

S.N	Department	KAIZEN Description	Annualized Benefit Rs. lacs	Status after Kaizen
1	SPG M1 - 3	Increase blow air pressure by reducing no of nozzles & put appropriate place		By reducing blow air nozzles & appropriate place more effect on fly removal.
2	SPG M1 - 3	due to damage storage boxes fibre accumulation from waste box		After repairing of storage boxes problem of fibre accumulation to be avoided.
3	SPG M1 - 3	Make a proper safety rail proper arrangement & avoid damage of CANS		BY making suitable safety rail avoid the damage of Cans and improve in proper arrangement of Cans
4	SPG M1 - 3	Put safety guard on New D/f TD 7.		by making of safety rail avoid damage of machine parts
5	SPG M1 - 3	Due to the no partition more accumulation of fibre		By making of partition cover fibre accumulation reduced
6	SPG M1 - 3	Due to no proper storage of identification rings problem of segregation of rings		After making of storage box proper segregation of identification rings
7	SPG M1 - 3	Improve the work practice by implementation of electric cleaning Gun.		After implementation of machine cleaning gun improve in work practice of cleaning of machine
8	SPG M1 - 3	Enlarge the preparatory section gate of mill no. -1,2&3		Enlarge the preparatory section gate easy to material transfer , good looking & 5s maintained.
9	SPG M1 - 3	Make a proper place for storage of empty simple bobbin		Improve in the segregation by making proper storage racks for placing of empty bobbins
10	SPG M1 - 3	Put safety guard on New LC 300 V4.		Put safety guard & avoid the chances of damage & scratches.
11	SPG M1 - 3	Put safety guard on Skaat Slub attachment		:Put safety guard & avoid the chances of damage & scratches.
12	SPG M1 - 3	Modification in the count board by impenation of MO NO		proper identification of running product by adding MO no system.
13	SPG M1 - 3	Put safety guard on S/f LF 4200.		Put safety guard & avoid the chances of damage & scratches.
14	SPG M1 - 3	Put safety guard on S/f LF1465 & LF1400.		Put safety guard & avoid the chances of damage & scratches.
15	SPG M4-6	Using Curtain with White coloured Mesh in place of Yellow Coloured Mesh in R/f Mill no. -4		In white mesh curtain lighting lux level /luminosity increased.
16	SPG M4-6	Cable dressing work at R/f office Mill no. -4.		Cable dressing work complete. Looking attractive and 5S maintained.
17	SPG M4-6	Bin rooms identification & marking in Mill no. -5		Identification & marking of bin rooms . Looking attractive and 5S maintained.
18	SPG M4-6	Made a stopper Stand for top clearer cover on China Simplex in Mill no.5		Made a new iron rod stopper & resolve the Top clearer broken problem & reduced the chances of any accident.
19	SPG M4-6	Made Iron rod frame for main motor of S/f no. -2 of Mill no.5.		Without any civil work Simplex machine started with in one hour after fitting new fabricated iron rod frame.
20	SPG M4-6	Marking & identification of sweeping waste area in Mill no.6		Make identification & marking of sweeping waste zone area. looking attractive and 5 S maintained.
21	SPG M4-6	Marking & identification of Nepco Room in Mill no.6.		Make identification & marking of Nepco room . looking attractive and 5 S maintained
22	SPG M4-6	Marking & identification of Emergency Gate in Blow Room Mill no.6		Make identification & marking of Emergency Gate in Blow Room . looking attractive and 5 S maintained.
23	SPG M4-6	Put safety guard on New Trutzschler Mixing Blender in Mill no -6		Put safety guard on Trutzschler mixing blender & reduced damage & scratches of the m/c.
24	SPG M4-6	Put safety guard on New Trutzschler Blow Room Line in Mill no. -6.		Put safety guard on Trutzschler Blow Room Line & reduced damage & scratches of the m/c.
25	SPG M4-6	Uni spray Pressure switch valve height decrease in Mill no. -6 .		Uni Spray Pressure switch valve height decrease . Easy to reach hand of the operator.
26	SPG M9	RF motor cover open due to improper setting		RF motor cover closed with proper adjustment .
27	SPG M9	RH not maintain due to fast air coming & hands moving may be accident		After partition fast air not coming & hands movement stop .
28	SPG M9	Certain hanging on asbestos sheet with wire.		New angle with hook proper certain hanging system
29	SPG M9	Gap between two partition, contamination may be come.		Gap between two partition close ,stop contamination .
30	SPG M9	Water dropping problem		after valve change water dropping problem end .
31	SPG M9	Slub attachment covered for safety purpose		slub attachment covered in proper way G.I sheet
32	SPG M9	MORE gap formation , with same size spacer so extra advantage in quaqlity		After use this clef improve in quality
33	SPG M9	Gap fill between floor & machine cover		Gap pack with wooden peace .
34	SPG M9	Improper light in mixing bin		After proper light darkness clear & can see any contamination
35	SPG M9	Floor broken		After cementing floor safety improve
36	SPG SJ11	We observe that in poly process high cuts and alarm on LC		So we take trial of bottom roll gauge on RSB 54/65 in place of 54/60,now cuts and alarm are in normal and also uster maintained below-1.70% in RSB
37	SPG SJ11	We observe high running breakage are in hazira fibre RF above (9-10)%		So we increase TPI one step and speed pattern now breakages are in optimum level.
38	SPG SJ11	Initially there is no MO no written in manual hank report so whenever pinter get hang then difficult to feef data in single screen		Now we start to write MO also in report
39	SPG SJ11	We observe that in SF(1-10) top clerer are in loose condition so clearer fly was coming in Roving		Total 367 top clearer attended
40	SPG SJ11	We observe that roving stop motion was not not working on many spindles in RF		So start to find out defective roving stop motion on daily basis and control 50%
41	SPG SJ11	We observe that temp was not maintained by H-plant in CF area due to winter season		So Heater installed in both phase of department
42	SPG SJ11	We observe that top clearer loading problem is high in COTS of 85 degree hardness		So 90 degree hardness cots introduced in hazira fibre RF
43	SPG SJ11	We observe that in RF side door cover glass were missing on many RF		So side glass attended by maint team
44	SPG SJ11	We observe that in many RF pneumafil box locking magnet was missing so door remain open all times.		Now Locking blade introduced to close when not in use
45	SPG SJ11	We observed in 30 PV ring frame have high start up breakage above(4.0 to 4.2)% on 2/O MSHF Rtr		So we switch to 3/O MS HF Rtr and now start up breakages are(2.5 -3.0)%
46	POST SPG M1-6	Cut cone package reduced by placing plastic sheet cover.		Package conveyor belt covered by plastic sheet so cut cone problem resolved.
47	POST SPG M1-6	Dust & fly problem on Empty cones & cheeses racks.		By proper curtaining of empty cones & cheeses racks avoid the dust & fly problems .
48	POST SPG M1-6	Fly & dust problem on cones in non conform racks.		After proper curtaining of racks of non conformance product deposition of fly & dust problem avoided
49	POST SPG M9	To stop packing tray at roller end stopper fixed at packing Line No 1		Stopper has been fixed at roller end of line No 1 to stop packing tray
50	POST SPG M9	Steam heater installed in yarn conditioning room of M9A & 9B		Steam heater has been installed in yarn conditioning room of M9A & 9B to improve yarn moisture %.
51	POST SPG M9	Emergency window opened in Packing Mill No 9		we have opened emergency window in packing Mill No 9 for safety purpose.
52	POST SPG M9	Plastic cone & paper cone kept separately color wise in cone rack		we have kept plastic cone & paper cone color wise separately in cone rack , 5'S ' maintained

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53	POST SPG SJ11	There is no number in Jumbo winding knotter.		Knotter no paste on Jumbo winding knotter for better understanding.
54	POST SPG SJ11	Before we have not check Assembly winder Individual drum weight		We have start to check Individual drum weight of Assembly winder to avoid weight variation problem
55	QAD M 1- 6	Conveyence was arranged from picking Head QA at 1:00 am on 15th Dec from Jaipur where as company conveyence was going to drop some one at 2:30 am , so it was advised to Sh Prasannan for not sending conveyence at 100 am & departure can be made with the conveyence going to drop .	0.02	Managed (One time Saving)
56	QAD M 1- 6	Procured PH Meter was started without calling service engineer .	0.06	Working satisfactory (One time Saving)
57	QAD M 1- 6	To get increased proportion of spliced yarn of 2/9.8's Poly yarn to M/s BSL (IKEA)		To avoid complaints of excess knots , Trial successful in supplied yarn from reconfirm action
58	QAD M 1- 6	Optimized EYC settings for corrective neppy yarn problem in ply yarn		To mark workable complaint involved lot as removal of neppy single in in ply yarn is critical
59	QAD M 1- 6	Identified bad habits of work practices in current status		Identified bad practices were write down in hindi font to work out more awareness among the concern
60	QAD M 1- 6	Non workable Ring Data Bax was replaced from Lab		Unnecessary covered space will be utalized / more open space
61	QAD M 1- 6	Shifted one table from Tensomaxx Instrument		Increased space for free movement / Improved look / House keeping
62	QAD M 1- 6	Shifting Stelometer from entry gate to side		Increased free space at entrance & improved look
63	QAD SJ11 & M9	Prepare card samples of card no 01 & take corrective action against high IPI value of card no-01 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
64	QAD SJ11 & M9	Prepare card samples of card no 03 & take corrective action against high IPI value of card no-0 (Count (Ne)- 1/30s P/V)		Improvement in yarn quality .
65	QAD SJ11 & M9	Check cots damage of all 40 ringframe machine & attend damage cots .		Improvement in yarn quality .
66	QAD SJ11 & M9	Save repair cost of wrap block handle.	0.05	Cost saving Rs 0.05 Lac.
67	QAD SJ11 & M9	Insert aluminum stopper in main gate of QAD SJ-11 for stop gate properly.		Safety
68	QAD SJ11 & M9	Repair open wire cable.		Safety
69	MAINT M1-3	In ultimo roving stop motion wedge not working properly due to screw touch wedge.		New type of self threading screw and roving guide developed
70	MAINT M1-3	There is a chance of missing of wedge of sliver stop motion		There is a chance of missing of wedge of sliver stop motion
71	MAINT M 4-6	LIFE OF 6205 BALL BEARING COMING ONLY 6 MONTH IN G5/1 RING FRAME IN MILL 6 DRAFTING ZONE.		WE MODIFIED THE BR. DRAFT BEARING HOUSING AS LR6 BEARING HOUSING TYPE WITH 6304 BEARING AND NOW LIFE INCREASED 6 TIME MINIMUM, SAVED RS-12000 IN LAST 3 YEAR.
72	MAINT M 4-6	THERE WAS 9 PCS OF ROLL STAND BRACKET DAMAGED BADLY IN S/F 1465 IN MILL 5.		WE REPAIRED THE ROLL STAND BRACKET IN HOUSE AND SAVE RS-10800/
73	MAINT M 4-6	THERE WAS NOT ANY LADDER TO REMOVE SPARE FROM HIGHT IN MILL 4 AC MAINTENANCE ROOM.		WE MADE LADDER IN HOUSE WITH ROBOTIC DOFFER SCRAPPED ALU.BAR.
74	MAINT M 4-6	VICE WAS KEPT ON FLOOR IN AC MAINT ROOM		WE GROUNDED THE VICE IN WALL ABOVE SCRAP BOX FOR WORK WITH SAFTY AND SAVED SPACE ALSO.
75	MAINT M 4-6	WE WERE KEEPING BOTTOM ROLL IN CORNER OF MAINTENANCE ROOM IN MILL 5 R/F		WE GROUNDED THE ANGLE ON WALL TO KEEP THE BOTTOM ROLL WITH SAFTY TO AVOID ROLL OUT.
76	MAINT M 9	Lapping of Loading Roll Of D/F Creel due because of small size .		Loading Roll Of D/F Creel developed in Single piece , now lapping is reduced .
77	MAINT M 9	Spray Pump of Blow Room was without cover and there is chances of accident .		Cover is provided on Spray Pump of Blow room to avoid accidents .
78	MAINT M 9	Crackers are found in Ring Yarn which detoriate yarn Quality		Old Apron Piece is fix on Nose Bar . Crackers are reduced in Ring Yarn and improved yarn Quality .
79	MAINT M 9	Life of Three nos. of seperate V belt was less in Murata 21C Autoconer .		Single Piece of Three V belt used and Life of belt is increased .
80	MAINT M 9	Cover of Jingwei Ring frame Gearing was Damage .		In house developed Cover of Jingwei Ring frame gearing .
81	MAINT SJ11	DUE TO OPEN COVER OF WEIGHING HOOPER CHANCE OF FALL DOWN ANY MATERIAL IS MORE		OPEN PLACE IS COVER WITH GI SHEET
82	MAINT SJ11	SPEED FRAME CLEARER CLOTH RATCHET SPRING BROKEN DURING REPARING ,LOTS OF TIME REQUIRED FOR REPLACING WORN OUT SPRING WITH NEW ONE		WE HAVE DEVELOP A METHOD IN THIS MATHOD WE HAVE NO NEED TO DE ASSAMBLE THE COMPLETE ASSLY AND WE CAN EASILY CHANGE THE SPRING WITH IN MINUTE
83	MAINT SJ11	85 DEGREE HARDNESS COTS ARE USING IN CORSE COUNT , TOP CLEARER LOADING PROBLEM IS COMING		START USING 90 DEGREE HARDNESS COTS IN CORSE COUNT M/C IN PLACE OF 85 TO REDUCE THE TOP CLEARER LOADING TENDENCY
84	MAINT SJ11	CHEESE WDG TENSION FREE DISC NYLONE BUSH WORN OUT REGULARLY		ON THE PLACE OF NYLONE BUSH START USING HEX BOLT.
85	ENGG M1-3	Cable dressing not done in right angle method		After Modification cable dressing done by right angle method
86	ENGG M1-3	QAD Main Power DB Cable Not Dressed properly		After Modification cable dressing work properly
87	ENGG M1-3	CCD out side having unwanted cables		After Modification cable dressing work properly and unwanted cables removed
88	ENGG M1-3	Blow Room door safety having limit switch but that having problem of target jamming		After Modification we installed proximity switch so that jamming problem will be removed now
89	ENGG M1-3	Draw frame was stop due to Spare discard from OEM veeder root counter meter	0.35	After kaizen we installed coretec counter meter and start the machine
90	ENGG M1-3	blow room having jamming problem due to motor not stop suddenly		After kaizen we installed resistance and drive so now that problem not come in blow room
91	ENGG M1-3	Remove dark zone at fire brigade stand		After kaizen we installed two led tube light , so now remove dark zone from here
92	ENGG M1-3	Unwanted Power Junction Removed		After kaizen we removed junction box and cable grouting under ground
93	ENGG M1-3	LT Cable Above main store		After kaizen we dressed that cable properly
94	ENGG M1-3	LED Light in front of store road		After kaizen we installed LED light at the place of before CFL Light .
95	ENGG M1-3	Copper Wounded transformer installed		After kaizen we installed copper wounded transformer so losses having less
96	ENGG M1-3	Zebra marking done at fire extinguisher		After kaizen we done Zebra marking near fire extinguisher.

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97	ENGG M1-3	Working activity and Kaizen suggestion board		After kaizen installed working instruction and suggestion board
98	ENGG M1-3	Key Box		After kaizen made a key box so keys are not lying here and there
99	ENGG M1-3	Telephone Junction Box		After kaizen installed new Plastic MDF Box and did junction properly
100	ENGG M1-3	Auto Coner cover protection		After kaizen installed one clip and provide protection of covers .
101	ENGG M1-3	Savio Polar Display cover		After kaizen installed cover for protection
102	ENGG M1-3	Wiring System improve		After kaizen wiring doing with flexible pipe . And provide safety
103	ENGG M1-3	Simplex Display Cover		After kaizen we provide protection by cover
104	ENGG M1-3	ADM Toilet Exhaust Fan Automatic On/ OFF		After kaizen we installed proximity sensor that will operated when toilet door will open and stop after 03 Min
105	ENGG M4-6	The Power cable joint in the roof of mill no.4 feeding supply to chiller & other near by areas.		Installed New Enclosure box to increase safety.
106	ENGG M4-6	The weighing balance supply is through normal switch socket.		Replace with Industrial switch to increase safety level
107	ENGG M4-6	Very unsafe wiring giving supply to lighting of shed of water conserve tank.		Replaced with industrial plug & with conduit wiring done properly.
108	ENGG M4-6	Observed that the panel light is continuously on for 24 Hours.		Installed one 2 pole MCB to cut it off & can on while working on the panel.
109	ENGG M4-6	EMS Converter installed without protective casing which is unsafe & looking odd		New protective wooden case made up in house by our carpenters & also fitted the cooling fan by our team. Now tottaly safe & looking attractive
110	ENGG M4-6	Old Blender Panel removed by our team.		Installed New Blender Panel by our in house team without calling service engineer & started by ourselves.
111	ENGG M4-6	Machine Inverter Failed & Spare Running Inverter also not running. Machine is stopped .	1	Reverted the old system having double speed motors & control contactors & started the machine.
112	ENGG M4-6	Excessive temperature observed in the Informator panel in Orion machine which results in failure of components in Informator		: Installed One Cooling fan to decrease this temperature in the back side of panel.
113	ENGG M4-6	Package belt started reverse direction but the push button station is not fixed properly & also looks bad.		Fixed these switches at the panel back side with proper fitting. Now looking good & safe.
114	ENGG M4-6	Street light enclosure boxes having no cover.		Replaced with new enclosure boxes with proper joints & coverings
115	ENGG M4-6	DB feeding supply to bachelor mess & all near by places having Fuse fittings & very unsafe wiring .		Installed DB which is removed from carding area with main 200 Amp. MCCB & all outgoing protected by MCB.
116	ENGG M9	Junction box installtion for morning pryer mike.		There was long cable for morning pryer, difficult to lay down daily. We fix a junction box near prayer assenbly and make the work eazier.
117	ENGG M9	Transformer tempreature meter box covering.		Transformer tempreature box galss was broken, we install the acralic sheet to cover up the box.
118	ENGG M9	Maintenance room alley lighting bord removal.		Auto coner maintenance room alley having unusing and broken switch board. We remove that switch board and cover up that with acralic sheet.
119	ENGG M9	Checker plate in LT Room.		There was no cheker plate behind the LT panel of M-9B. We arrange the plate in-house and cover up that area.
120	ENGG M9	Place identification for unrepaired material.		There was no specified area for unrepaired item and they were layin with OK items, Which creat problem during need of that item. Now we make saperate almira to place unrepaired items
121	ENGG M9	Street light conversion with led light.		There were CFL street light near dye house and M-9. Its luminus was very low. Now We replace all those light with LED light.
122	ENGG M9	Light installation on ETP.		There were faulty streat light on ETP. We replace them with removed CFL street light and attend the drakness problem in that area.
123	ENGG M9	MCB Box installtion for lighting in WCS.		There was domestic lighting switch bord near WCS. Which was not good for safety. We replaced that with MCB box.
124	ENGG M9	Supply route change for exhaust fan in dryer.		In dryer section supply wire routing for exhaust fan was going near the floor. Which was not good for safety.We remove that route and take areal rout for that exhaust fan.
125	ENGG M9	Drive installtion for blender of Line-1.		Feed Latics of blender was running with direct supply. That was giving jerk on gear box. We take that on drive supply.
126	ENGG M9	Main cable routing for boiler.		The main cable for boiler was going thorough trench having hot water. That might damage the cable. We take out that cable and laying through other areal route.
127	ENGG M9	Lighting box change in chemical room.		There was old and damaged lighting MCB box in dye house chemical room. We replaced that with new MCB box.
128	ENGG M9	Sensor installtion for coil demand in boiler.		There was no sensor for coil demand sensor in 4 Ton boiler. Due to that operator were facing problem on feeling the coil tank. We install new sensor and make that in circuit for coil demand.
129	ENGG M9	Power repoert for utility consumption.		There was no single sheet to check utility power consumption. We are regularly collecting datas and making power consumption sheet for utility.
130	ENGG M9	Energy Meter installtion on Draw Frame PDB.		There was no meter to check Draw Frame power consumption. We install new energy meter on D/F PDB to monitor draw frame power consumption.
131	ENGG M9	Drive installtion for screw feed on boiler 4 Ton.		Before that coil was feeding directly in 4 Ton boiler. We install drive for screw feder on boiler boiler conversion.
132	ENGG SJ11	There was no any provision to take heavy motors from ground floor to first floor and manual motor lifting was quite unsafe which might cause any mis happening.		We made opening in both South & North phase & fixed a chain block system for safe transportation of heavy motors.
133	ENGG SJ11	In Speed frame, oil dropping from Gear chamber caused all control & power cables viscid & fluff accumulation on the sticky cable.		We have fixed a tray to collect wastage oil of gear chamber.
134	ENGG SJ11	In Ringframe, Siemens HMI display screen visibility got poor.	0.38	We have explored LCD Display & fixed on defective HMI and running successfully.
135	ENGG SJ11	In Ringframe, earlier there was two separate relays for pinter Doffing & Running signal.		We used the LMW machine Running/Doffing signal to avoid malfunction of Pinter system and also spare 2 relay in each machine.
136	ENGG SJ11	Linc Coner CBF Sensor X25C & X27C cable frequently cutting problem.		Guarded the cable by using PU tube & properly dressed.
137	ENGG SJ11	In Transformer room floor became dirty due to oil dropping from busshing, OLTC etc.		We have placed a tray to collect the oil and maintain 5S in Transformer room.
138	ENGG SJ11	IR Compressor temperature increased problem.		Replaced the exiting ventilation window with new modified window

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139	ENGG SJ11	UPS Batteries were not properly placed due to not space in the Batteries stand		We made a stand for UPS batteries to maintain Properly placed & SS.
140	ENGG SJ11	Power Capacitors connected on H plant DBs were not properly placed.		We made a stand for Power Capacitors to maintain SS.
141	ENGG UTILITY	Fabricated a new Line for water drain of 4TPH boiler		We have fabricated a new pipe line for water draining for 4TPH boiler.
142	ENGG UTILITY	Fabricated a new leader & platform on 4TPH boiler.		We have fabricated a new leader & platform on 4TPH boiler
143	ENGG UTILITY	Fix the pressure gauge Properly on 4 TPH Boiler.		We have fix the pressure gauge Properly on 4 TPH Boiler
144	ENGG UTILITY	Fix a new Safety Guard On Pump		We have fabricated a new safety guard and fix it on Pump & Coupling for safety purpose
145	ENGG UTILITY	Fix a new pressure gauge meter on Steam header.		We have fix a new pressure gauge meter on Steam header.
146	ENGG UTILITY	Fix a new G.I. Sheet on Wet oppner Machine.		We have fix a new G.I. Sheet on Oppner machine for safety purpose. By this Sheet now the fiber is not going to inside the machine.
147	ENGG UTILITY	Fix a new G.I. Sheet for safety purpose		Dye house we have fix a new G.I. Sheet for safety purpose
148	ENGG UTILITY	Fabricated properly Line for water drain of LR Tower Trunch water		We have fabricated properly Line for water drain of LR Tower Trunch water.
149	ENGG UTILITY	Fabricated a new properly line of Steam nozzle drain point		Fabricated a new properly line of Steam nozzle drain point
150	ENGG UTILITY	Fabricated a new box for PH Paper		After Kaizen in Rochem 450 KLD plant we have fix a new box for PH paper.
151	ENGG UTILITY	Fabricated a new Cover of blower		In Crusher of boiler we have fabricated a new Cover of blower for safety purpose.
152	ENGG UTILITY	Fix a new Sensor in the bunker of 4TPH Boiler.		In 4TPH Boiler we have fix a sensor in the bunker. & when the bunker is full with the petcock this sensor is Stop the working of crusher.
153	DYE HOUSE	Old unsafe electrical cables in chemical room area.		New cable dressing network
154	DYE HOUSE	MODIFICATION OF CHEMICAL -ROOM		MODIFICATION OF CHEMICAL -ROOM
155	HRD & Training	Yarn quality improvement		Trainers checked disturbed/miss fly catcher in each ringframe of m1 to m9 and gave report,attended by maint
156	IT	P&A user don't know about advanced excel functions i.e. Pivot tables etc., due to lack of knowledge user takes more time during taking summary of deptt. data		Training has been organized and provided to user for advanced excel options i.e. Pivot tables etc., its helpful to user to completed their job in less time frame
157	IT	Earlier there is lot of Error in CAS300, Due to this Balance sheet taking more time, cause delay, Visited to Banswara & create all GL Rule for the Same		After creation of GL rules at BSW, there is no error pending in CAS300
158	Guest House	Railing on Vertical wall on staires		We install steel railing on vertical wall on staires for supporting guest during stairing and avoid dirty of wall .
Total Annualized Amount			1.86	