BEST 5 KAIZEN

RSWM Limited, Kharigram

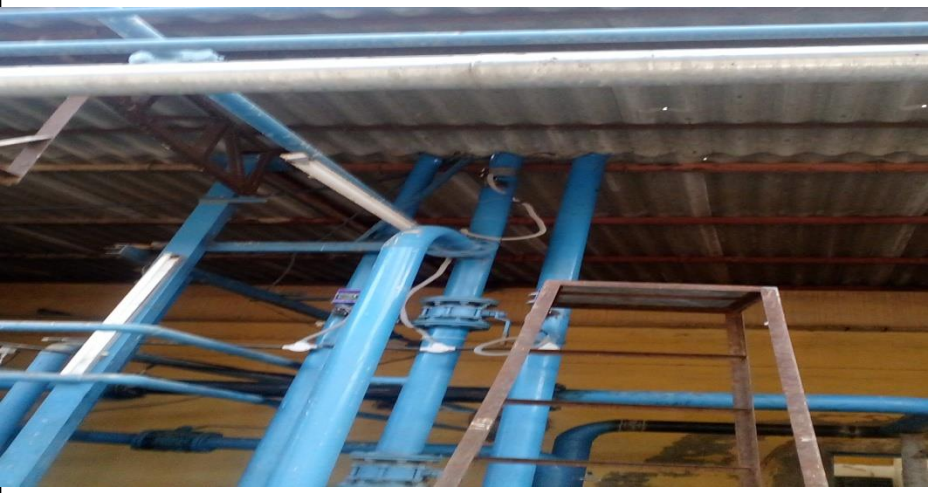
March -2016

RSWM Limited, Kharigram - Best Kaizen : March' 2016					
Sr. No.	**Department**	**Kaizen Title**	**Annulized Benefits (Rs. Lacs)**	**Benefits - Monetory / System Improvement / Time Saving**	**Kaizen Originator**
1	ENGG UTILITY	To install Air Flow Meter in Main Compressed Air Line it was required to sh stop M 1 to 9 but Team done installation in running line with necessary tools and expert.	0.25	By doing this work online, no need of plant stop which results Zero Production Loss to install Air Flow Meter	Sh. Kanheya Lal
2	ENGG SJ11	In SJ11 BTS Tube Cleaner HMI damaged which comes in Rs. 1.14 Lacs. Team used Ring Frame HMI of Rs. 0.40 Lacs and installed the same with Neuenhauser support.	0.74	BY doing this Kaizen, replacement cost reduced as well as common inventory may be kept.	Sh. Vikas Garg
3	SPG M4-6	Lappet rail tilting time reduce in R/f G5/1 in Mill no.4.	2.30	Reduction in lappet tilting time redcued doffing time and increased productivity.	Sh. Ramesh Gurjar
4	POST SPG M 9	For Re issue material packing started use of old HDPE bags.	1.44	By using old HDPE bags huge amount saving and inventory will be reduced.	Sh. SP Vaishnav
5	ENGG M 9	In CTMTC Ring Frame, Ring Rail movement controlled by OEM designed Limit switch Box.Installed proximity switch which are more reliable and cost effective.	0.48	By using proximity switches set maint / replacemetn cost reduced and trouble shooting will be easy which saves down time.	Sh. Narendra Singh

KAIZEN SHEET

KAIZEN Theme :Calibration of Air flow meter

Unit No./Mill No.: Compressor
Location: Compressor
Date : 02/03/2016
KAIZEN No.: 1



BEFORE KAIZEN

Observation : Before Kaizen Air Flow Meter removing from main line for calibration.

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 : After Kaizen We have plan of stop the mill wise 5-10 minutes but our technician work on main pressure line and removed the flow meter with out shut down and after calibrated flow meter fitted on main line. This flow meter calibrated work in all mill.

Benefit :

We have Financial Benefit in this kaizen because of all mill wise m/c with out loss and work completed . Save the detention time minimum 10 minutes of all mill m/c. stopped time.

Tangible Gain Calculation (If applicable)

Total Shut down time save =Total mill 8 x10 minutes =80 Minutes**.=Apps.3 lacs Saved**

Identified By: Sh. .Khanya Lal

Approved By : Sh.Sanjay Vishnoi

Implemented By: Sh. Neeraj Sharma

Sustenance Plan

SN	Activity	Resp.	Target

Scope and plan (Horizontal Deployment)

KAIZEN SHEET

KAIZEN Theme : Textra Tube Cleaner touch display

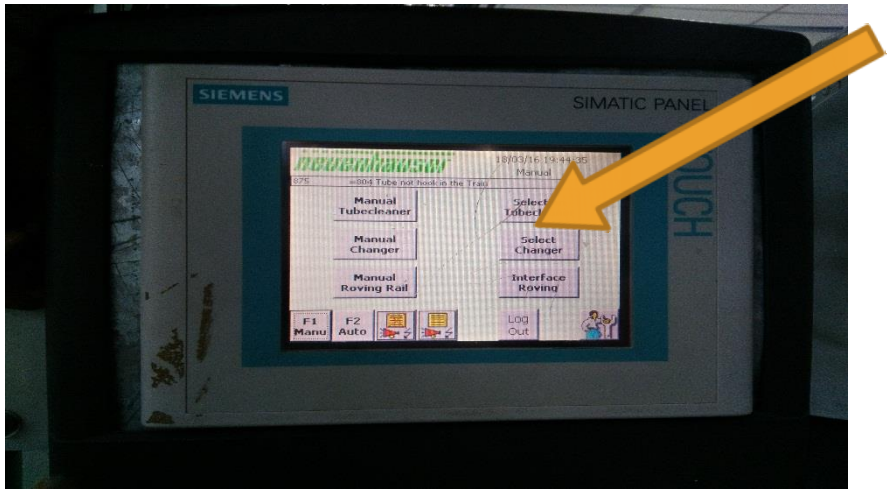
Unit No./Mill No.: SJ-11
Location: BTS Textra
Date : 18.03.2016
KAIZEN No.: 03

BEFORE KAIZEN

Tube Cleaner touch display (Make Siemens) OP177b 4" was not work & actual cost of display is 1.14 Lacs.

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

We explore the NH Substitute & installed Siemens OP177 B 6" display & display cost is Rs. 0.40 Lacs. Thus saved Rs. 0.74 Lacs

Benefit :

Tangible / Intangible

Tangible Gain Calculation (If applicable)

0.74 Lacs for each replacement.

Identified By: Sh. Vinod Kumar

Approved By : Sh. AS Rathore

Implemented By: Sh. Vikas Garg

Sustenance Plan

SN	Activity	Resp.	Target

Scope and plan (Horizontal Deployment)

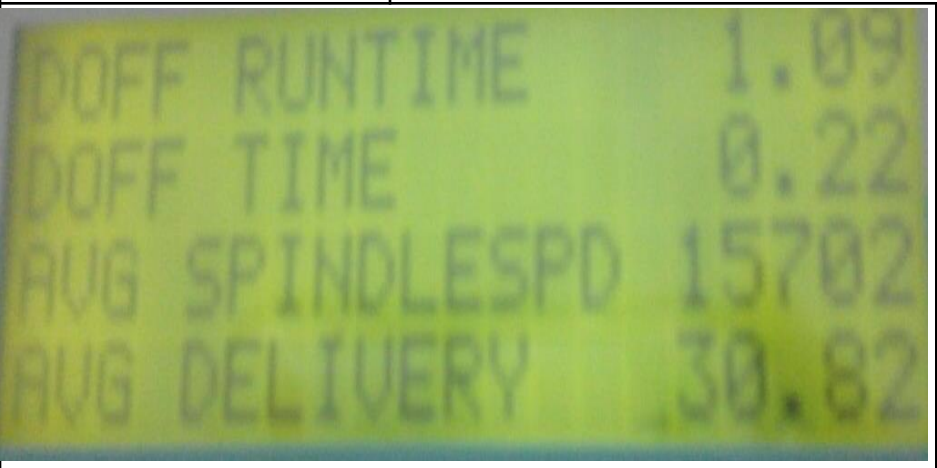
KAIZEN SHEET

RSWM Limited
An LNJ Bhilwara Group Company

KAIZEN Theme : Lappet rail tilting time reduce in R/f G5/1 in Mill no.4.

Unit No./Mill No.: SPG 4
Location : RING FRAME
Date : **02.03.2016**

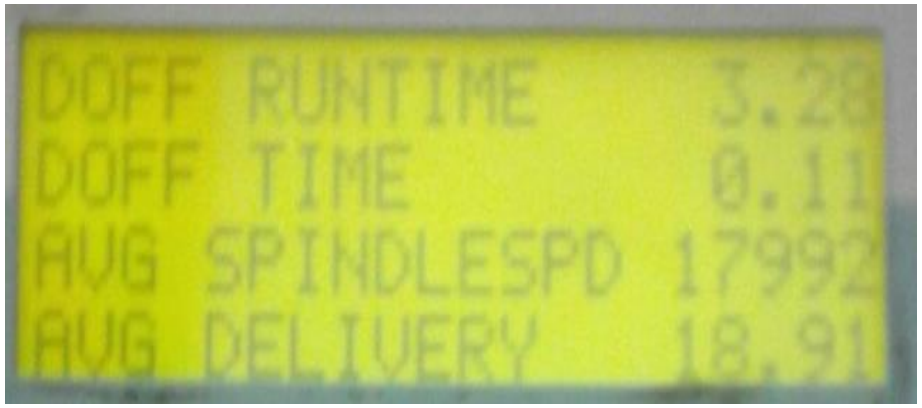
KAIZEN No--- 1



BEFORE KAIZEN

Observation : Before kaizen lappet rail timing 22 second.

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 : After kaizen lappet rail timing 11 second. saving of 11 second in every doff.

Benefit :

Tangible Gain Calculation (If applicable)

NOT APPLICABLE FOR ANY TANGIBLE GAIN

Identified By: Ramesh Gurger

Approved By : HOD SPG
Implemented By: Manish Gupta

Sustenance Plan

SN	Activity	Resp.	Target
1	Lappet rail down time reduce . due to this saving of 11 second in every doff.	Manish Gupta	Completed

Scope and plan (Horizontal Deployment)

KAIZEN SHEET

KAIZEN Theme : PACKING COST REDUCED IN RE ISSUE PACKING BY USING OLD HDPE BAGS

Unit No./Mill No.: 9
Location : PACKING
Date : 12.03.2016
KAIZEN No. 3

BEFORE KAIZEN NEW BAGS WERE BEING USED IN RE ISSUE PKG.

BEFORE KAIZEN

Observation-: EARLIER NEW BAGS WERE USED IN RE ISSUE PACKING SO PACKING COST WAS COMING HIGH.

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 ARE **SAVING RS. 12000 / MONTH (1.44 Lacs / year)** IN PACKING COST BY USING OLD HDPE BAGS IN RE - ISSUE PACKING.

Benifit :

Tangible / Intangible

Tangible Gain Calculation (If applicable)

Identified By: S.K.CHAUBEY
Approved By : Dy. COO sb.
Implemented By:
S.P.VAISHNAV

Sustenance Plan

SN	Activity	Resp.	Target

Scope and plan

KAIZEN SHEET

KAIZEN Theme : Ring Frame Ring Rail Limit Switch

Unit No./Mill No.: M-9
Location: Speed Frame
Date : 15/03/2016
KAIZEN No.: 05

BEFORE KAIZEN

For Ring Rail Movement control through Limit Switch .it is very costly (RS.3000)

AFTER KAIZEN

In place of limit Switch fixed Sensor for Ring Rail Movement control is cheap in price. RS1000

Category : (Tick √ right one)

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

Benefit :

Tangible / Intangible

Tangible Gain Calculation (If applicable)

1) Total 24 Nos set defective
2) Thus saved Rs. (2000 x 24=48000.00) i.e 0.48 Lacs

Identified By: Sh. Surendra

Approved By : Sh. AS Rathore

Implemented By: Sh. Narendra Singh

Sustenance Plan

SN	Activity	Resp.	Target
1	Regular checking of limit switch and Sensor	Narendra Singh	

Scope and plan (Horizontal Deployment)