

# ME *Connect*



Bi-monthly Newsletter

Vol. 1 No. 5

## GOLD AWARD



### QCFI

**HYDERABAD CHAPTER**

## From Executive Chairman's Desk:

Dear All,

**We have to work with “Know- how” rather than “Some-how”.**

In present scenario, for Operational excellence to achieve, CME is the only Brahmastra available with us. We all have seen many successful results on “Annual CME day”.

Break down & Rejection are completely a waste & burden on manufacturing units. It eats our hard earned profit. High rejections are mainly due to failure of our defined Process. If our Process owners are alert & sincere towards discharging their duties then surely we will see very few rejections.

At a time when companies are going for Industry 4.0 & other new digital Technologies, we are still struggling on High rejection & Breakdowns. Just see the Bearing consumption in most of the sleeper units. It looks like & replaced so frequently as nut & bolts. Quality Circle & kaizen have to be a routine in units.

We have to be very competitive at all fronts. Group has to adopt World class manufacturing practices, use various tools & techniques of CME & that is only presently available & easily implementable systems with us. You all have no option but to succeed. As a team, we have to face international challenges & keep our head high in all situation.

Plant Operation team & CME have to work together to take forward our organization to next level. It is highly required to be more efficient & cost effective to meet the requirements of ever demanding customer i.e. Railways.

Our team has to be innovative & always think of some improvement.

Each employee has to contribute in a very meaningful way to plant's performance & “Aatmnirbhar Bharat”.

We all have to change our mindset & Patil group has to be a benchmark organization among construction & manufacturing companies.

All the Best.

**L S Patil**

Executive Chairman, Patil Group

## ANNUAL CME DAY

CME has celebrated its first ever Annual CME day on 8<sup>th</sup> Oct 2020.

Journey till date of CME was explained. Various milestones and achievements were shown.

Comparative Plant rating based on performance was shared with all. Some plants have done very appreciable progress on Manufacturing Excellence.

EC sir has explained the Need to improve upon our existing systems by inculcating Tools & techniques of CME. Implementing all the 5 pillars of Manufacturing Excellence will certainly improve plant efficiency.

On this day, plants & individuals were awarded virtually in following categories

Top 3 Quality Circle projects

Top 5 scorers in “Kaushal kranti-2020” online skill competition

Best Safety Plant

Top 5 Manufacturing Excellence coordinators

Best Maintenance plant

Top 3 Quality Circle projects

Gold Award: Reduction of Vibrator burning-Udvada



**Team Udvada**



## Silver Award: Reduction of IS/IT-Kaipadar



Team Kaipadar



## Bronze Award: Reduction of Skip Bucket Breakdown-Gaya



Team Gaya





## Best Safety Plant: Bobbili



**Team Bobbili**



## Best Maintenance Plant

### 1. Kallakal Foundry casting products Pvt. Ltd



**Team Kallakal**



## 2. Patil Rail Infrastructure Pvt. Ltd, Udvada



**Team Udvada**



### Best Coordinator Award:



**1**

**Gyanaranjan Biswal**  
**Kaipadar**



**2**

**Md Minaj Alam**  
**Gaya**



**3**

**Subhrajyoti Paul**  
**Anara**

### SAFETY

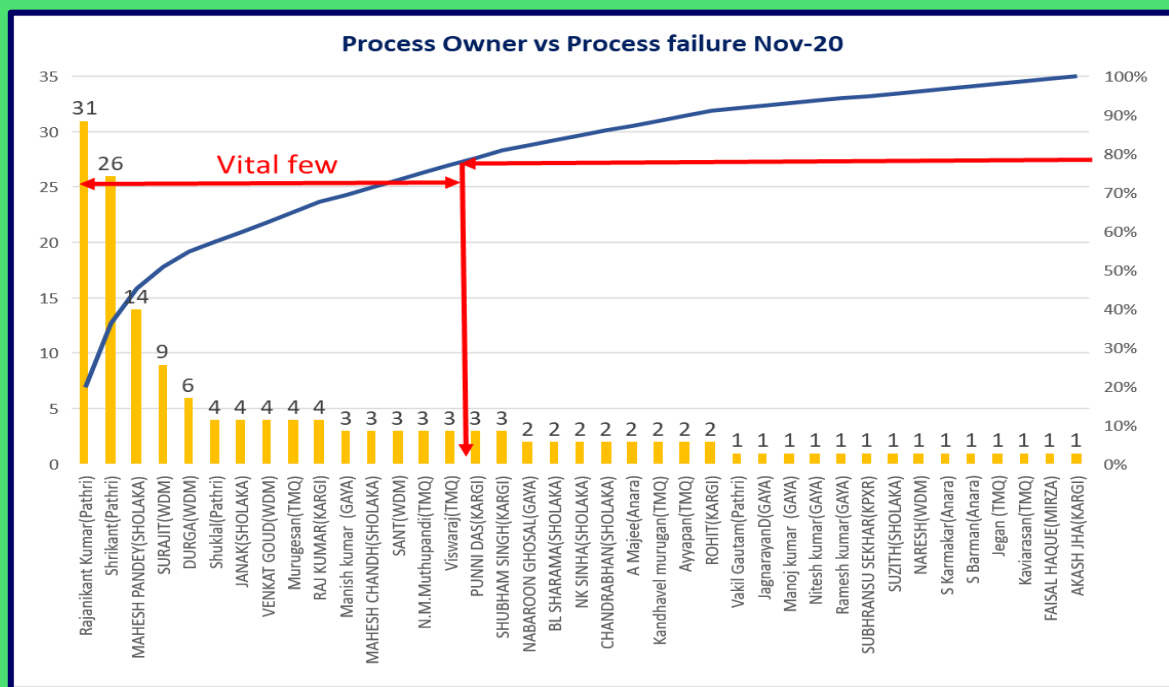
From the Incidents reported from Plants, it is evident that Accident cases has reduced w.r.t. last year. But we all have to be very alert all times so that our individual plant & whole group remains Accident free.



## PROCESS OWNERSHIP

CME along with Quality team has finalized a format where all the Rejection in sleeper plant will be recorded on daily basis & shared daily with CME. Back tracing is done to find out the day & shift of manufacturing & find out the concerned Process owner. Those process owners who has contributed most for the higher rejections will be accordingly counselled, trained, motivated & warned.

Such Process owners who is unable to control Process & causing repeated high rejection will be dealt with severely. Following Pareto chart shows the status in first 3 weeks of November.



## QUALITY CIRCLE PROJECTS

Till now some plants have come up with excellent Quality circle projects which has shown consistent Improvement in Rejection Control, Cost saving & reduction of break downs. They are:

1. Reduction of Vibrator burning
2. Reduction in Breakdown of Screw conveyor
3. Skip bucket down time reduction
4. IS/IT rejection reduction
5. Crack reduction project
6. EB rejection control

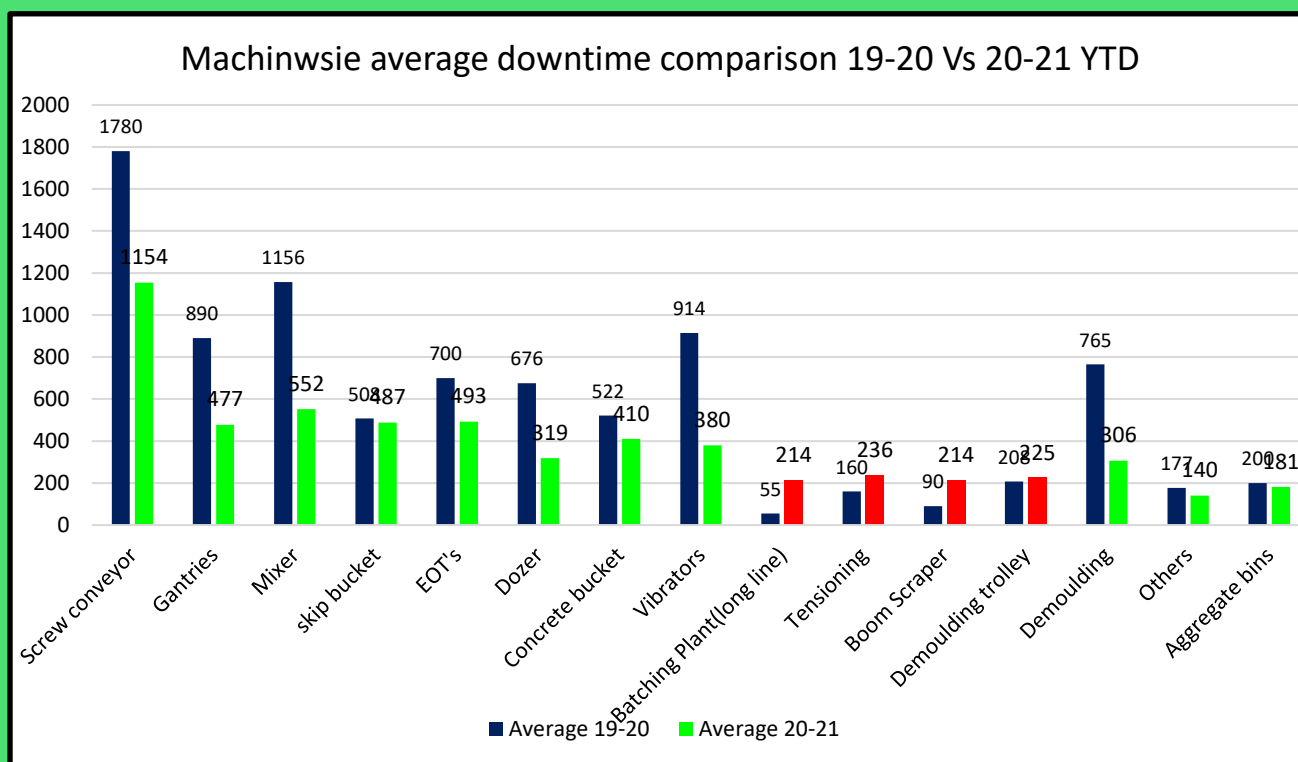
These QC projects have been shared with all sleeper plants for immediate Implementation.

## MACHINE DOWNTIME & FOCUSED MAINTENANCE

Maintenance performance of all plants (Sleeper, Wire & Insert) are reviewed fortnightly by Top management. Breakdown, Root cause & analysis, Bearing Consumption, Vibrator & motor burning, Maintenance cost, Loss of production etc are presented & discussed.

Some plants have improved gradually on overall Maintenance performance in last Quarter. Plants with higher downtime have to catch up & give tough competition to the better performing units.

Plants to focus & implement “Know your machine Concept, Fix responsibility in Maintenance team, Strict PM adherence, Multi skilling, brain storming, Root cause analysis, Training & skill improvement to achieve success on this front.



## KAIZEN

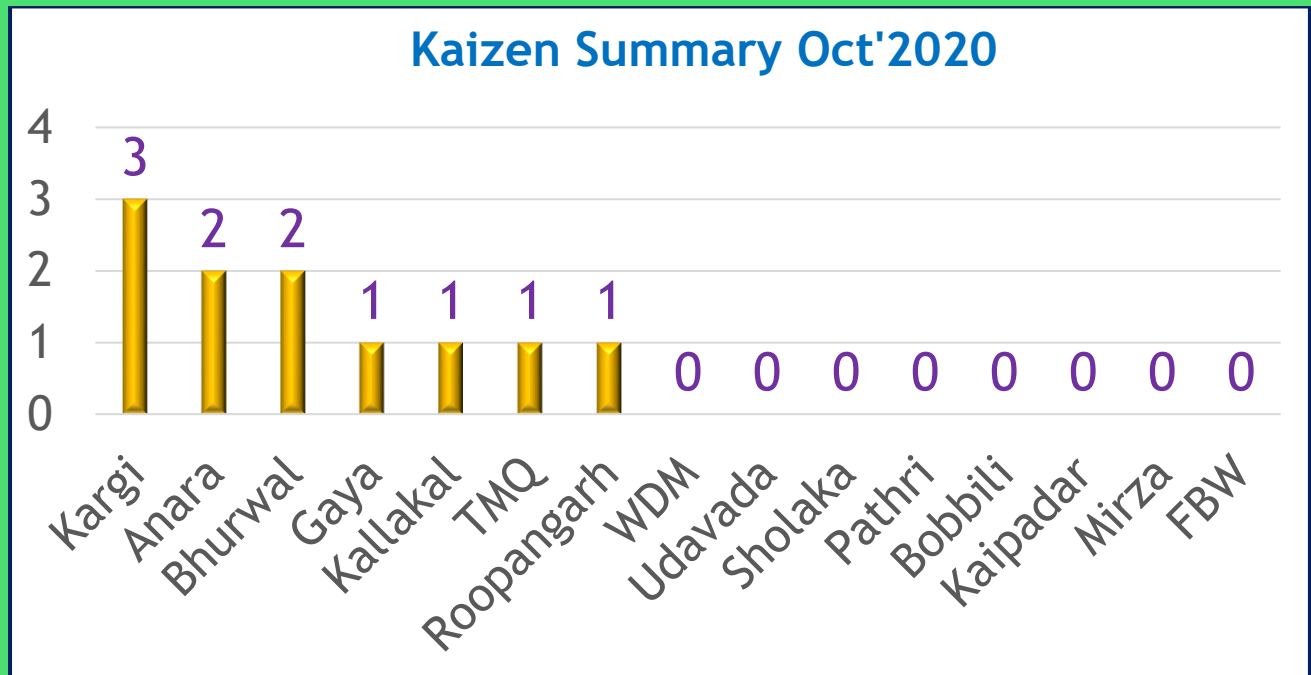
CME had conducted various online training program on KAIZEN with every plant.

Some very good & impressive Kaizens are completed which have improved in Productivity,

Saving in Time & manpower, Innovative Reuse of scrap by maintenance team, In-house developed indigenous parts & eliminated dependency on suppliers.



All plants have to be hell-bent on thinking, Brainstorming & come up with implementable ideas. Target is to generate 2 kaizens per manufacturing unit



- Kallakal: Mfg of belt conveyor in-house
- Burhwal: In-house pedestal manufacturing
- Burhwal: Liner plate bending M/C in-house
- Kargi: Mfg of sand seave by Helical spring
- TMQ: stamping system on Sleeper
- Anara: End plate straightness checking fixture

## TRAINING & DEVELOPMENT

When any employee first starts working in a company, they must receive classroom & on-the-job training that will help them learn what is expected of them as well as the job skills necessary for their new position.

Training always help employees fit perfectly in to their Upcoming or Current role. Patil group has always high focus on Training & development of Employees.



## KAUSHAL KRANTI ONLINE SKILL COMPETITION

“Kaushal kranti 2020”, an online skill competition of all Plant employees of Patil group including plant heads to supervisor level were conducted. Before conducting this test, elaborate Training on all the Tools & techniques of CME were given.

Top five scorer got awarded with ₹2000 & skill certificate. Total 162 participates participated across group in which 128 participants got more than 50% marks.

Retest were conducted for the employee who could not make it first attempt.

Top five Scorer:

 <b>1<sub>Rank</sub></b> <b>Rakesh Kumar</b> <b>Kallakal</b>	 <b>1<sub>Rank</sub></b> <b>Manoj Mal</b> <b>Bokaro</b>	 <b>2<sub>Rank</sub></b> <b>Harsh Kapadia</b> <b>Burhwal</b>	 <b>3<sub>Rank</sub></b> <b>Manjit Panda</b> <b>Bobbili</b>
 <b>3<sub>Rank</sub></b> <b>Gyanaranjan Biswal</b> <b>Kaipadar</b>	 <b>3<sub>Rank</sub></b> <b>Devraj Thakur</b> <b>Kaipadar</b>	 <b>4<sub>Rank</sub></b> <b>Raja Randeep</b> <b>FBW</b>	 <b>5<sub>Rank</sub></b> <b>Aditya Behera</b> <b>Kargi</b>

## GOOD PERFORMING PLANT

Kallakal has performed relatively better in the month of October'2020, with some ever highest figures.

Every plant is advised to publish their plant performance & special achievements for the month.

Kallakal Performance Report OCT-2020	
Production	6.84 Lac ( RT 381: 2.97 L & RT 6901 : 3.86 L)
Quality	RT 381 : 3.09 % ( Quantity Tested : 2.86 Lac )
	RT6901: 2.76 % ( Quantity tested : 3.69 Lac)
Maintenance	Total B/D 1.4 % ( 605 minutes)
	Electrical - 240 Mints ( 0.6% )
	Mechanical- 365 Mints ( 0.8% )
Dispatch	7.06 Lac Insert
Packed	1.1 Million insert
Quality Circle	Mould Box repair & maintenance completed
Kaizen	Two Kaizen has been completed
	1. Belt conveyor 2. RT 381 12 cavity to 14 cavity



## QCFI CCQC GOLD AWARD

CME had participated in QCFI Hyderabad chapter of Quality Circle competition. Project on “Screw conveyor breakdown reduction” from UDVADA plant was our participating Entry.

Chapter Convention on Quality Concept was organized for participants from Andhra Pradesh & Telangana state. Many organizations participated with their Quality circle projects.

Our organization have been awarded GOLD & Now we are eligible for participating in NCQC-2020 which is a National Level competition.



## NEW ACQUISITION

Patil Group has acquired Apna Technologies & Solutions Pvt Ltd (“ApnaTech”), the Company is into a business of development and manufacturing of digital railway track diagnosis solution like Wheel Impact Load Detectors, Hot Box Detectors, Acoustic Bearing Detector and On-Board Systems etc., to Indian Railways. ApnaTech has majority of market share in the Railway Wayside System market and PRIL partnership will help in retaining the spot as the market grows.



ApnaTech Hot Box Detector System APNATech Wheel Impact Load Detector  
PRYJ/NCR System AGC/NCR

Apna Technologies & Solutions (ApnaTech), designs, develops, manufactures and maintains Integrated Technology Products & Systems that improves and increases Safety and Efficiency of assets in Railways. ApnaTech is the First company India to Install wayside systems like Wheel Impact Load Detectors & Hot Box Detectors in Indian Railways Network.

This new partnership adds additional strength to ApnaTech in Implementing Indigenous Technologies & Solutions in India and aligns with Government of India's goal Atmanirbhar Bharat.

## PLANT RATING CRITERIA

Plant ratings Based on the individual plant performance on all the 5 Pillars of CME, Response & communication are done. Different weightage are given to every pillar. Every plant can more or less rate themselves based on the work progress on Manufacturing Excellence. Final rating is given by CME and Plant can check their score achieved in a very transparent way.

SI No	Category	Weightage
1	Safety	7%
2	5S	7%
3	Quality Circle (linked with savings & improvements)	20%
4	Focused Maintenance (Linked with downtime %)	17%
5	Process Ownership (linked with rejection %)	17%
6	T&D	10%
7	Kaizen (linked with savings & improvements)	17%
8	Communication & Response	5%

## UPCOMING CME PLAN & PROGRAM

1. Annual Training program on Skill up gradation to Maintenance team.  
This will be held in the month of January'2021 at our Training Centre at Kargi. Various industry experts on Bearing, Motors, generator, Compressor, Vibrators, VFD function, Transformer, boiler etc from SKF, Kirloskar, L&T will be the trainers.
2. Manufacturing Excellence to be launched at New Insert plant & wire plant @ Bokaro, Hubli unit.
3. Re-launch of Manufacturing excellence @ ACPL & Roopangarh
4. CME audits
5. 5S certification through QCFI to Top 5 scorers in upcoming online knowledge & skill test.