

**SUCCESS THRO'
JAPANESE MANAGEMENT PRACTICES IN**

**SPINNING
MILLS**



CONSULTANT / ARCHITECT

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JAPANESE 5S PRACTICES



**TO ELIMINATE ‘WASTE’ AND
‘NON-VALUE ADDED’ ACTIVITIES
IN THE SPINNING MILL DAILY
WORK ACTIVITIES FROM THE
RECEIPT OF COTTON TO YARN
DESPATCH.**

5S BENEFITS / RESULTS

TO ACHIEVE THE BUSINESS OBJECTIVES

- 1) PRODUCTIVITY (P)**
- 2) QUALITY (Q)**
- 3) COST (C)**
- 4) DELIVERY (D)**
- 5) SAFETY (S)**
- 6) MORALE (M)**

5S BENEFIT / RESULT - 2023-24

Sl. No	Category	5S Objectives	UQM	Bench - Mark March-2023	Target March - 2024	Result March -2024
1	P	Improving spinning utilization %	%	98.00	98.50%	98.4 ↓
2		Reducing spinning pneumafil waste %	%	0.97	0.80	0.84 ↓
3		Reducing yarn waste % in Auto Coner	%	0.75	0.70	0.72 ↓
4		Improving OE spinning utilization %	%	91.80	97.00	95 ↑
5		Improving GPS index	Grams / Spl	100.95	105	103 ↑
6		Reducing preparatory dept useable waste %	%	0.48	0.35	0.40 ↓
7	Q	Reducing alarm cops rejection %	%	0.89	0.75	0.80 ↓

5S BENEFIT / RESULT – 2023-24

Sl. No.	Category	5S Objectives	UQM	Bench - Mark March-2023	Target March-2024	Result March-2024
8	C	Reduction of maintenance spares inventory	Rs in Lakhs	101.14	90	96 ↓
9		Reduction of packing material inventory	Rs in Lakhs	11.16	10.00	10.4 ↓
10		Reduction of Electrical spares inventory	Rs in Lakhs	10.41	10.00	09.6 ↓
11		Better scrap management	Rs in Lakhs	41.63	44	43 ↑
12	D	Reducing the retrieval time of tools/spares	Sec	34	28	30 ↓

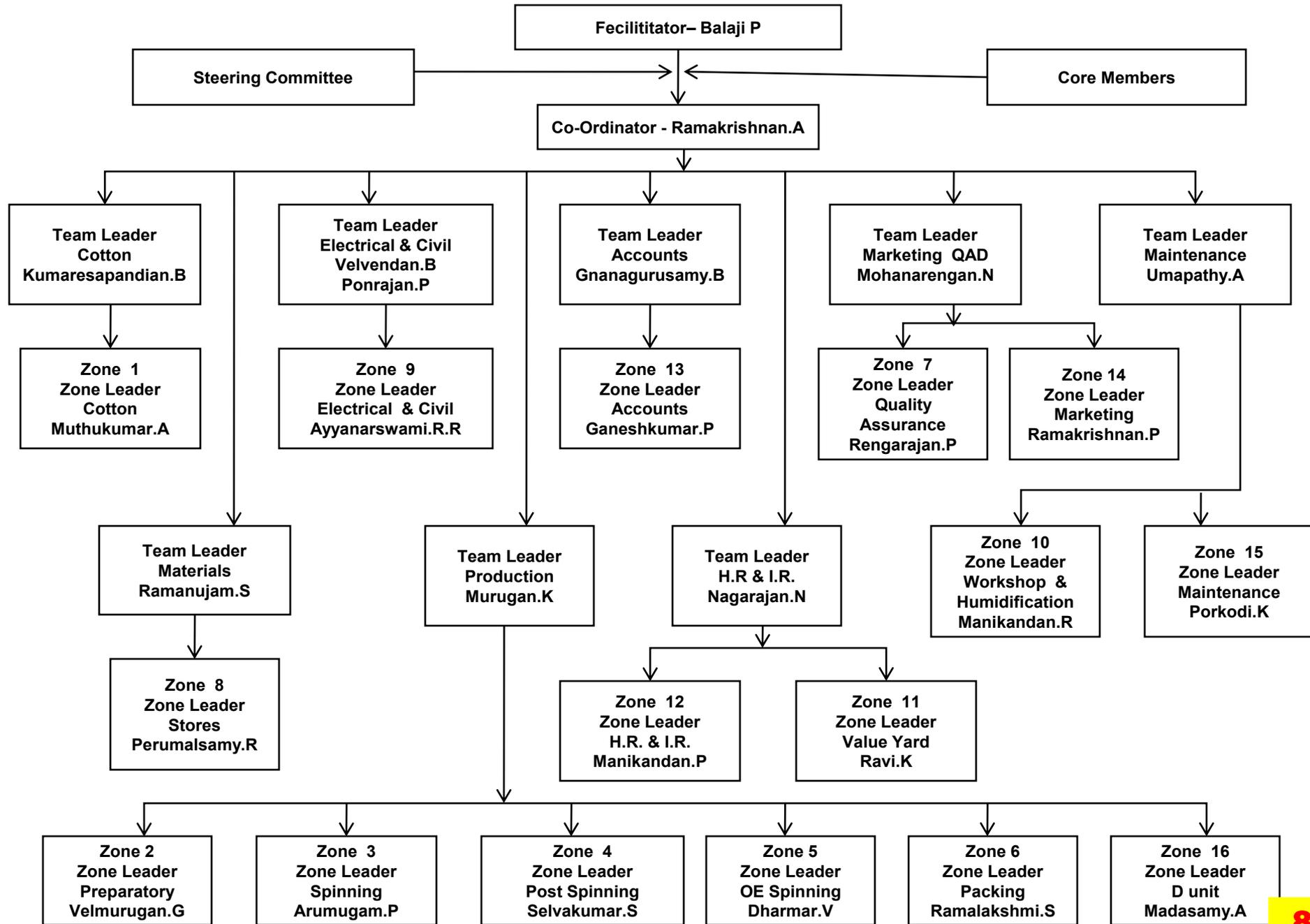
5S BENEFIT / RESULT – 2023-24

Sl. No.	Category	5S Objectives		UQM	Bench-Mark March-2023	Target March-2024	Result March-2024
13	S	Eliminating injury & Accidents	Major	No	1	0	0 ↓
			Minor	No	4	0	0 ↓
			Injury	No	13	0	0 ↓
14	M	Improving morale of the employee		Number per month	148	400	300 ↑

5S ORGANIZATION CHART

**IS PREPARED TO
INVOLVE ALL THE
PEOPLE FOR
ACHIEVING THE
5S OBJECTIVES**

Mill 5S ORGANIZATION CHART



Achieving Mill monthly KRA & 'Key Performance Indicators (KPI)' through 5S OBJECTIVES

S. no	Company KRA (Key Result Area)	KRA is achieved through 5S objectives or target	Responsible zones
1.	Improving spinning utilization %	1.Improving carding efficiency	Zone - 2 Preparatory
		2.Improving Comber efficiency	Zone - 2 Preparatory
		3.Improving simplex efficiency	Zone - 2 Preparatory
		4.By reducing Traveler change time	Zone - 3 Spinning
		5.By Reducing spinning doffing time	Zone - 3 Spinning
		6.By increasing cone winding efficiency	Zone -4 - Post Spinning
		7.By reducing Mechanical breakdown & Electrical Breakdown	Zone 6 & 7 Maintenance & Electrical

Achieving Mill monthly KRA & ‘Key Performance Indicators (KPI)’ through 5S OBJECTIVES

S. no	Mill KRA (Key Result Area)	KRA is achieved through 5S objectives or target	Responsible zones
2.	Reducing spinning pneumafil waste %	1.By reducing the spinning EM	Zone – 3 Spinning
		2.By reducing EBR in spinning	Zone – 3 Spinning
3.	Reducing yarn waste % in Auto Coner	1.By reducing alarm cops rejection in cone winding	Zone – 8 QAD
4	Improving GPS Index	1.By reducing EBR in spinning	Zone – 3 Spinning
		2.By reducing the spinning EM	Zone – 3 Spinning

Achieving Mill monthly KRA & 'Key Performance Indicators (KPI)' through 5S OBJECTIVES

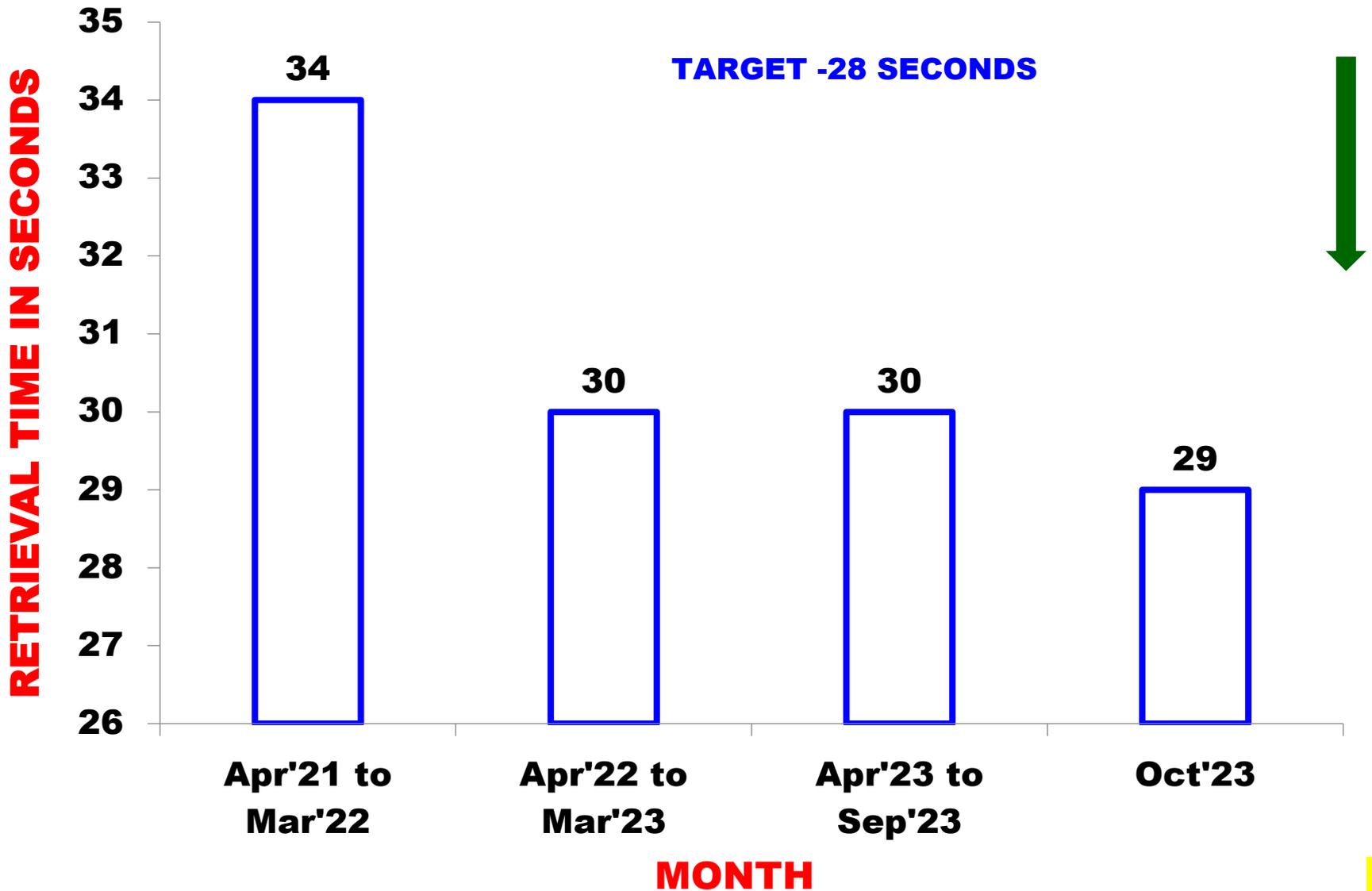
S. no	Company KRA (Key Result Area)	KRA is achieved through 5S objectives or target	Responsible zones
5.	Reducing alarm cops rejection %	1.By improving the cleaning activities in all department	Zone 6 Maintenance & Zone - 8 QAD
6	Reducing the inventory	1.By reducing the maintenance spares , belts & bearing , consumable items.	Zone - 6 Maintenance Zone - 7 Electrical Zone - 10 - Stores
		2.By reducing packing material cost	Zone - 5 Packing

Achieving Mill monthly KRA & 'Key Performance Indicators (KPI)' through 5S OBJECTIVES

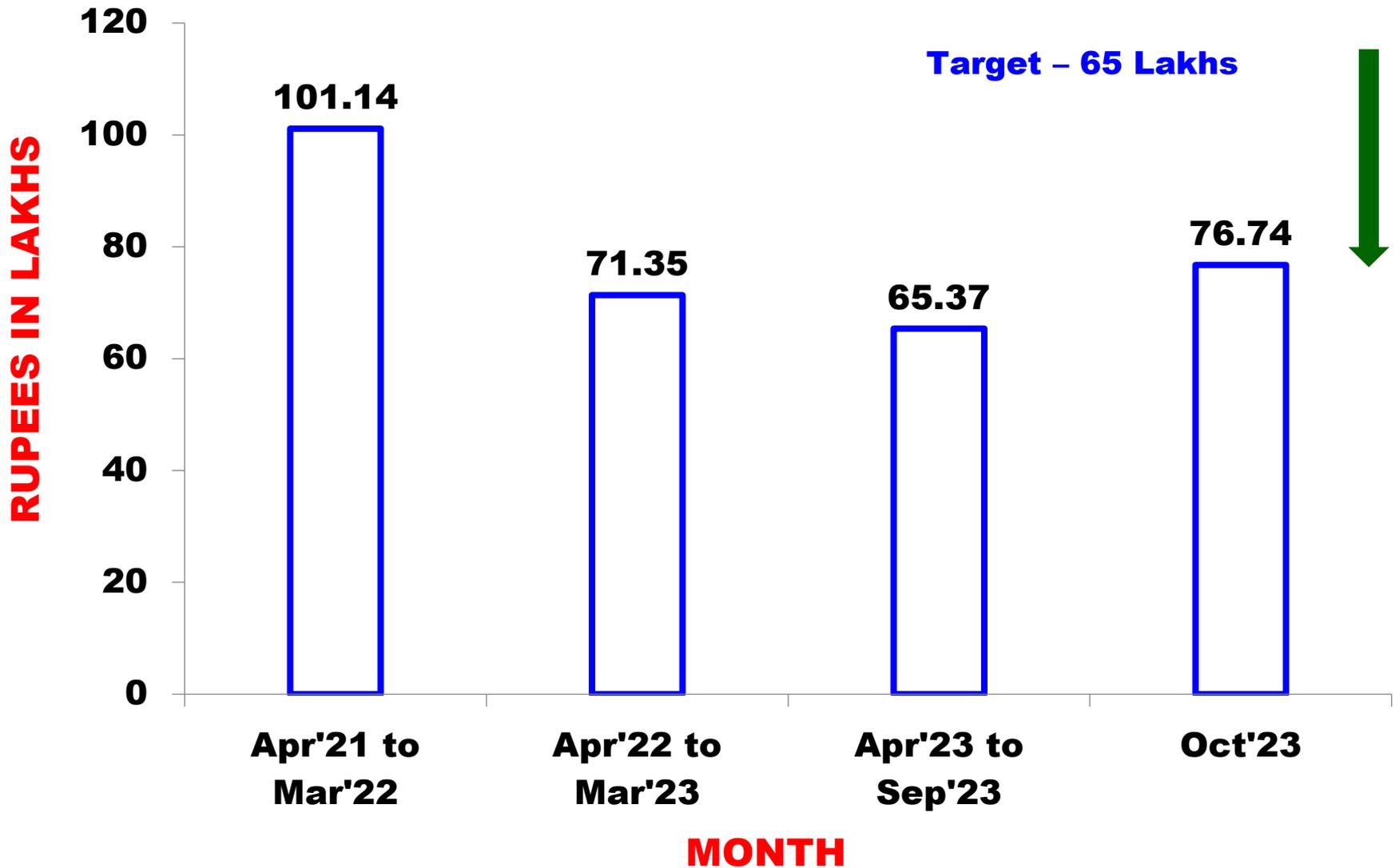
S. no	Company KRA (Key Result Area)	KRA is achieved through 5S objectives or target	Responsible zones
7.	Better Value Yard Management	1.By following disposal plan standards & colour code standards	All zones
8.	Eliminating injuries & Accidents	By improving safe work environment & reducing unsafe act & unsafe condition	All zones
9.	Improving the employees number of suggestions	By motivating & appreciating all the employees	All zones

MONTHLY
5S BENEFITS / RESULTS
FROM
SPINNING MILLS

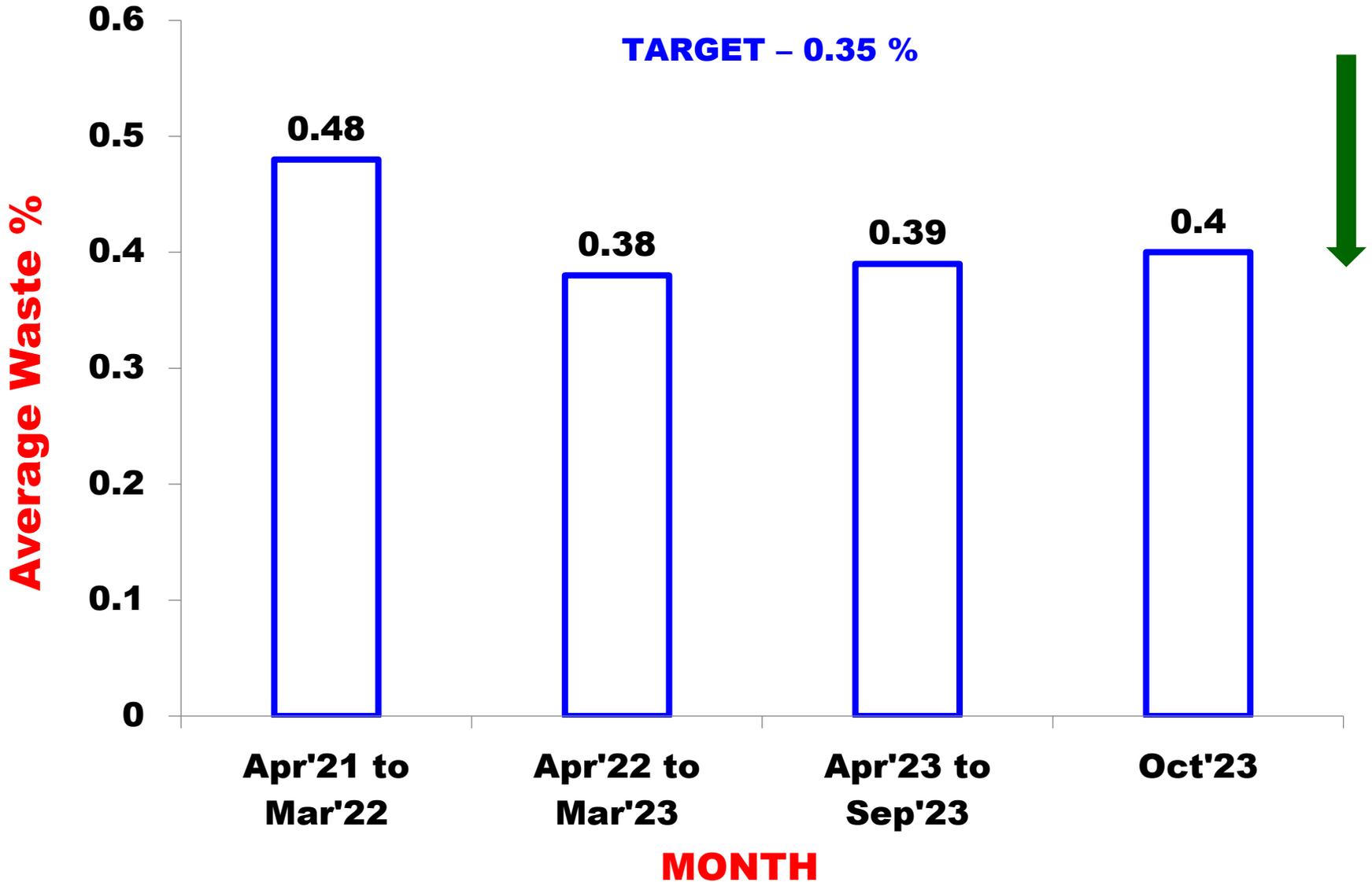
TOOLS & SPARES RETRIEVAL TIME REDUCTION



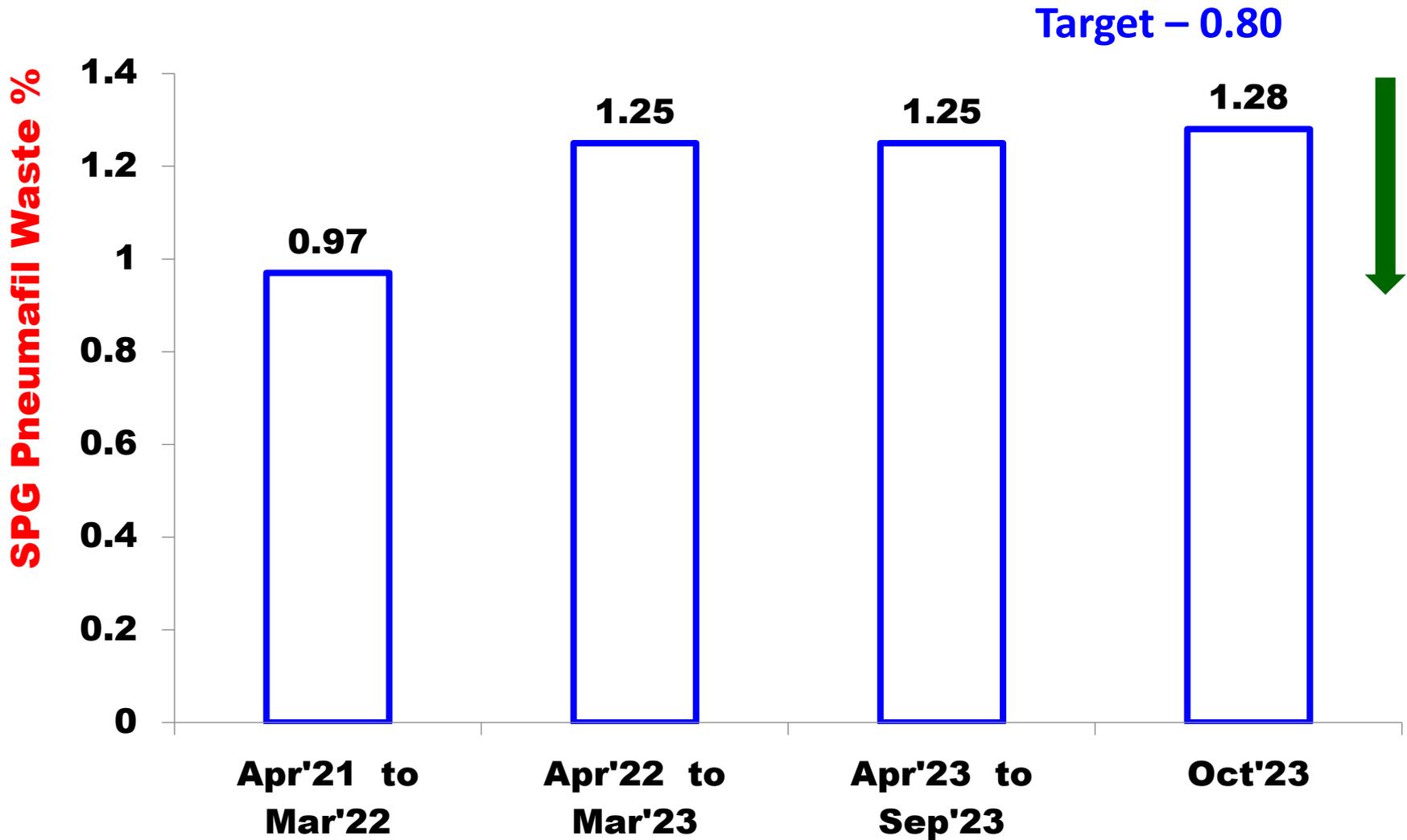
REDUCTION OF MAINTENANCE SPARES INVENTORY



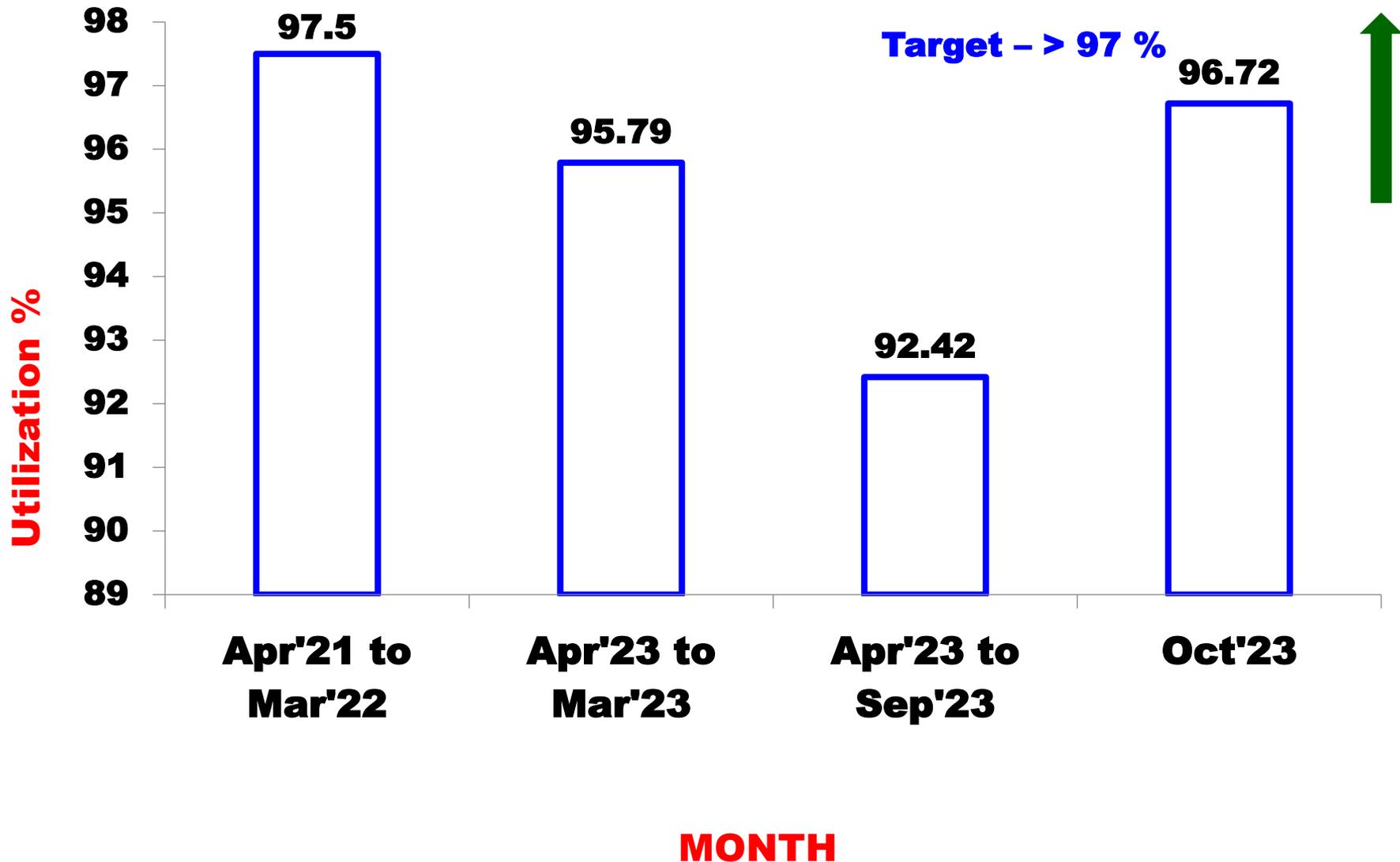
REDUCING USABLE WASTE % IN PREPARATORY



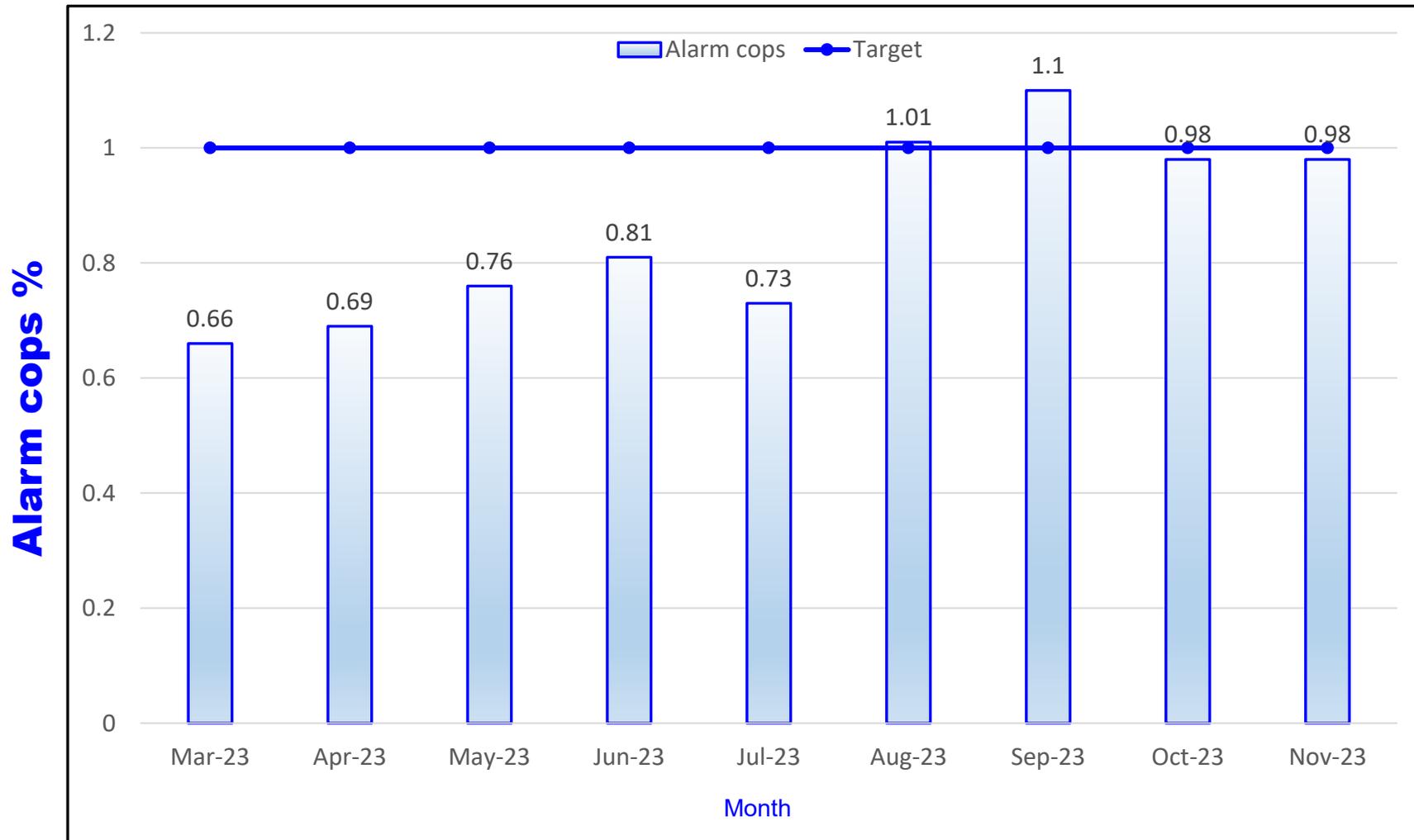
REDUCING SPG PNEUMAFIL WASTE % IN SPINNING



IMPROVING SPINNING UTILIZATION

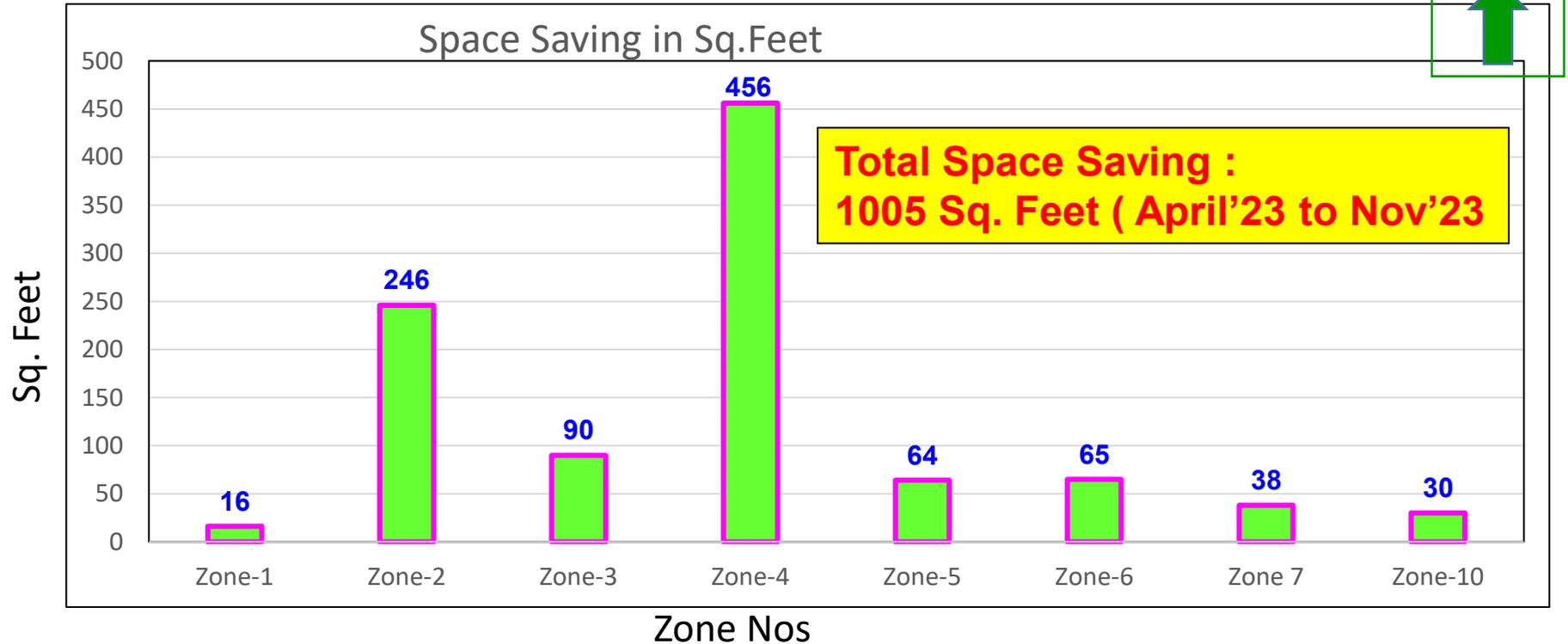


Process material wastage reduction:



1. By continuously following the 3S Activities.
2. By providing SOP
3. By following Do's & Don'ts method.

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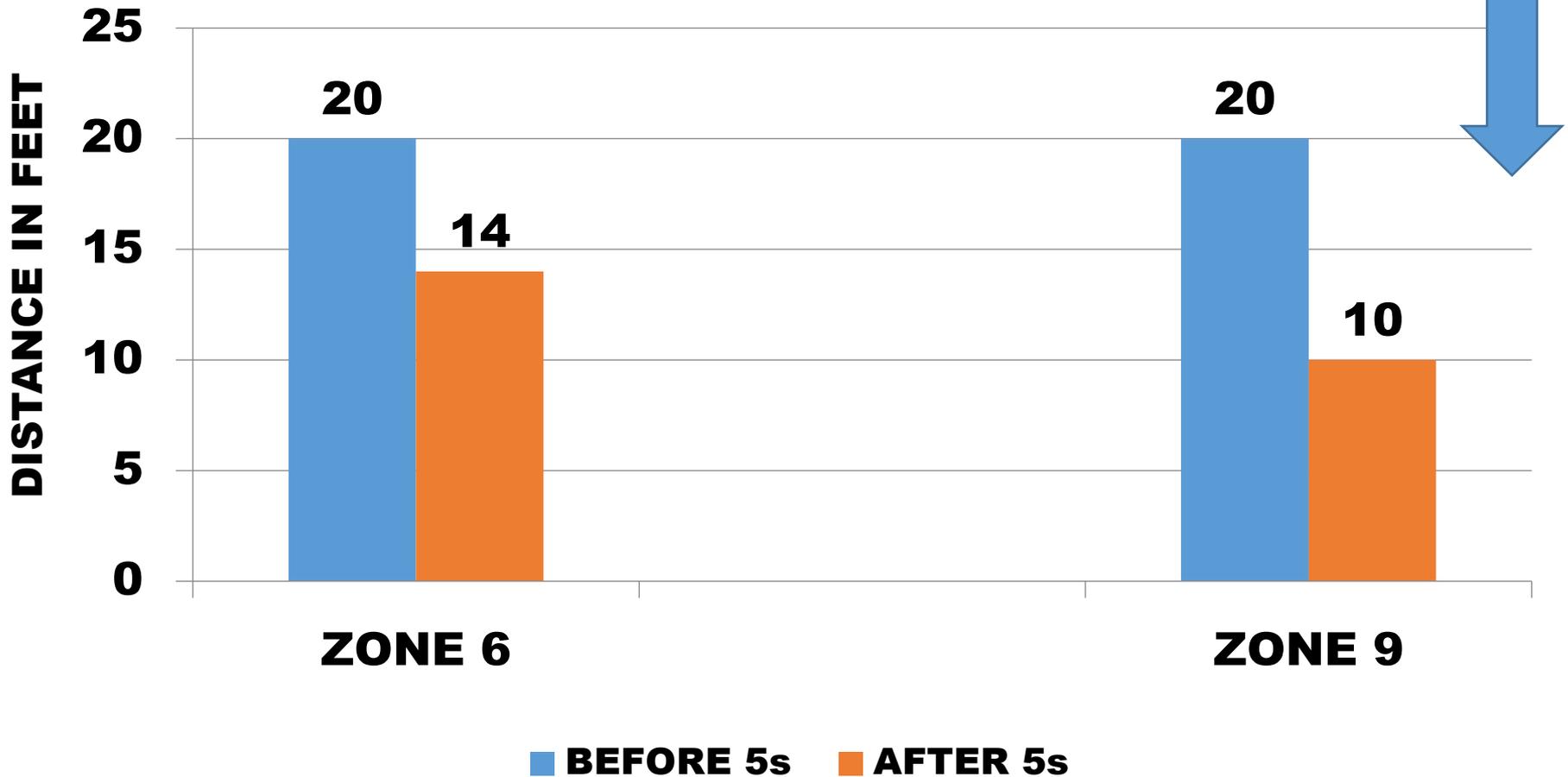


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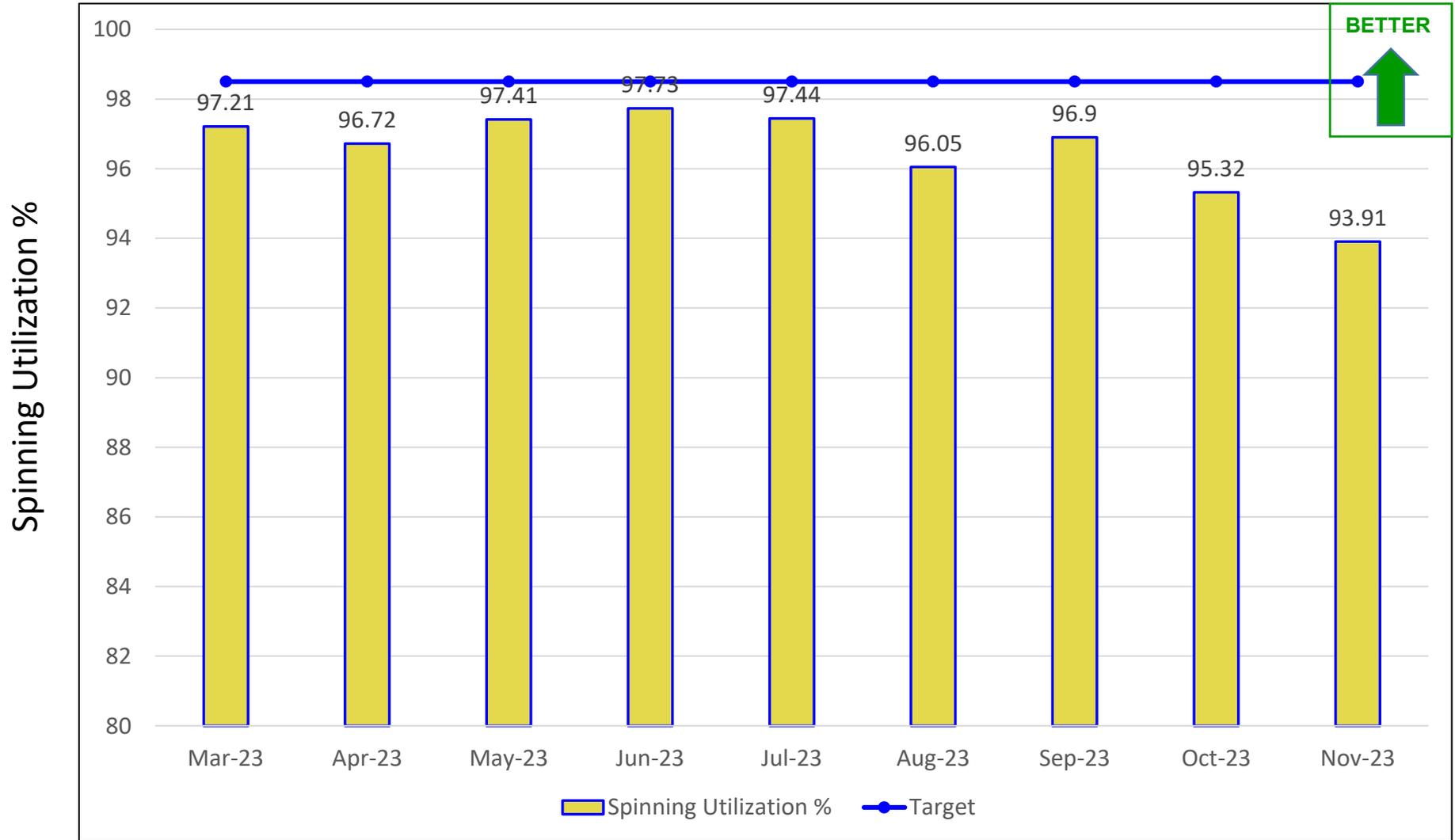
1. Unwanted items removed from departments.
2. Rarely used items moved to Long Term Storage.
3. Grouping and re-arrangement of materials
4. Implementing the vertical storage by providing Racks for empty paper cones, Adass cones and Alarm cops.
5. Providing the separate sheds for Lycra storage , Transport the cones to other mills, Run out bobbins storage . And the same place utilized to respective department's process materials.
6. By optimizing stores inventory , & Rearrange the materials.

REDUCTION OF OPERATOR MOVEMENT DISTANCE

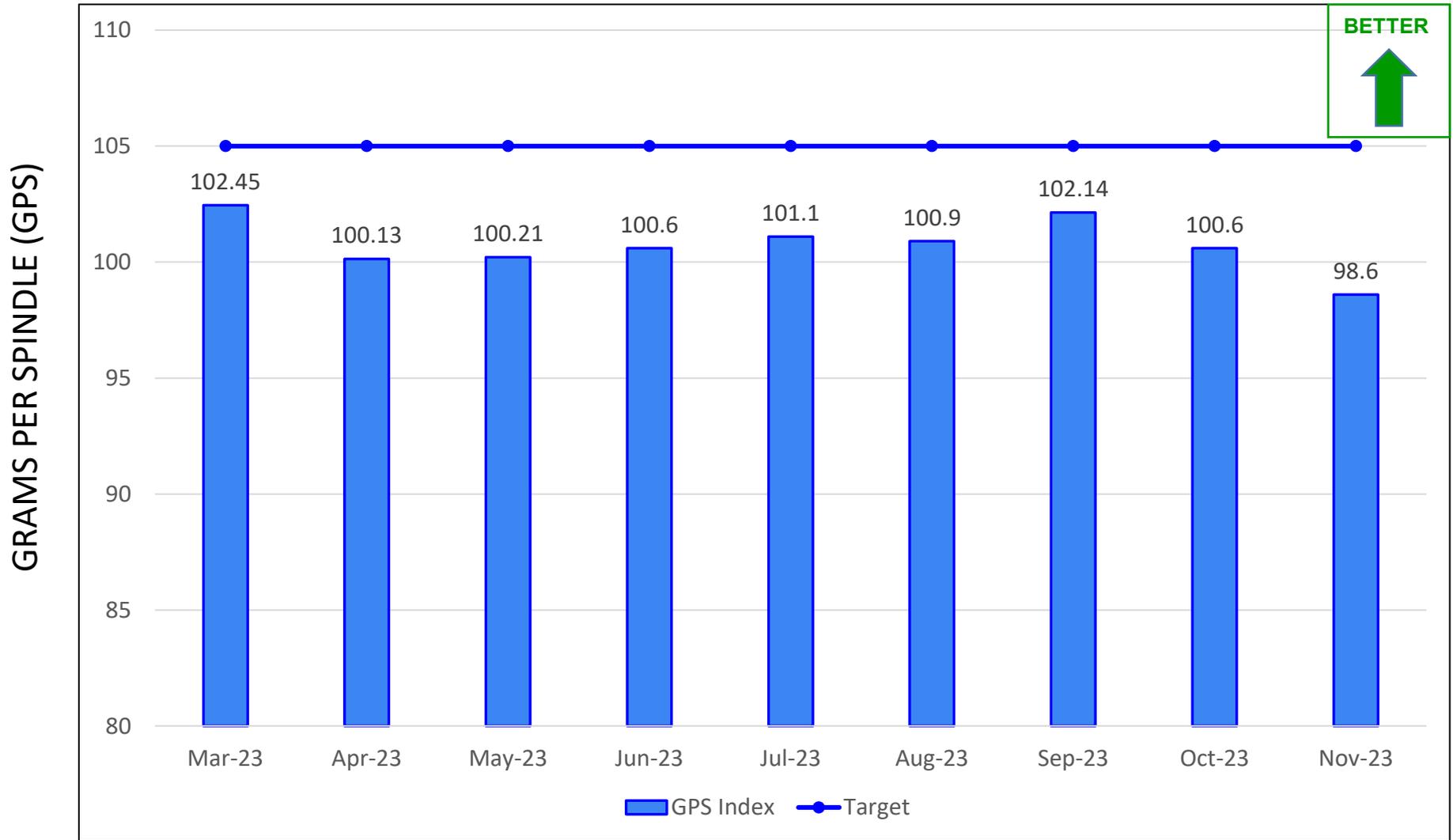
Period : April 2023 to Oct. 2023



Productivity Improvement :



Productivity Improvement :



REVENUE FROM VALUE YARD.

Disposal – Once in 3 Months or
Materials reach the maximum Limit

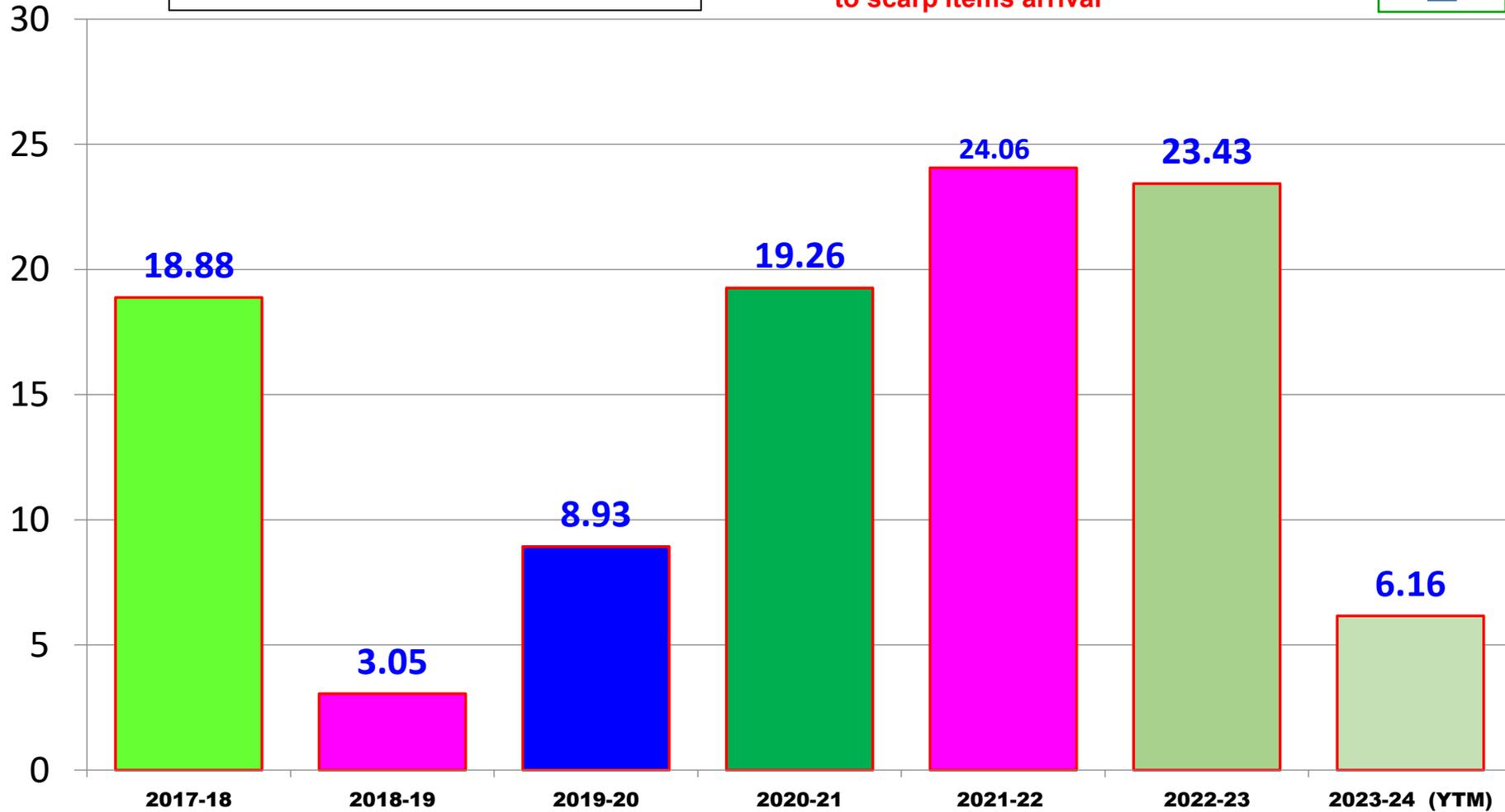
Value yard classification 34 to 57

1. Grouping of scrap items according to Value
2. Fixed Location for Each scrap items
3. By avoiding mix up of scrap materials
4. Revising the Disposal frequency according to scarp items arrival

BETTER



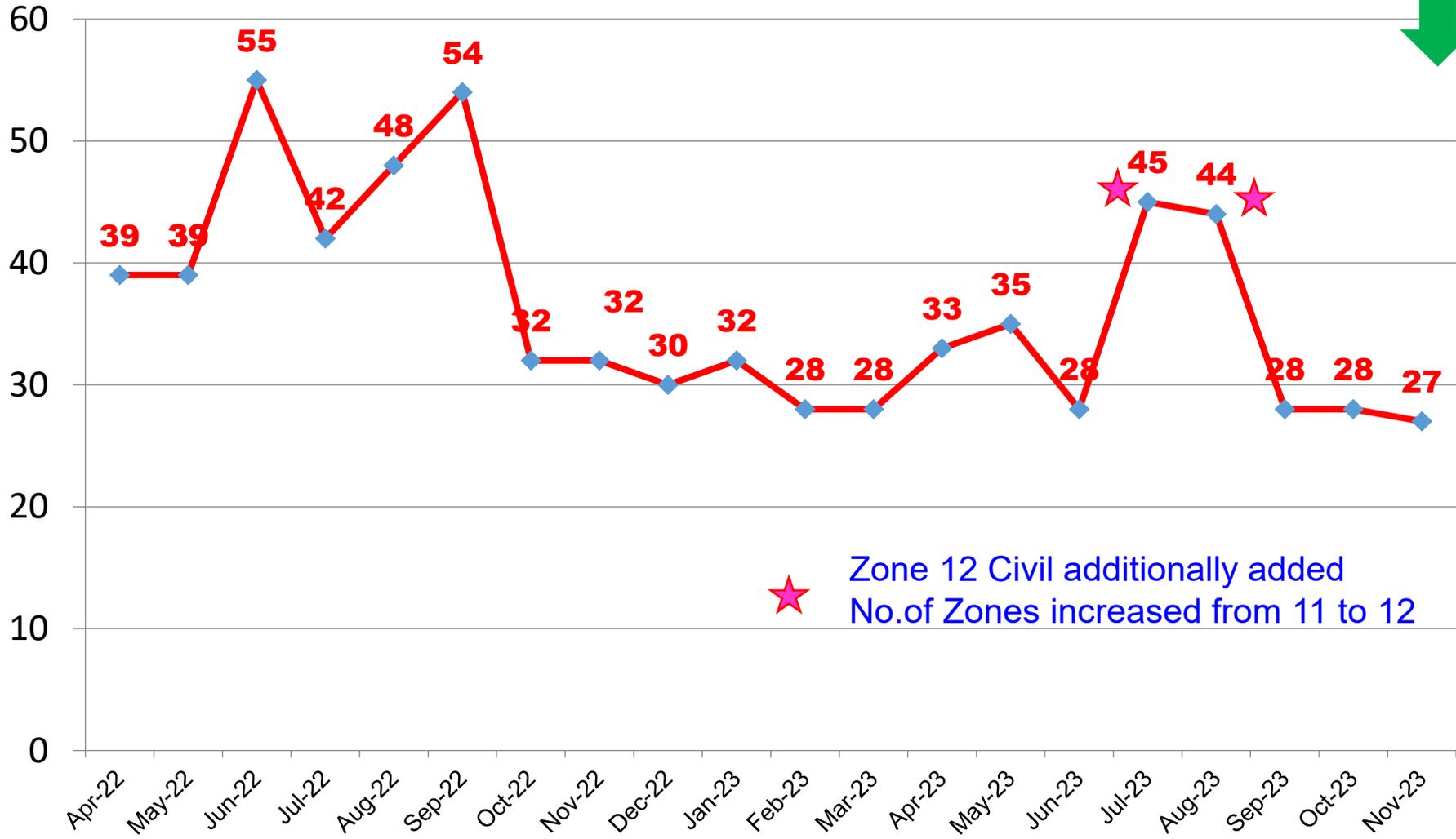
Rs in Lakhs



REDUCTION OF NO.OF DEVIATIONS:

Total No.Of Non conformities for 12 Zones

No. of Deviations



HOW

**THE PEOPLE
ARE INVOLVED
TO ACHIEVE
THE TARGET....**

5S PRACTICES ORIENTATION TRAINING FOR NEW JOINERS



- ❑ We provide 5S Training for All new joiners, both in Class room and On the Job within a month (30 Days) of joining for sustenance.
- ❑ While On the Job Training , we are doing evaluation.

DAILY 5S ACTIVITIES

5S PLEDGE TAKING & STANDING MEETING – 5 MINS (6.55 AM 7.55AM, 8.55 AM, 3.25 PM , 11.55 PM)



5S PLEDGE TAKING



STANDING MEETING



DAILY 5 MINS 5S ACTIVITIES



**5 MINS (7.00 AM
8.00 AM ,
3.30 PM &
12.00 AM)**



INSPECTION :
Checking and
Removing the
Unwanted items



SHINE:
Cleaning the
machine
surrounding
before starting the
work.

SET IN ORDER :
Arranging the lap
cloth properly.

DAILY 5 MINS 5S ACTIVITIES



5S SUSTAINABILITY ACTIVITIES

Daily 5S Self Audit

Daily 5S Self Audit for sustenance.



WEEKLY REVIEW MEETING :



**Zone: 4 – Post Spinning
Every Thursday**



**Zone: 6 – Maintenance
Every Saturday**



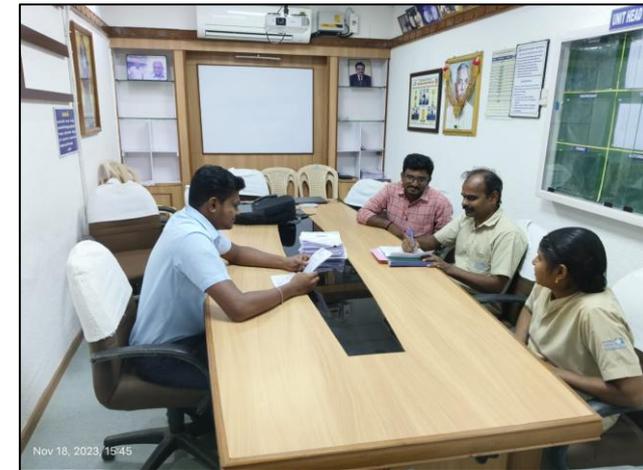
**Zone: 9 – HR & Admin
Every Saturday**



**Zone: 2 – Preparatory
Every Tuesday**



**Zone: 3 – Spinning
Every Wednesday
Time : 3.40 to 4.00 pm**



**Zone: 1 – Cotton
Every Friday**

Venue : Discussion Room-1 & 2

5S STEERING COMMITTEE - MONTHLY REVIEW MEETING



Date:-14.10.2023

Time:-11:00 AM

Venue:- Heinrich Centre

INTERNAL AUDITOR TRAINING - QUARTERLY

We have conducted **5S Auditor Training Program** to our Employees and Staffs at every Quarter to Improve their 5S Audit Knowledge level and **to increase our Number of 5S Internal Auditors.**



MONTHLY INTERNAL CROSS AUDIT BY CERTIFIED AUDITORS



Zone:5 Spinning, 25.10.17



Zone:7 QAD, 25.10.17

PERIODICAL EXTERNAL AUDIT BY CONSULTANT



ZONE NO. : 10 WORKSHOP

ZONE NO. : 14 MARKETING



BEST ZONE AWARD TROPHY

1st PRIZE PRODUCTION ZONE (ZONE - 2,3 PREPARATORY & SPINNING)



1st PRIZE BEYOND THE PRODUCTION ZONE (ZONE - 6 - MAINTENANCE)



2nd PRIZE BEYOND THE PRODUCTION ZONE (ZONE - 8 QAD)



TEI & COMMUNICATION DAY CELEBRATION - Every 10th DATE

