling by trolley which reduces its Temp. As well as recovery comes lower.	0.49	We have make and modified the Boiler APH Ash System and 100% use in boiler by air blow pipe.	Sh. RS Chouhan
3	POST SPG SJ11	Since project started we have using 5 ply corner sheet for pallet packing to to avoid transit damage to pallets.	2.31	We have taken trial of pallet packing by 3 ply corner sheet and found there is no risk of pallet damage during transit. Therefore starting 3 ply corner sheet for pallet packing.	Sh. RK Gupta
4	MAINT.SJ11	During Doff at while Cheese replacement work going on break disk missing problem even after due care.	0.12	Since it causing extra cost of break disk replacement hence we have fixed break disk by adhesive thus in avg. Rs. 1000.00 saving started per month.	Sh. Din Dayal
5	ENGG. SJ11	SJ11 Finished Godown has power supply due to store, desptach and packing working. Power Supply switching was manual which may lead to any incident if anyone forget to switch off power supply at the end of day.	<b>Safety</b>	To ensure safety for electric power supply complete switching panel converted in auto mode as power supply switch off automatically at defined time. At present time setting is 09.00 AM to 09.00 PM.	Sh. Kishan Lal

# KAIZEN SHEET

Unit No./Mill No.: 4  
 Location :RING FRAME  
 Date : 20-06- 2016  
 KAIZEN No.: RSWM KGM 1

KAIZEN Theme :



## BEFORE KAIZEN

Observation:  
 Robotic Doffer of Ring Frame went in breakdown as its Bracket broken and supposed to receive from CTMTC China which leads long time to start again.

### 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 have explored in house arrangement, design the same and with help of workshop developed and started stopped Doffer. It saved cost of spares as Rs. 27000.00 one time.

### Benefit :

INCREASE THE PRODCTIVITY

### Tangible Gain Calculation (If applicable)

One time spare cost saving of Rs. 27000.00



Identified By: Sh. Sardar Singh

### Sustenance Plan

### Scope and plan (Horizontal Deployment)

SN	Activity	Resp.	Target

Approved By : Sh. AK Dubey



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

<b>AFTER KAIZEN</b>	<b>Benefit :</b>
Observation : After Kaizen We have make and modified the Boiler APH Ash System and 100% use in boiler by air blow pipe.	Due to this kaizen we have avoid the Wastage of APH Ash and used of 100%in Boiler.
	<b>Tangible Gain Calculation (If applicable)</b>
	3%improve the recovery in pet coke. Coal Consumption Avg.10500x.3%=31.5Kg 1Kg.Pet coke=Rs.6.5/- Total Amount in month=31.5*6.5*30=6142.5/- <b>Saving for 8 months =Rs.6142*8=49140/-</b>

**Identified By: Sh. RS Chouhan**

**Approved By : Sh Sanjay Vishnoi**

**Implemented By: Sh .R.S. Chouhan**

Sustenance Plan			
S N	Activity	Resp.	T a r g e t

**Scope and plan (Horizontal Deployment)**

# KAIZEN SHEET

**KAIZEN Theme : Packing cost saving through corner sheet in pallet**

Unit No./Mill No.: SJ-11  
 Location : Post Spinning.  
 Date : 25.6.16  
 KAIZEN No. 2



## BEFORE KAIZEN

Observation:- Since project started we have using 5 ply corner sheet for pallet packing to avoid transit damage to pallets.

## 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 have taken trial of pallet packing by 3 ply corner sheet and found there is no risk of pallet damage during transit. Therefore starting 3 ply corner sheet for pallet packing.

## Benefit :

Tangible / Intangible

## Tangible Gain Calculation (If applicable)

Save Rs. 19 / sheet \*33.33 sheet used / day \*365 = Save 2.31 lacs /annum.

## Scope and plan (Horizontal Deployment)

**Identified By: Sh. RK Gupta**

**Approved By : Sh. Vinay Srivastav**

**Implemented By: DP Sharma**

## Sustenance Plan

S	Activity	Resp.	Target
N			

**KAIZEN Theme : TFO TENSION MULTI DEVICE BREAK DISC**



**BEFORE KAIZEN**

**Observation : During Doff at while Cheese replacement work going on break disk missing problem even after due care.**

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 : Since it causing extra cost of break disk replacement hence we have fixed break disk by adhesive thus in avg. Rs. 1000.00 saving started per month.**

Benefit :

**Tangible / Intangible**

Tangible Gain Calculation (If applicable)

**ONE BREAK DISC COST IS 10 /PCS. ONE MONTH CONSUMPTION IS 100 PCS & FROM LAST 1 MONTH NOT A SINGLE PIECE IS PURCHASE. SAVING 1000 RS / MONTH. ANNUAL SAVING RS. 0.12 LACS**

Identified By: SH. DIN DAYAL

Sustenance Plan

Scope and plan (Horizontal Deployment)

Approved By : SH. VIRENDRA KUMAR

SN	Activity	Resp.	Target

Implemented By: SH. RAMESH KHATRI

# KAIZEN SHEET

Unit No./Mill No.: SJ-11  
 Location: Finish Godown  
 Date : 12.06.2016  
 KAIZEN No.: 09

**KAIZEN Theme** :Observe finish Godown Lighting control by MCB switch.

## BEFORE KAIZEN

Observation--:SJ11 Finished Godown has power supply due to store, desptach and packing working. Power Supply switching was manual which may lead to any incident if anyone forget to switch off power supply at the end of day.

## Category : ( Tick v right one)

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

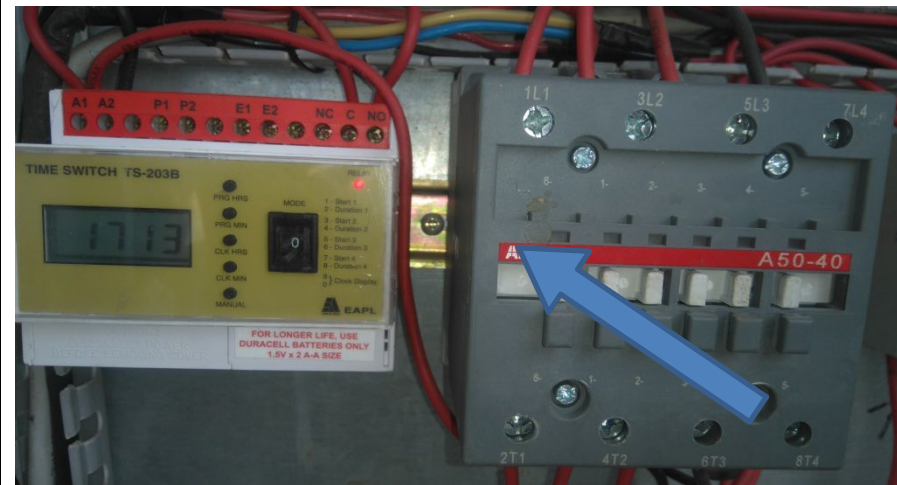
## AFTER KAIZEN

Observation : To ensure safety for electric power supply complete switching panel converted in auto mode as power supply switch off automatically at defined time. At present time setting is 09.00 AM to 09.00 PM

## Benefit :

Tangible / Intangible

## Tangible Gain Calculation (If applicable)



Identified By: Sh. Kishan Lal  
 Approved By : Sh. AS Rathore  
 Implemented By: Sh. Mahaveer

## Sustenance Plan

## Scope and plan (Horizontal Deployment)

SN	Activity	Resp.	Target

# Thanks

**Arvind Singh Rathore**  
**Manish Gupta**