

Unit - Kharigram

**BEST 5 KAIZEN**

**May -2016**

## RSWM Limited, Kharigram - Best Kaizen : May 2016

Sr. No.	Department	Kaizen Title	Annulized Benefits in Rs. Lacs	Benefits - Monetary / System Improvement / Time Saving	Kaizen Originator
1	ENGG SJ11	Since two unimix and one condensor bypassed as per production deptt requirement which reduced suction requirement hence exercised to reduce MA Fan RPM	6.42	Earlier MA Fan was running in auto mode of energy saving. We have discussed with Luwa and fixed MA Fan frequency from 42 Hz to 36 Hz and achieved saving of approx. 12 KW per hour	Sh. Mishri Lal
2	SPG SJ11	There was centralized waste collection motor for Speed Frame OHTC on each phase ( 5 Speed Frame )	2.43	Now OHTC waste collection done by machine fan motor by modifying piping.	Sh. Vivek Katiyar
3	ENGG UTILITY	In M1-9 some Autoconers running with high compressed air pressure up to 7.7 Kg pressure	4.49	All machines study done and compressed air pressure optimized up 7.0 Kg this reduce power consumption of Air Compressor at generation end	Sh. Anil Kumar
4	CPPC	Export material of RGS & KGM were packed at sealed at Port which leads higher cost	1.38	Export material container filling system modified such as now it will be sealed at plant site and reduces transportation cost.	Sh. Gajendra Maru
5	POST SPG M9	In M9A Yarn Conditioning Room there was no steam line like all other Mills	2.19	Steam line provided which improves moisture contents and started moisture gain saving.	Sh. SP Vaishnav

# KAIZEN SHEET

**KAIZEN Theme : Optimization of Blowroom North side MA Fan**

Unit No./Mill No.: SJ-11  
 Location: North Blow room H-plant  
 Date : 02.05.2016  
 KAIZEN No.: 01



## BEFORE KAIZEN

Observation:- After 2 No's Unimix stopped in North Side Blow room Line, we observe Pascal of MA Fan increase as per requirement.

## 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 optimized the inverter frequency with respect to Pascal of MA Fan and department requirement & saved approx. 6.417 Lacs/Year.

## Benefit :

Tangible / Intangible

## Tangible Gain Calculation (If applicable)

- After optimized frequency we saved approx. 250 units/day.
- 250X30X12= 90000 Units/Year
- Per Year Saving in Rs. Lacs =  $(90000 \times 7.13) / 10^5 = 6.417$  Lacs

Identified By: Sh. Manoj Kumar / Mishri Lal

## Sustenance Plan

## Scope and plan (Horizontal Deployment)

SN	Activity	Resp.	Target

Approved By : Sh. AS Rathore

Implemented By: Sh. Nishant

# KAIZEN SHEET

Unit No./Mill No.: SJ-11

Location :SF OHTC waste collection area

Date 1.05.16

KAIZEN NO-1

KAIZEN Theme : : SF waste collection



## BEFORE KAIZEN

### Observation:-

SF OHTC waste collection system was operate by separately 3 kw 2 motors

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 :

Now OHTC waste collecting by , machine fan waste collecting motor. Spare 2 motors of 3 KW

Benefit :

Tangible / Intangible

Tangible Gain Calculation (If applicable)

= 3.0 \*2 \*.65 \*24\*365\*7.13  
= Rs. 2.43 Lacs per annum

Identified By: Sh Vivek Katiyar

Sustenance Plan

Scope and plan (Horizontal Deployment)

Approved By : Sh. BK Verma

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N

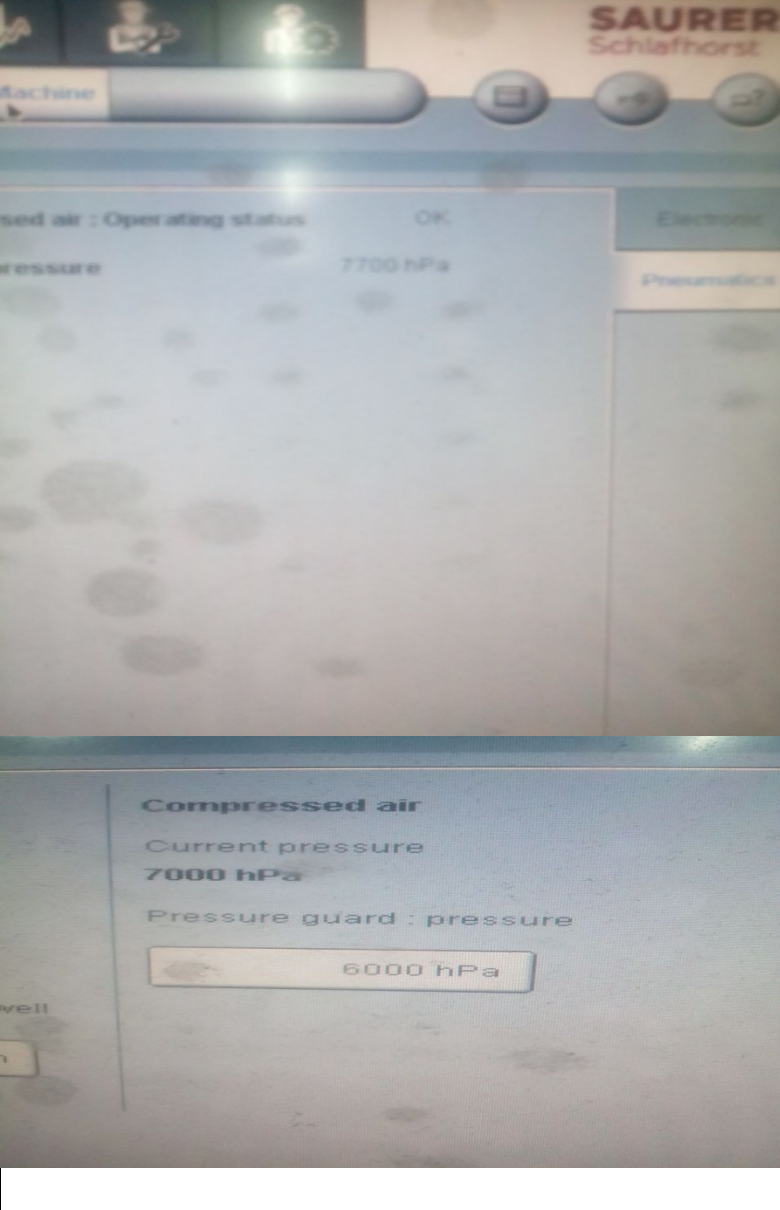
Activity

Resp.

Target

Implemented By:Sh. Ram Gopal





Observation : Before Kaizen in Mill no.9 autocorner excess high pressure coming in autocorner up to 7700 kg/cm2 .

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

**AFTER KAIZEN**

**Benefit :**

Observation : After Kaizen we have supplied the high air pressure uniformly distribution by pipe line in all mills and also arrest some leakages .

Minimize excess running hrs of compressure and unit saving per day unit 175.  
 @Power cost Rs 7.13 /-unit  
 Total cost saving per day =175\*7.13=1247 Per day  
 =Rs.1247\*360 days=Rs.449190/-

**Tangible Gain Calculation (If applicable)**

This work is completed in house team =Rs.449190/-

Identified By: Sh .Anil Kumar  
 Approved By : Sh Sanjay Vishnoi  
 Implemented By: Sh .Neeraj Sharma

**Sustenance Plan**

**Scope and plan (Horizontal Deployment)**

S N	Activity	Resp.	Target



# KAIZEN SHEET

**KAIZEN Theme :** Inter Unit Mix Container Shipment

Unit No./Mill No.: YARN SALES  
 Location : KGM  
 Date : 30<sup>th</sup> **MAY 2016**  
 KAIZEN No.: 01 **RSWM/L/2016/MX/Y**

**Export material of RGS & KGM were packed at sealed at Port which leads higher cost**

## BEFORE KAIZEN

Observation : Export material of RGS & KGM were packed at sealed at Port which leads higher cost

### Category : ( Tick v right one)

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

**Export material container filling system modified such as now it will be sealed at plant site and reduces transportation cost**

## AFTER KAIZEN

Observation : Export material container filling system modified such as now it will be sealed at plant site and reduces transportation cost

### Benefit :

Tangible / Intangible  
**Inter Unit Mix Container Stuffed at plant**  
**Tangible Gain Calculation (If applicable)**  
 Tangible Gain Rs-11551/--  
 Per month

**Identified By:**  
Gajendra Maru

**Approved By :**  
Shri K.C.KOGTA

**Implemented By:** YARN SALES

### Sustenance Plan

SN	Activity	Resp.	Target

### Scope and plan (Horizontal Deployment)

## KAIZEN SHEET

**KAIZEN Theme : In Yarn conditioning room M-9 A steam line given to increase moisture gain in yarn.**

Unit No./Mill No.: 9A  
 Location : PACKING  
 Date : 21.05.2016  
 KAIZEN No. 4



Picture

### BEFORE KAIZEN

Observation-: There was not steam line in yarn conditioning room in M-9A . We were not taking extra moisture gain .

### 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 : Now we have fixed steam line in yarn conditioning room M-9A & taking extra moisture gain in final product. **Gain in Rs. 219780 / year @ 0.01% moisture gain.**

### Benefit :

Tangible / Intangible

### Tangible Gain Calculation (If applicable)

### Sustenance Plan

Activity	Resp.	Target
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### Scope and plan

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Identified By: SP Vaishnav  
 Approved By : Sh. SK Choubey  
 Implemented By: Sh. Sanjay Vishnoi