

QUALIFICATIONS PACK - OCCUPATIONAL STANDARDS FOR TEXTILE SECTOR

What are Occupational Standards(OS)?

- OS describe what individuals need to do, know and understand in order to carry out a particular job role or function
- OS are performance standards that individuals must achieve when carrying out functions in the workplace, together with specifications of the underpinning knowledge and understanding

Contact Us:

Textile SSC

E-mail: ceo@texskill.in



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Introduction

Qualifications Pack – Fitter - Autoloom Weaving Machine

SECTOR: TEXTILE

SUB-SECTOR: WEAVING

OCCUPATION: MAINTENANCE

REFERENCE ID: TSC/Q 2402

ALIGNED TO: NCO-9002 / 7233.46

Brief Job Description: An autoloom Weaving Machine Fitter, is a job-role in a weaving department. The responsibility of autoloom Weaving Machine Fitter is to Maintain the loom efficiently so as to get maximum output with minimum defects , with less cost of production giving due importance to safety and environment aspects.

Personal Attributes: A autoloom Weaving Machine Fitter should have good eyesight, eye-hand coordination, motor skills and vision including near vision, distance vision, colour vision, peripheral vision, depth perception and ability to change focus).

Job Details	Qualifications Pack Code	TSC/Q 2402		
	Job Role	Fitter - Autoloom Weaving Machine		
	Credits (NSQF)	TBD	Version number	1.0
	Sector	Textile	Drafted on	15/12/14
	Sub-sector	Weaving	Last reviewed on	21/01/15
	Occupation	Maintenance	Next review date	01/03/16
Job Role	Fitter – Autoloom Weaving Machine			
Role Description	To run autoloom weaving machine efficiently so as to get maximum output with minimum defects, giving due importance to safety & environmental aspects.			
NSQF level	5			
Minimum Educational Qualifications	Preferably Class 10th			
Maximum Educational Qualifications	NA			
Training (Suggested but not mandatory)	Preferably training in weaving department.			
Experience	Not essential			
National Occupational Standards (NOS)	<p>Compulsory:</p> <ol style="list-style-type: none"> TSC/N 2403 (Taking charge of shift and handing over shift to fitter) TSC/N 2404 Maintaining Autoloom Weaving Machine TSC/N 9001(Maintain work area, tools and machines.) TSC/N 9002 (Working in a team) TSC/N 9003 (Maintain health, safety and security at work place.) TSC/N 9004 (Comply with industry and organizational requirements.) <p>Optional: Not Applicable</p>			
Performance Criteria	As described in the relevant OS units			

Table 1: Glossary of Key Terms

Keywords /Terms	Description
Definitions	Sector is a conglomeration of different business operations having similar businesses and interests. It may also be defined as a distinct subset of the economy whose components share similar characteristics and interests.
Sub-sector	Sub-sector is derived from a further breakdown based on the characteristics and interests of its components.
Vertical	Vertical may exist within a sub-sector representing different domain areas or the client industries served by the industry.
Occupation	Occupation is a set of job roles, which perform similar/related set of functions in an industry.
Function	Function is an activity necessary for achieving the key purpose of the sector, occupation, or area of work, which can be carried out by a person or a group of persons. Functions are identified through functional analysis and form the basis of OS.
Sub-functions	Sub-functions are sub-activities essential to fulfill the achieving the objectives of the function.
Job role	Job role defines a unique set of functions that together form a unique employment opportunity in an organization.
Occupational Standards (OS)	OS specify the standards of performance an individual must achieve when carrying out a function in the workplace, together with the knowledge and understanding they need to meet that standard consistently. Occupational Standards are applicable both in the Indian and global contexts.
Performance Criteria	Performance Criteria are statements that together specify the standard of performance required when carrying out a task.
National Occupational Standards (NOS)	NOS are Occupational Standards which apply uniquely in the Indian context.
Qualifications Pack Code	Qualifications Pack Code is a unique reference code that identifies a qualifications pack.
Qualifications Pack(QP)	Qualifications Pack comprises the set of OS, together with the educational, training and other criteria required to perform a job role. A Qualifications Pack is assigned a unique qualification pack code.
Unit Code	Unit Code is a unique identifier for an OS unit, which can be denoted with either an 'O' or an 'N'.
Unit Title	Unit Title gives a clear overall statement about what the incumbent should be able to do.

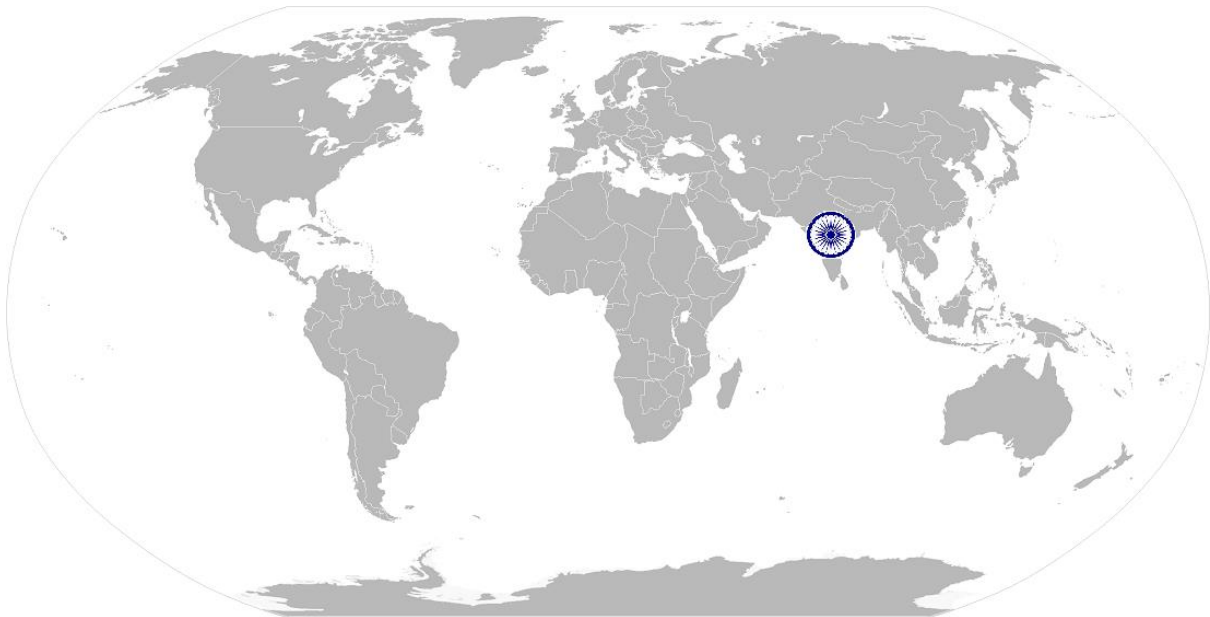
Description	Description gives a short summary of the unit content. This would be helpful to anyone searching on a database to verify that this is the appropriate OS they are looking for.
Scope	Scope is the set of statements specifying the range of variables that an individual may have to deal with in carrying out the function which have a critical impact on the quality of performance required.
Knowledge and Understanding	Knowledge and Understanding are statements which together specify the technical, generic, professional and organizational specific knowledge that an individual needs in order to perform to the required standard.
Organizational Context	Organizational Context includes the way the organization is structured and how it operates, including the extent of operative knowledge managers have of their relevant areas of responsibility.
Technical Knowledge	Technical Knowledge is the specific knowledge needed to accomplish specific designated responsibilities.
Core Skills/Generic Skills	Core Skills or Generic Skills are a group of skills that are key to learning and working in today's world. These skills are typically needed in any work environment. In the context of the OS, these include communication related skills that are applicable to most job roles.
Helpdesk	Helpdesk is an entity to which the customers will report their IT problems. IT Service Helpdesk Attendant is responsible for managing the helpdesk.
Keywords /Terms	Description
SSC	Sector Skill Council
OS	Occupational Standard(s)
NOS	National Occupational Standard(s)
QP	Qualifications Pack
NSQF	National Skill Qualification Framework
NCO	National Classification of Occupations
TBD	To Be Determined
TSC	Textile Sector Skill Council
NSDC	National Skill Development Corporation

Acronyms

TSC/N 2403

Taking charge of shift and handing over shift to fitter

National Occupational Standard



Overview

This unit is about taking charge of shift from previous shift fitter and relieving the responsibilities to the next shift fitter

TSC/N 2403

Taking charge of shift and handing over shift to fitter

Unit Code	TSC/N 2403
Unit Title (Task)	Taking charge of shift and handing over shift to fitter
Description	This unit is about taking charge of shift from previous shift fitter and relieving the responsibilities to the next shift fitter
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> ▪ To take charge of shift from previous shift fitter ▪ To hand over the shift to next shift fitter
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
To take charge of shift from previous shift fitter	<p>To be competent, you must be able to:</p> <p>PC1. come at least 15 – 20 minutes earlier to the work spot</p> <p>PC2. ensure that the necessary tools, gauges etc, are in place.</p> <p>PC3. meet the previous shift fitter, discuss with him regarding the issues faced by him with respect to the quality or production or spare or safety or any other specific instruction etc.</p> <p>PC4. check for the availability of the weft & the condition of the same</p> <p>PC5. check the condition of the running beams , for cross ends, ends pulling out particularly at the selvedge</p> <p>PC6. take “ rebound round” of the allotted looms</p> <p>PC7. check the shuttle condition in the allotted looms</p> <p>PC8. note down the break downs</p> <p>PC9. check for the size of the cloth rolls & to see whether any indication is there in the cloth rolls</p> <p>PC10. check the cleanliness of the machines & other work areas</p> <p>PC11. check whether any spare/raw material/ tool / fabric/ any other material are thrown under the machines or in the other work areas.</p> <p>PC12. question the previous shift fitter for any deviation in the above and bring the same to the knowledge of his/ her shift superior as well that of the previous shift as well.</p>
To hand over the shift to next shift fitter	<p>PC13. hand over the shift to the incoming fitter in a proper manner & get clearance from the incoming counterpart before leaving the work spot</p> <p>PC14. report to his shift superiors as well as that of the incoming shift, in case his/ her counterpart doesn't come for the incoming shift. in that case, the shift has to be properly handed over to the incoming shift superior & get clearance from him before leaving the work spot</p> <p>PC15. report to his shift superior about the quality / production / safety issues/ any other issue faced in his/ her shift and should leave the department only after getting concurrence for the same from his/ her superiors</p>
Knowledge and Understanding (K)	
A. Organizational Context (Knowledge of the company/	<p>The individual on the job needs to know and understand:</p> <p>KA1. the organization's policies & standard operating procedures (SOP)</p> <p>KA2. have an awareness, knowledge of customers</p> <p>KA3. potential hazards associated with the machines and the safety precautions</p>

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organization and its processes)	<p>must be taken</p> <p>KA4. protocol to obtain more information on work related tasks</p> <p>KA5. contact person in case of queries on procedure or products and for revolving issues related to defective machines, tools, materials & equipments</p> <p>KA6. details of the various job rolls & responsibilities</p> <p>KA7. documentation and reporting formats</p> <p>KA8. work targets & review machine with superiors</p> <p>KA9. protocol and format for reporting work related risks/ problems</p> <p>KA10. method of obtaining /giving feed back with respect to performance</p> <p>KA11. importance of team work .harmonious working relationships</p> <p>KA12. process for offering /obtaining work related assistance</p> <p>KA13. responsibilities under health, safety and environmental legislation</p> <p>KA14. guidelines for storage & disposal of waste materials</p>
B. Technical/Domain Knowledge of product	<p>KB1. the user/individual on the job needs to know and understand:</p> <p>KB2. the minimum quality requirements of the product with respect to permissible/non-permissible defects</p> <p>KB3. fabric quality particulars such as ends & picks per inch, width, products weave etc.</p>
About the Raw materials	<p>KB4. yarns from natural fibers - cotton, silk, wool</p> <p>KB5. yarns from manmade fibers - polyester, nylon, viscose</p> <p>KB6. blended yarns - Polyester Cotton, Polyester Viscose</p>
About different types of Looms	<p>KB7. hand loom</p> <p>KB8. power loom - conventional loom</p> <p>KB9. auto loom - shuttle looms</p> <p>KB10. shuttle less looms - rapier , projectile , air jet, waterjet</p> <p>KB11. tappet loom/ Cam Loom/ Crank Loom , Dobby Loom, Jacquard Loom</p>
About types of weave	<p>KB12. plain weave, twill , drill, plain satin, stripe satin , dobby designs , jacquard designs</p>
Causes for fabric defects: due to weaver, due to loom, due to other reasons	<p>KB13. wrong drawing , wrong denting, end out , double end, broken pick, double pick, missing pick, hand stain , hole, wrong weft, bad selvedge,</p> <p>KB14. end out, let-off, take- up problem, temple mark, temple cut, emery hole/ emery cut/ emery mark, broken pick, missing pick, double pick, short pick, snarls, impression mark, oil stain, lashing in, weft catching, selvedge cut, loops, weft stitches, warp stitches, bumping mark, weft crack, cloth torn , bad shedding, warp floats, weft floats, reed mark, bad selvedge, starting mark, thin & thick place , hair line crack,</p> <p>KB15. spinning faults - thin place, thick place, neps, kitties, contamination, color flies, yarn variation, shade variation</p> <p>KB16. sizing faults - shade variation, size patches, sizing oil, bead formation,</p> <p>KB17. weaving faults - wrong weft, wrong pattern, less width, low EPI, low PPI, wrong Warp,</p>
Inspection Standard	<p>KB18. four Point American System</p> <ul style="list-style-type: none"> ● Below 3" - 1 point ● Between 3" to 6 " - 2 points

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	<ul style="list-style-type: none"> Between 6" to 9" - 3 points Above 9" - 4 points
British System of grading Cuttable Faults, Warp Way Continuous Faults, Specification Deviations	<p>KB19. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No 3 Major Faults, 15 minor points</p> <p>KB20. B Grade - Rejection. Deviation from A Grade</p> <p>KB21. cuttable faults ; hole, let - off, take - up, selvedge cut, weft crack, cloth torn, wrong pattern, bad shedding, size patches , sizing oil, bead formation, wrong weft,</p> <p>KB22. major faults : wrong drawing, wrong denting, end out, double end, temple mark, temple cut, emery hole, emery cut, emery mark, impression mark, guide tooth mark, under tuck in, tails, warp stitches , warp floats, reed mark, bad selvedge, yarn variation, shade variation,</p> <p>KB23. cloth width - no minus is accepted & no excess above 0.5" is accepted</p> <p>KB24. ends per inch - plus or minus 2 is accepted</p> <p>KB25. picks Per Inch - Plus or Minus 1</p>
American System	<p>KB26. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No of grading Export Specification Deviation. Maximum 15 points for 100 Square meter Standard – Piece</p> <p>KB27. B Grade - Rejection. Deviation from A Grade Lengths</p> <p>KB28. between 40 meters to 79.75 meters - 20% to variation from buyer to buyer)</p> <p>KB29. above 80 meters - 80%</p>
Safety Mechanism	<p>KB30. safety mechanisms of the machines & should ensure that the same are in order</p> <p>KB31. stop motions & should ensure that the same are in order</p> <p>KB32. the indication lamps & should ensure that the same are in order</p>
Machine Operators	KB33. functional operations of the machines, where He/She is working
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to: SA1. Write clear and short sentences
	Reading Skills
	You need to know and understand how to: SA2. comprehend written instructions
B. Professional Skills	<p>On the job the individual should be able to:</p> <p>SB1. plan and manage work routine based on instructions from supervisor</p> <p>SB2. willingly participate in the various programs/ meetings that will be conducted by the superiors & put forth the suggestions in the interest of the company</p> <p>SB3. participate in the " quality circles" that will be formed by the superiors</p> <p>SB4. extend voluntary supports and adapt to the various procedures that will be adopted by the company with respect to compliances for the different certifications like " ISO 9001", " ISO 14001", SA 8001" ,GOTS certification " fair Trade " etc.</p>
C. Technical Skills	Weaver's Knot

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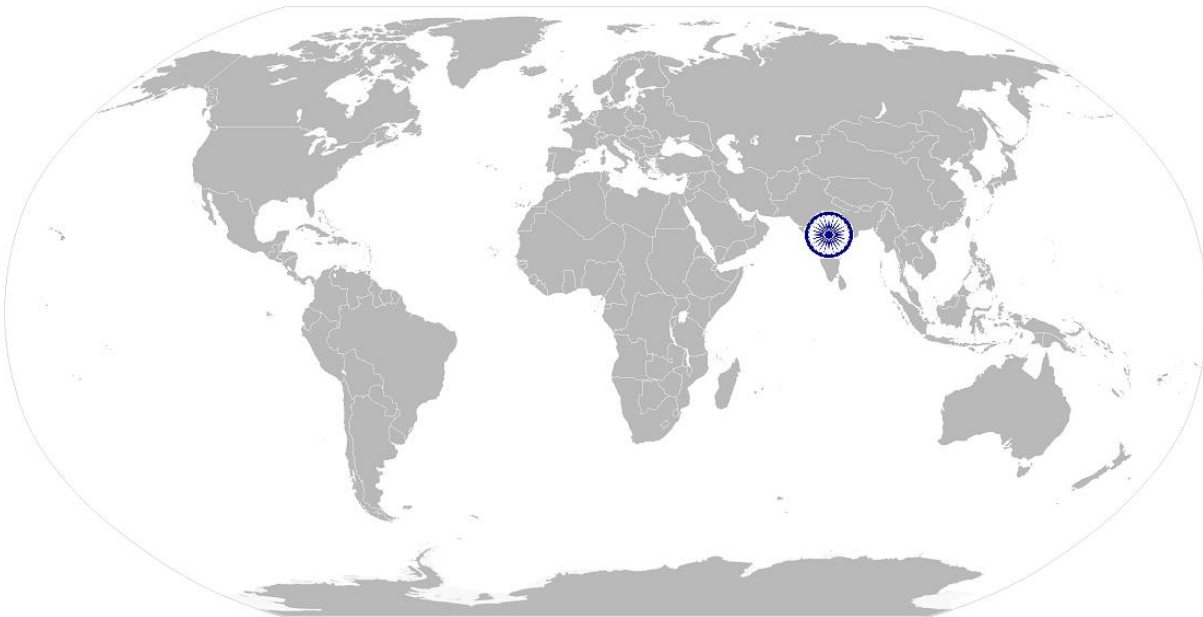
	<p>You need to know and understand how to:</p> <p>SC1. ensure that Warp breaks/loom hour doesn't exceed 3</p> <p>SC2. ensure that weft breaks/loom hour doesn't exceed 2</p> <p>SC3. ensure that fabric rejection doesn't exceed 2%</p> <p>SC4. ensure that the efficiency is maintained in excess of 85%</p> <p>SC5. ensure that the warp waste doesn't exceed 1%</p> <p>SC6. ensure that the weft waste doesn't exceed 2 %</p> <p>SC7. ensure the life of the shuttle in excess of 6 months</p> <p>SC8. ensure the life of wooden picking stick in excess of 6 months</p> <p>SC9. put a minimum of 15 knots/ minute</p>
	<p>Battery Filling</p> <p>SC10. fill around 24 pirns in a battery in a maximum period of 2 minutes</p>
	<p>Attending to Warp/ Weft Break</p> <p>SC11. attend battery filling with proper pick finding in 30 seconds</p> <p>SC12. attend a single warp end through dropper, Heald & reed dent in 45 to 60 seconds depending on the automation of the machines/ type of weave etc.</p>
	<p>Quality Evaluation</p> <p>SC13. weave fabric free from " Weaver oriented damages " such as " Wrong Drawing" , " Wrong Denting" " End Out " " Double End" etc.</p>



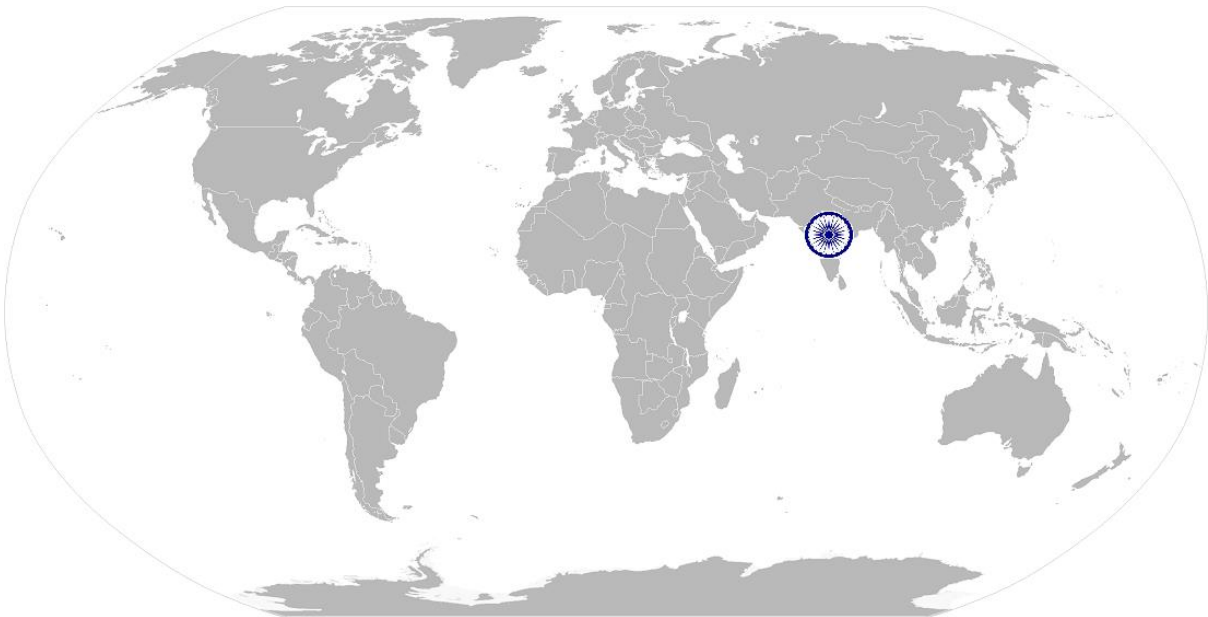
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NOS Version Control

NOS Code	TSC/N 2403		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/01/15
Occupation	Maintenance	Next review date	01/03/16



National Occupational Standard



Overview

This unit provides performance criteria, knowledge & understanding and skills & abilities required to run an automatic shuttle loom.

TSC/ N 2404

Maintaining Autoloom Weaving Machine

National Occupational Standard

Unit Code	TSC/N 2404
Unit Title (Task)	Maintaining Autoloom Weaving Machine
Description	This unit provides performance criteria, knowledge & understanding and skills & abilities required to run an automatic shuttle loom, by attending to warp breakages, weft breakages so as to get maximum output & minimum defects; without entertaining any damage to the people , the machine etc; and without wasting much of raw materials, spares, tools etc. Without spoiling any environmental aspects.
Scope	This unit/task covers the following: <ul style="list-style-type: none"> ▪ Attending to quality issues ▪ Attending to production issues/breakdowns ▪ Ensuring maintenance activities ▪ Other work practices
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Attending to quality issues	<p>To be competent, you must be able to :</p> <p>PC1. ensure that the production is commenced only after the sample is approved</p> <p>PC2. ensure that bulk production is started only after the first roll is approved</p> <p>PC3. ensure that warp stop motion functions properly, so that no end problem , warp float etc. doesn't occur on the fabrics</p> <p>PC4. ensure that centre weft fork functions properly so that fabrics don't get rejected due to weft crack,</p> <p>PC5. ensure that scissor & temple cutter function properly so that fabrics don't get rejected due to lashing- in</p> <p>PC6. maintain take – up & let-off mechanisms properly so that fabrics don't get rejected due to let-off faults, take-up faults etc.</p> <p>PC7. ensure proper functioning of stop motions, back rest, shedding, anti crack motion & to ensure no play in sley, crank arm. etc., so that fabrics are free from defects like starting mark, bad shedding etc.</p> <p>PC8. maintain temple setting , reed setting so that fabrics don't get rejected for reasons like “ temple cut”, temple mark”, reed mark”</p>
Attending to Production issues/ Breakdowns	<p>PC9. see that automatic weft replenishment mechanism functions properly</p> <p>PC10. see that shuttle condition is good</p> <p>PC11. see that shuttle reaches the boxes without any “ rebound”</p> <p>PC12. see that the condition of heald wires, heald frames , reed etc. are in good condition</p> <p>PC13. see that the reversing mechanism functions properly</p> <p>PC14. see that the loom runs with the actual required belts and should see that there is no slippage in the same, so as to ensure that the loom works in the recommended speed.</p> <p>PC15. see that replenishment of spares or attending to break downs is done in the prescribed time.</p> <p>PC16. ensure required humidity in the loom shed</p> <p>PC17. check the knotted looms & ensure that knotting is carried out without cross</p>

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Maintaining Autoloom Weaving Machine

	<p>ends</p> <p>PC18. check the sort change loom & ensure that drawing & reaching was carried out without any cross ends.</p> <p>PC19. ensure “looms breakage study” and check the quality of both warp & weft yarn. for any deviation the same has to be brought to the knowledge of the higher authority.</p> <p>PC20. check the sizing quality and for any deviation, the same has to be brought to the notice of the higher authority.</p> <p>PC21. ensure proper dropper cleaning</p>
<p>Ensuring Maintenance Activities</p>	<p>PC22. ensure that the looms are cleaned properly as per the below schedule</p> <ul style="list-style-type: none"> • Daily cleaning • Cleaning during knotting • Cleaning during sort changes <p>PC23. ensure that the looms are lubricated using grease, gear-tack oil etc., as per the schedule</p> <ul style="list-style-type: none"> • Daily points • Weekly points • Monthly points • Once in 6 months • yearly once <p>PC24. To carry out preventive maintenance as per the schedule</p> <ul style="list-style-type: none"> • Daily checking • Weekly once • Bi monthly • Monthly • 6 months once • Yearly <p>PC25. apply new shuttle , in the looms where all maintenance schedules are strictly followed</p> <p>PC26. ensure the life of all the spares through effective maintenance</p>
<p>Other Work Practices</p>	<p>PC27. control “ pirn breakages” & to maintain “ empty pirn stock” on weekly basis, so as to ensure of the life.</p> <p>PC28. check “ shuttle condition” on weekly basis and initiate corrective action</p> <p>PC29. maintain “ spare changing details ” note, for the following details.</p> <ul style="list-style-type: none"> • Loom no. • Name of the spare • Side (if any) • Part no. • Name of the supplier • Make • Date of application • Date of removal • Reason for removal • Life of item

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Maintaining Autoloom Weaving Machine

PC30. salvage the “ broken spare “ & to avail new spare, only after producing the “ old spare to the Stores.

PC31. maintain “ Sort Muster” as per the below details

- Loom No.
- Construction Details
- Warp Material details
- Warp Count
- Warp Mill Name
- Warp Yarn Test Report(Test Parameters)
- Reed Used
- Total Ends Used
- Name Of The Sizing
- Warping Breakage Rate
- Average Warp Count
- Size Pick Up
- Warp break/ loom hour
- Weft Material Details
- Weft Count
- Weft Mill Name
- Weft Yarn Test Report(Test Parameters)
- Reed Space
- Weft breakage per loom hour]
- Average Loom Efficiency
- Loom Speed
- Average Production in Kilo Picks/loom day
- Production in metres/loom day
- Date of knotting
- Knotted metres
- Date of exhaustion
- Produced metres
- Warp Crimp
- Warp Consumption/metre (Excluding Size Add On)
- Warp Wt in kgs/ metre (Including Size add on)
- Weft Consumption/metre
- Total cloth wt in kgs/ metre
- GSM
- Fabric doffed
- Fabric inspected
- Fabric Passed
- Fabric Rejected
- Rejection %
- Reason For Rejection
- Warp Waste %
- Weft Waste %



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Maintaining Autoloom Weaving Machine

	<p>PC32. maintain effective working of “ Generator”</p> <p>PC33. see that “ Air” is not misused Can use air for cleaning, only in the areas, where it is allowed</p> <p>PC34. ensure proper maintenance of “ Air Compressor”</p> <p>PC35. ensure that " Loom Cards " for all the required details are placed on all the looms</p> <ul style="list-style-type: none"> • Loom No. • Construction details • Reed Count • Reed Space • Weft Count • Pick Wheel • Winding Spindle No. • Drawing Method <p>PC36. see that the weft yarn is completely used , without giving room for additional wastage of raw materials. For any quality issue or defective cone etc., the same has to be brought to the notice of the Superiors.</p> <p>PC37. Maintain “ Knotting Entry Note” with the following details</p> <ul style="list-style-type: none"> • Loom No. • Construction Details • Date Of Knotting • Time of Exhaustion • Cleaning Completed Time • Beam Loading Completed Time • Knotting Completed Time • Loom Run Time • Total Stopped Time For Knotting • Name Of the Sizing • Set No. • Beam Nos. • Beam Metres • Old Warp Waste kgs • New Warp Waste kgs • Cleaning Quality • Knotting Quality <p>PC38. Ensure Relative Humidity in the Department is maintained</p> <p>PC39. ensure correct quality of thrums are there & see that the same are properly tied</p> <p>PC40. check the knotted loom for knotting quality etc. Double ends have to be removed</p> <p>PC41. report to superiors for any deviation in the same & for any other quality issue</p> <p>PC42. ensure that cloth rolls are doffed whenever/ wherever necessary</p> <p>PC43. give preference to safety . Should not enter the area, where He/ She are not</p>
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Maintaining Autoloom Weaving Machine

	<p>allowed. Should not do a job in which training has not being given</p> <p>PC44. ensure that no raw material/ cloth/ spare/ tool / any other material is thrown under/ near the machines or in the other work areas.</p>
Knowledge and Understanding (K)	
<p>A. Organizational Context (Knowledge of the company/ organization and its processes)</p>	<p>The individual on the job needs to know and understand:</p> <p>KA1. the organization's policies & standard operating procedures (SOP)</p> <p>KA2. awareness, knowledge of customers</p> <p>KA3. potential hazards associated with the machines and the safety precautions must be taken</p> <p>KA4. protocol to obtain more information on work related tasks</p> <p>KA5. contact person in case of queries on procedure or products and for revolving issues related to defective machines, tools, materials & equipments</p> <p>KA6. details of the various job rolls & responsibilities</p> <p>KA7. documentation and reporting formats</p> <p>KA8. work targets & review machine with superiors</p> <p>KA9. protocol and format for reporting work related risks/ problems</p> <p>KA10. method of obtaining /giving feed back with respect to performance</p> <p>KA11. importance of team work .harmonious working relationships</p> <p>KA12. process for offering /obtaining work related assistance</p> <p>KA13. responsibilities under health, safety and environmental legislation</p> <p>KA14. guidelines for storage & disposal of waste materials</p>
<p>B. Technical/Domain Knowledge of product</p>	<p>KB1. the user/individual on the job needs to know and understand:</p> <p>KB2. the minimum quality requirements of the product with respect to permissible/non-permissible defects</p> <p>KB3. fabric quality particulars such as ends & picks per inch, width, products weave etc.</p>
<p>About the Raw materials</p>	<p>KB4. yarns from natural fibers - cotton, silk, wool</p> <p>KB5. yarns from manmade fibers - polyester, nylon, viscose</p> <p>KB6. blended yarns - Polyester Cotton, Polyester Viscose</p>
<p>About different types of Looms</p>	<p>KB7. hand loom</p> <p>KB8. power loom - conventional loom</p> <p>KB9. auto loom - shuttle looms</p> <p>KB10. shuttle less looms - rapier , projectile , airjet, waterjet</p> <p>KB11. tappet loom/ Cam Loom/ Crank Loom , Dobby Loom, Jacquard Loom</p>
<p>About types of weave</p>	<p>KB12. plain weave, twill , drill, plain satin, stripe satin , dobby designs , jacquard designs</p>
<p>Causes for fabric defects: due to weaver, due to loom, due to other reasons</p>	<p>KB13. wrong drawing , wrong denting, end out , double end, broken pick, double pick, missing pick, hand stain , hole, wrong weft, bad selvedge,</p> <p>KB14. end out, let-off, take- up problem, temple mark, temple cut, emery hole/ emery cut/ emery mark, broken pick, missing pick, double pick, short pick, snarls, impression mark, oil stain, lashing in, weft catching, selvedge cut, loops, weft stitches, warp stitches, bumping mark, weft crack, cloth torn ,</p>

TSC/ N 2404

Maintaining Autoloom Weaving Machine

	<p>bad shedding, warp floats, weft floats, reed mark, bad selvedge, starting mark, Thin & Thick Place , Hair line crack,</p> <p>KB15. spinning faults - thin place, thick place, neps, kitties, contamination, color flies, yarn variation, shade variation</p> <p>KB16. sizing faults - shade variation, size patches, sizing oil, bead formation,</p> <p>KB17. weaving faults - wrong weft, wrong pattern, less width, low EPI, low PPI, wrong Warp,</p>
Inspection Standard	<p>KB18. four Point American System</p> <ol style="list-style-type: none"> i. Below 3" - 1 point ii. Between 3" to 6 " - 2 points iii. Between 6" to 9" - 3 points iv. Above 9" - 4 points
British System of grading Cuttable Faults, Warp Way Continuous Faults, Specification Deviations	<p>KB19. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No 3 Major Faults, 15 minor points</p> <p>KB20. B Grade - Rejection. Deviation from A Grade</p> <p>KB21. cuttable faults ; hole, let - off, take - up, selvedge cut, weft crack, cloth torn, wrong pattern, bad shedding, size patches , sizing oil, bead formation, wrong weft,</p> <p>KB22. major faults : wrong drawing, wrong denting, end out, double end, temple mark, temple cut, emery hole, emery cut, emery mark, impression mark, guide tooth mark, under tuck in, tails, warp stitches , warp floats, reed mark, bad selvedge, yarn variation, shade variation,</p> <p>KB23. cloth width - no minus is accepted & no excess above 0.5" is accepted</p> <p>KB24. ends per inch - plus or minus 2 is accepted</p> <p>KB25. picks Per Inch - Plus or Minus 1</p>
American System	<p>KB26. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No of grading Export Specification Deviation. Maximum 15 points for 100 Square meter Standard – Piece</p> <p>KB27. B Grade - Rejection. Deviation from A Grade Lengths</p> <p>KB28. between 40 meters to 79.75 meters - 20% to variation from buyer to buyer)</p> <p>KB29. above 80 meters - 80%</p>
Safety Mechanism	<p>KB30. know the safety mechanisms of the machines & should ensure that the same are in order</p> <p>KB31. know about the stop motions & should ensure that the same are in order</p> <p>KB32. know about the indication lamps & should ensure that the same are in order</p>
Machine Operators	<p>KB33. know about the functional operations of the machines, where He/She is working</p>

Skills (S)

A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to: SA1. Write clear and short sentences
	Reading Skills
	You need to know and understand how to: SA2. comprehend written instructions
	Participation

TSC/ N 2404

Maintaining Autoloom Weaving Machine

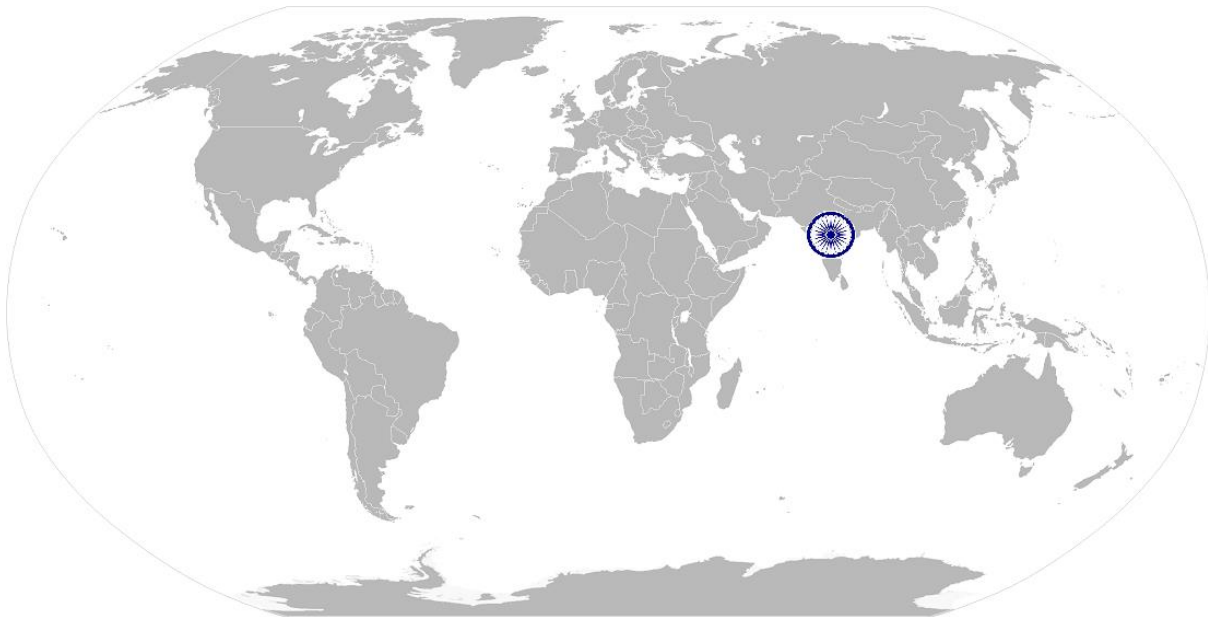
	<p>On the job the individual should be able to:</p> <p>SA3. Plan and manage work routine based on instructions from supervisor</p> <p>SA4. participate in the various programs/ meetings that will be conducted by the Superiors & put forth the suggestions in the interest of the Company</p> <p>SA5. Participate in the " Quality Circles" that will be formed by the Superiors</p> <p>SA6. extend voluntary supports and adapt to the various procedures that will be adopted by the Company with respect to compliances for the different certifications like " ISO 9001", " ISO 14001", " SA 8001" , GOTS Certification " Fair Trade " etc.</p>
<p>B. Professional Skills</p>	<p>Weaver's Knot</p> <p>On job the individual should be able to achieve the following skills :</p> <p>SB1. ensure that Warp breaks/loom hour doesn't exceed 3</p> <p>SB2. ensure that weft breaks/loom hour doesn't exceed 2</p> <p>SB3. ensure that fabric rejection doesn't exceed 2%</p> <p>SB4. ensure that the efficiency is maintained in excess of 85%</p> <p>SB5. ensure that the warp waste doesn't exceed 1%</p> <p>SB6. ensure that the weft waste doesn't exceed 2 %</p> <p>SB7. ensure the life of the shuttle in excess of 6 months</p> <p>SB8. ensure the life of wooden picking stick in excess of 6 months</p> <p>SB9. should put a minimum of 15 knots/ minute</p>
	<p>Battery Filling</p> <p>SB10. Should be able to fill around 24 pirns in a battery in a maximum period of 2 minutes</p>
	<p>C. Technical Skills</p>
<p>Quality Evaluation</p>	
<p>SC3. should be able to weave fabric free from " Weaver oriented damages " such as " Wrong Drawing" , " Wrong Denting" " End Out " " Double End" etc.</p>	

TSC/ N 2404

Maintaining Autoloom Weaving Machine

NOS Version Control

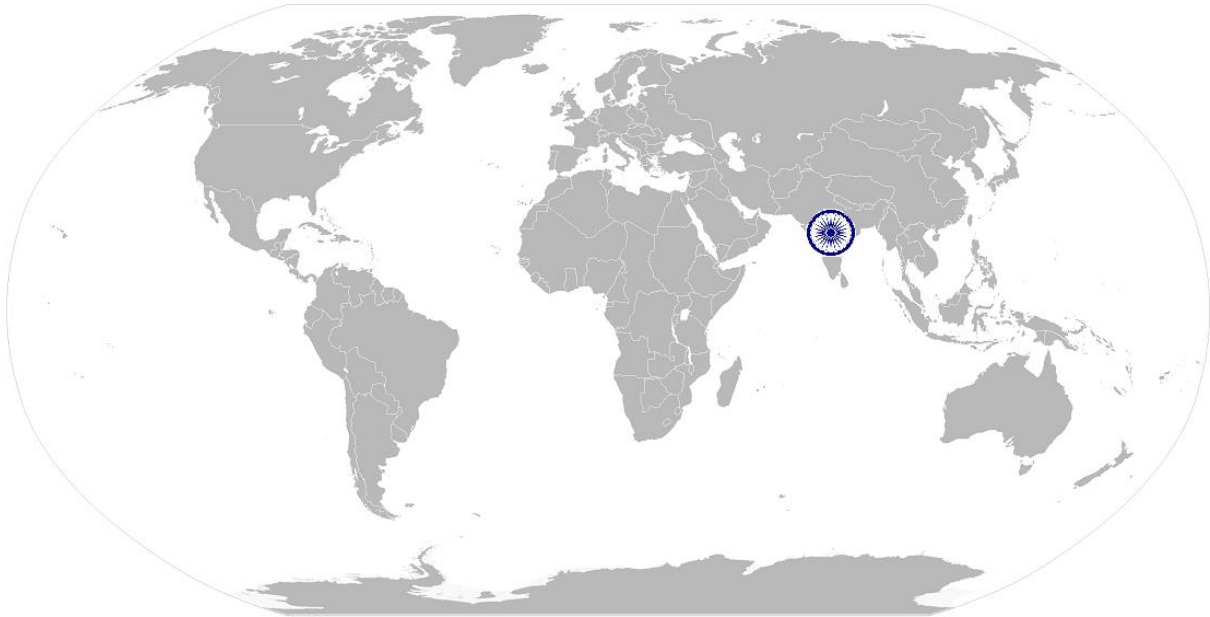
NOS Code	TSC/N 2404		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/01/15
Occupation	Maintenance	Next review date	01/03/16



SSC/ N 9001

Maintaining work area, tools and machines

National Occupational Standard



Overview

This unit is about maintaining work areas and activities to ensure tools and machines are maintained as per norms.


TSC/ N9001

Maintaining work area, tools and machine

Unit Code	TSC/ N9001
Unit Title (Task)	Maintaining work area, tools and machines
Description	This unit provides performance criteria, knowledge & understanding and skills & abilities required to organize/ maintain work areas and activities to ensure tools and machines are maintained as per norms
Scope	This unit/task covers the following: <ul style="list-style-type: none"> ▪ Maintain the work area, tools and machines
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Maintain the work area, tools and machines	<p>To be competent, you must be able to:</p> <p>PC1. handle materials, machinery, equipment and tools with care and use them in the correct way</p> <p>PC2. use correct lifting and handling procedures</p> <p>PC3. use materials to minimize waste</p> <p>PC4. maintain a clean and hazard free working area</p> <p>PC5. maintain tools and equipment</p> <p>PC6. carry out running maintenance within agreed schedules</p> <p>PC7. carry out maintenance and/or cleaning within one's responsibility</p> <p>PC8. report unsafe equipment and other dangerous occurrences</p> <p>PC9. ensure that the correct machine guards are in place</p> <p>PC10. work in a comfortable position with the correct posture</p> <p>PC11. use cleaning equipment and methods appropriate for the work to be carried out</p> <p>PC12. dispose of waste safely in the designated location</p> <p>PC13. store cleaning equipment safely after use</p> <p>PC14. carry out cleaning according to schedules and limits of responsibility</p>
Knowledge and Understanding (K)	
A. Organizational Context (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. organizational standard operating procedures (SOP)</p> <p>KA2. limits of your own responsibility</p> <p>KA3. ways of resolving with problems within the work area</p> <p>KA4. the production process and the specific work activities that relate to the whole process</p> <p>KA5. the importance of effective communication with supervisors</p> <p>KA6. the lines of communication, authority and reporting procedures</p> <p>KA7. the organization's rules, codes and guidelines (including timekeeping)</p> <p>KA8. the company's quality standards</p> <p>KA9. the importance of complying with written instructions</p> <p>KA10. equipment operating procedures / supervisor's instructions</p>
B. Technical Knowledge	<p>You need to know and understand:</p> <p>KB1. work instructions and specifications and interpret them accurately</p> <p>KB2. relation between work role and the overall manufacturing process</p> <p>KB3. hazards likely to be encountered when conducting routine maintenance</p> <p>KB4. the importance of taking action when problems are identified</p>

TSC/ N9001

Maintaining work area, tools and machine

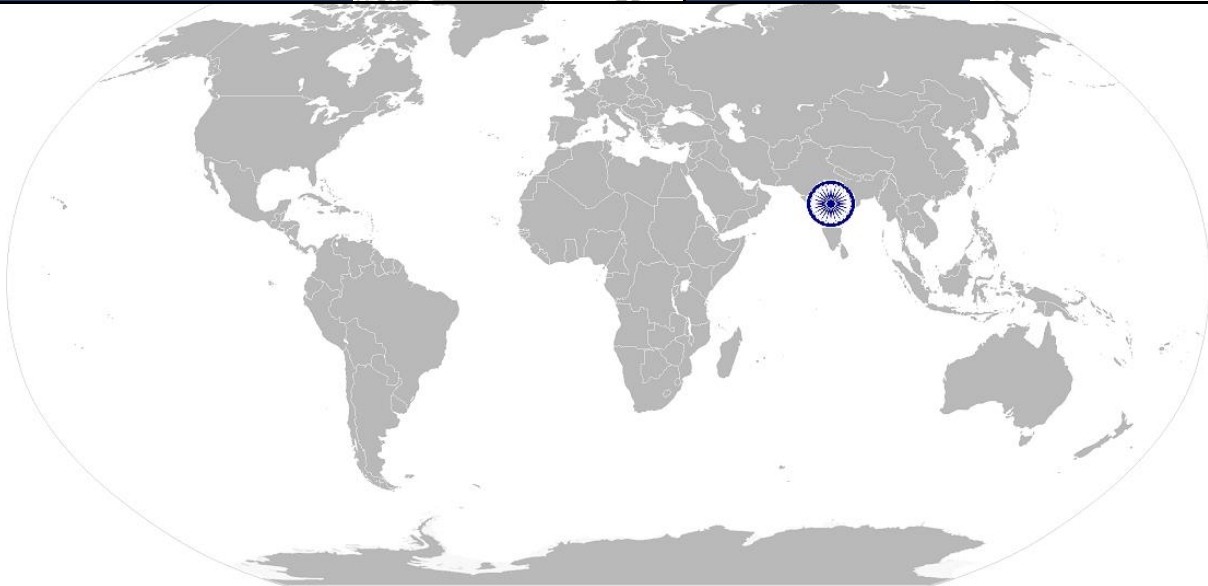
	KB5. different ways of minimizing waste KB6. the importance of running maintenance and regular cleaning KB7. effects of contamination on products i.e. machine oil, dirt, foreign materials KB8. common faults with equipment and the method to rectify KB9. maintenance procedures KB10. different types of cleaning equipment and substances and their use KB11. safe working practices for cleaning and the method of carrying them out
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	SA1. Write clear and short sentences
	Reading Skills
	You need to know and understand how to: SA2. comprehend written instructions SA3. read any application sent by other colleagues
	Oral Communication (Listening and Speaking skills)
	You need to know and understand how to: SA4. Communicate effectively in local language SA5. communicate with supervisor appropriately SA6. talk to others to convey information effectively
B. Professional Skills	Problem Solving
	You need to know and understand how to:  SB1. identify the real reason of problem faced SB2. apply problem-solving approaches in different situations SB3. refer anomalies to the supervisor SB4. seek clarification on problems from others
	Attention to Detail
	You need to know and understand how to: SB5. apply good attention to detail SB6. check your work is complete and free from errors SB7. make sure every kind of communication is error free
C. Technical Skills	You need to know and understand : SC1. communicate effectively SC2. apply leadership skills wherever required SC3. take initiative at the right place SC4. understand the requirement to be creative

TSC/ N9001

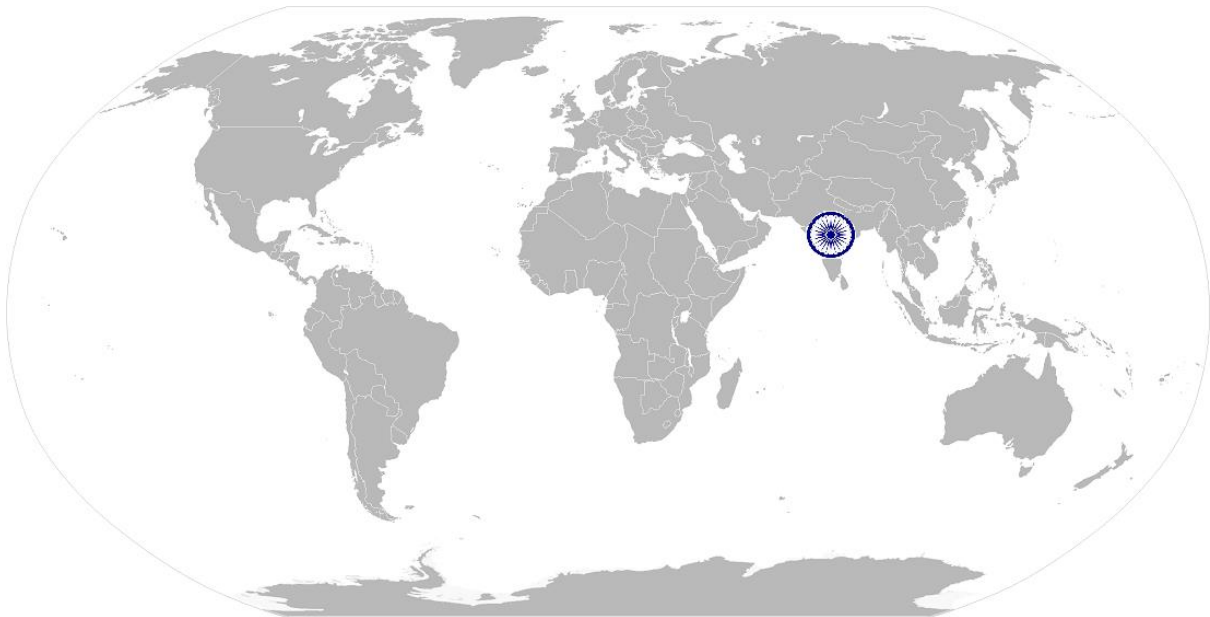
Maintaining work area, tools and machine

NOS Version Control

NOS Code	TSC/ N9001		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/01/15
Occupation	Maintenance	Next review date	01/03/16



National Occupational Standard



Overview

This unit is about working as part of a team in the textile industry.

TSC/ N9002

Working in a team

Unit Code	TSC/ N9002
Unit Title (Task)	Working in a team
Description	This unit is about working as a team member in the textile industry
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> ▪ commitment and trust ▪ communication ▪ adaptability ▪ creative freedom
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Commitment and trust	<p>To be competent, you must be able to:</p> <p>PC1. be accountable to the own role in whole process</p> <p>PC2. perform all roles with full responsibility</p> <p>PC3. be effective and efficient at workplace</p>
Communication	<p>PC4. properly communicate about company policies</p> <p>PC5. report all problems faced during the process</p> <p>PC6. talk politely with other team members and colleagues</p> <p>PC7. submit daily report of own performance</p>
Adaptability	<p>PC8. adjust in different work situations</p> <p>PC9. give due importance to others' point of view</p> <p>PC10. avoid conflicting situations</p>
Creative freedom	<p>PC11. develop new ideas for work procedures</p> <p>PC12. improve upon the existing techniques to increase process efficiency</p>
Knowledge and Understanding (K)	
A. Organizational Context	<p>You need to know and understand:</p> <p>KA1. Standard operating procedures (SOP) and regulations in a textile mill</p> <p>KA2. procedure followed to get the final output in the mill</p> <p>KA3. safe working practices to be adopted in textile mill</p> <p>KA4. reporting to the supervisor or higher authority about any grievances faced</p>
B. Technical Knowledge	<p>KB1. the importance of the previous and next step of the process</p> <p>KB2. process flow in a textile mill and the concerned workers</p> <p>KB3. material flow in a textile mill and the required person</p> <p>KB4. functions of different parts of the machine</p> <p>KB5. tools and equipments used</p> <p>KB6. guidelines for operating the machine</p> <p>KB7. safety procedures to be followed in the machine</p>
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to:
	<p>SA1. Write clear and short sentences</p> <p>SA2. write daily work report</p> <p>SA3. write grievance complaint application</p>
	Reading Skills

TSC/ N9002

Working in a team

	SA4. comprehend written instructions SA5. read any application sent by other colleagues
	Oral Communication (Listening and Speaking skills)
	SA6. communicate with supervisor appropriately SA7. talk to co-workers to convey information effectively
B. Professional Skills	Problem Solving
	You need to know and understand how to: SB1. identify the real reason of problem faced SB2. be able to find the most effective solution to the problems faced
	Attention to Detail
	SB3. apply good attention to detail SB4. ensure every kind of communication is error free
C. Technical Skills	You need to know and understand how to: SC1. communicate effectively SC2. apply leadership skills wherever required SC3. take initiative at the right place SC4. understand the requirement to be creative

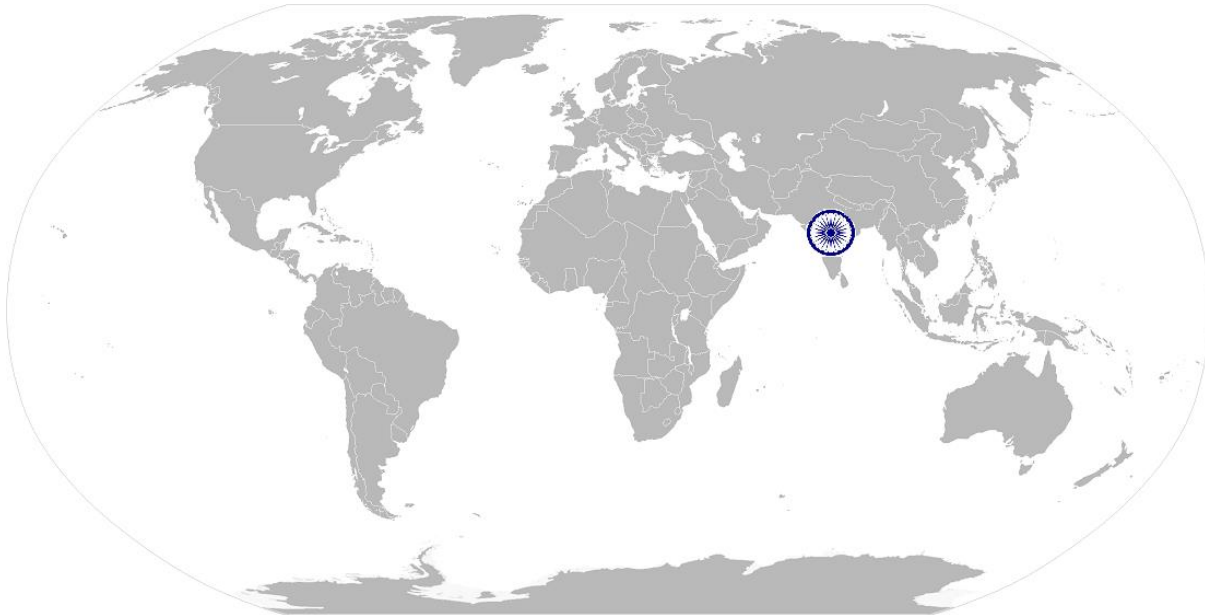


TSC/ N9002

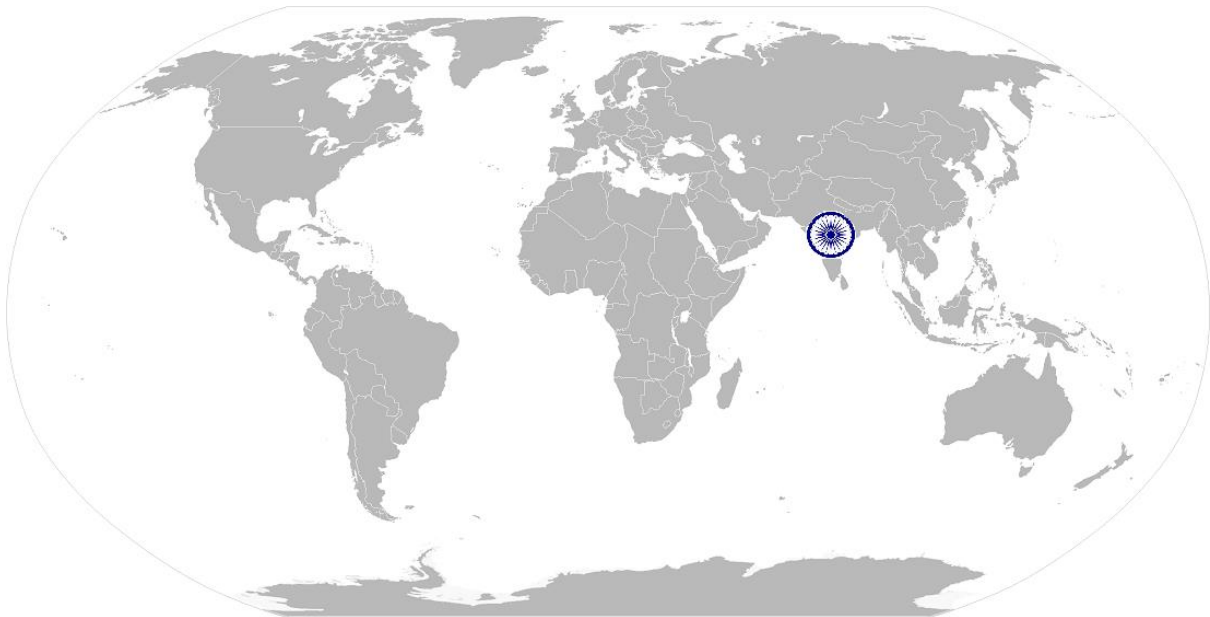
Working in a team

NOS Version Control

NOS Code	TSC/ N9002		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/01/15
Occupation	Maintenance	Next review date	01/03/16



National Occupational Standard



Overview

This unit is about maintaining health, safety, and security standards at workplace.

TSC/ N9003

Maintain health, safety and security at work place

Unit Code	TSC/ N9003
Unit Title (Task)	Maintain health, safety and security at work place
Description	This unit provides performance criteria, knowledge & understanding and skills & abilities required to comply with health, safety and security requirements at the workplace and covers procedures to prevent, control and minimize risk to self and others.
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> ▪ comply with health, safety and security requirements at work ▪ recognizing the hazards ▪ planning safety techniques ▪ implementing the programs
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Comply with health, safety and security requirements at work	<p>To be competent, operator must be able to:</p> <p>PC1. comply with health and safety related instructions applicable to the workplace</p> <p>PC2. use and maintain personal protective equipment such as “ear plug”, “ nose mask “, “ head cap” etc., as per protocol</p> <p>PC3. carry out own activities in line with approved guidelines and procedures</p> <p>PC4. maintain a healthy lifestyle and guard against dependency on intoxicants</p> <p>PC5. follow environment management system related procedures</p> <p>PC6. identify and correct (if possible) malfunctions in machinery and equipment</p> <p>PC7. report any service malfunctions that cannot be rectified</p> <p>PC8. store materials and equipment in line with organisational requirements</p> <p>PC9. safely handle and remove waste</p> <p>PC10. minimize health and safety risks to self and others due to own actions</p> <p>PC11. seek clarifications, from supervisors or other authorized personnel in case of perceived risks</p> <p>PC12. monitor the workplace and work processes for potential risks and threat</p> <p>PC13. carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned</p> <p>PC14. report hazards and potential risks/ threats to supervisors or other authorized personnel</p> <p>PC15. participate in mock drills/ evacuation procedures organized at the workplace</p> <p>PC16. undertake first aid, fire-fighting and emergency response training, if asked to do so</p> <p>PC17. take action based on instructions in the event of fire, emergencies or accidents</p> <p>PC18. follow organisation procedures for shutdown and evacuation when required</p>
Recognizing the hazards	<p>To be competent, you must be able to:</p> <p>PC19. identify different kinds of possible hazards (environmental, personal, ergonomic, chemical) of the industry</p> <p>PC20. recognise other possible security issues existing in the workplace</p>

TSC/ N9003

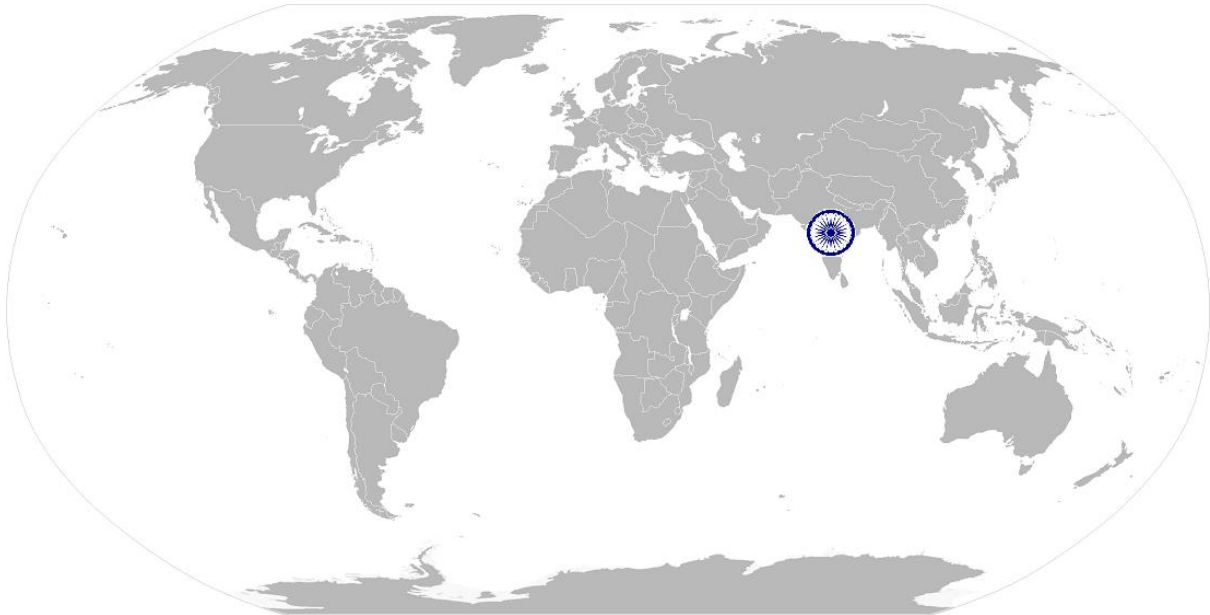
Maintain health, safety and security at work place

Planning the safety techniques	PC21. recognise different measures to curb the hazards
Implementing the programs	PC22. communicate the safety plan to everyone PC23. attach disciplinary rules with the implementation
Knowledge and Understanding (K)	
A. Organizational Context (Knowledge of the company/ organization and its processes)	You need to know and understand: KA1. Standard operating procedures (SOP) and regulations in a textile mill KA2. safe working practices to be adopted in textile mill KA3. quality systems and other processes practiced in the textile mill KA4. health and safety related practices applicable at the workplace KA5. potential hazards, risks and threats based on nature of operations KA6. organizational procedures for safe handling of equipment and machine operations KA7. potential risks due to own actions and methods to minimize these KA8. environmental management system related procedures at the workplace KA9. layout of the plant and details of emergency exits, escape routes, emergency equipment and assembly points KA10. potential accidents and emergencies and response to these scenarios KA11. reporting protocol and documentation required KA12. details of personnel trained in first aid, fire-fighting and emergency response KA13. actions to take in the event of a mock drills/ evacuation procedures or actual accident, emergency or fire
B. Technical Knowledge	You need to know and understand: KB1. occupational health and safety risks and methods KB2. personal protective equipment and method of use KB3. identification, handling and storage of hazardous substances KB4. proper disposal system for waste and by-products KB5. signage related to health and safety and their meaning KB6. importance of sound health, hygiene and good habits KB7. ill-effects of alcohol, tobacco and drugs
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to: SA1. Write clear and short sentences
	Reading Skills
	SA2. comprehend written instructions
	Oral Communication (Listening and Speaking skills)
	SA1. listen to others attentively SA2. respond to emergencies, accidents or fire at the workplace SA3. evacuate the premises and help others in need while doing so SA4. the value of physical fitness, personal hygiene and good habits SA5. talk with others politely
B. Professional Skills	Decision Making
	SB1. identify correct safety measure for particular hazard SB2. make required safety plans as and when required

TSC/ N9003

Maintain health, safety and security at work place

	SB3. raise alarm in case of emergency
	Analytical Thinking
	SB4. know the use of correct safety measure whenever required
	Attention to Detail
	SB5. be attentive to details SB6. be careful to avoid occurrence of hazards
C. Technical Skills	You need to know and understand : SC1. maintenance of neatness at work SC2. procedure for reporting unwanted behavior

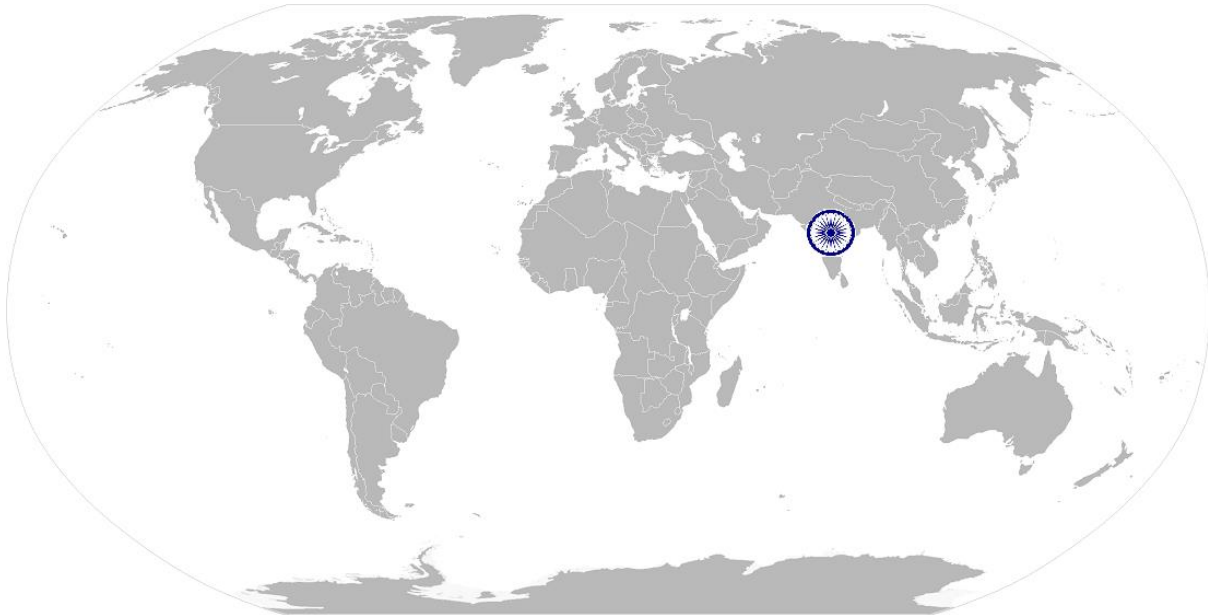


TSC/ N9003

Maintain health, safety and security at work place

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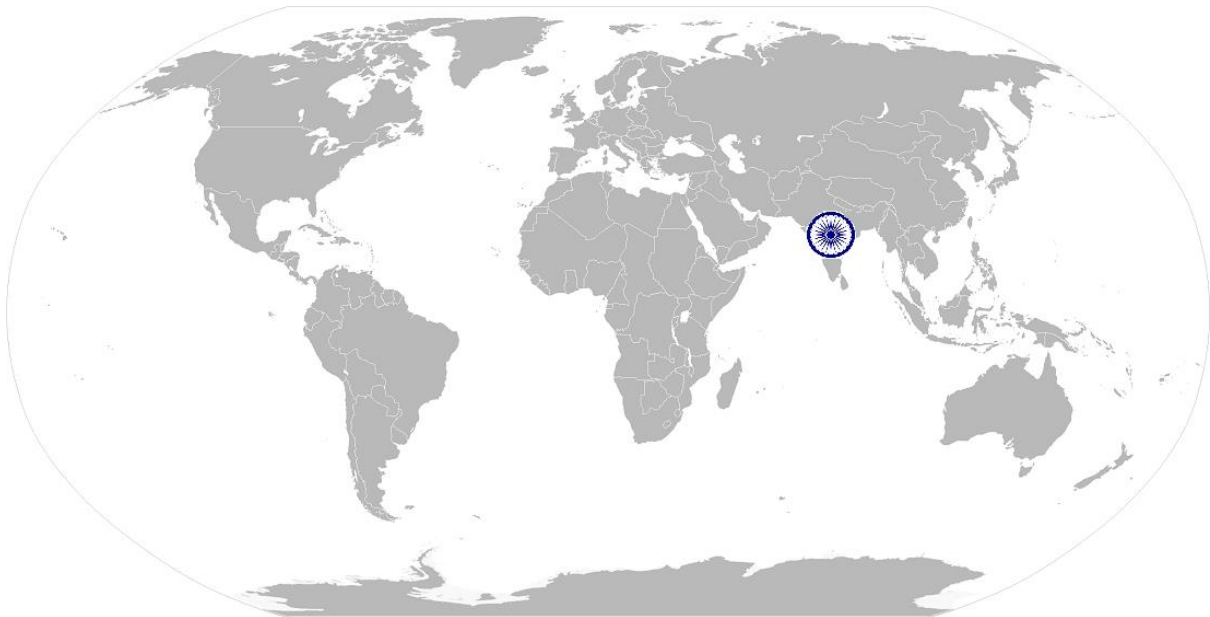
NOS Code	TSC/ N9003		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/01/15
Occupation	Maintenance	Next review date	01/03/16



AMH/N 9004

Comply with industry and organisational requirements

National Occupational Standard



Overview

This unit is about knowing, understanding, and complying with the requirements of the organization and the textile industry.

AMH/N 9004

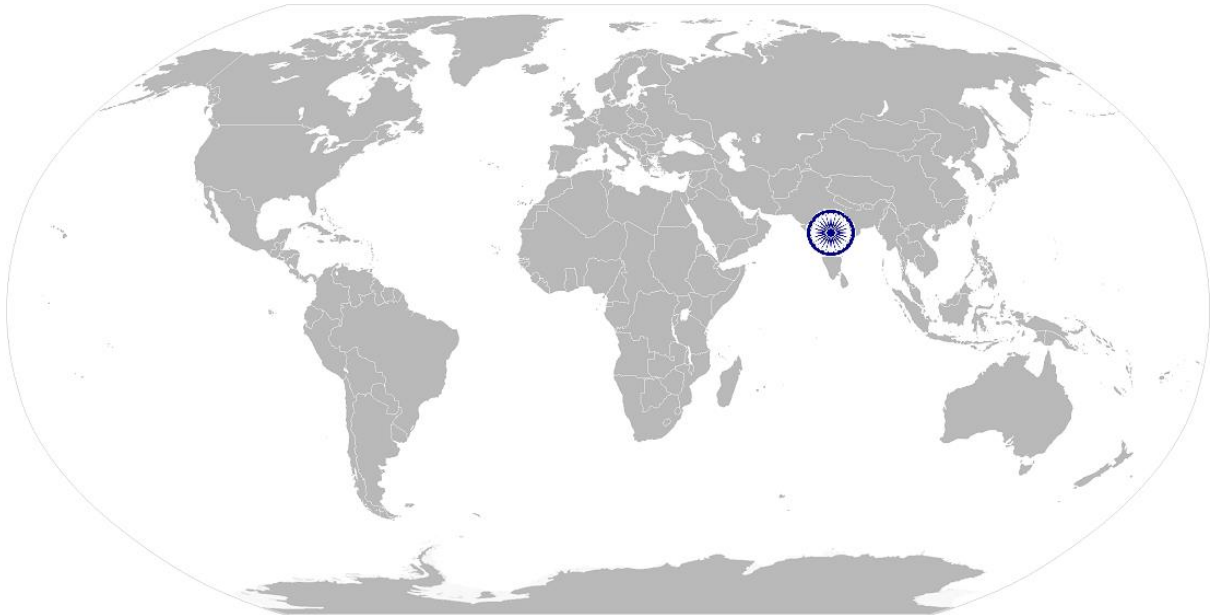
Comply with industry and organisational requirements

National Occupational Standard	Unit Code	TSC/ N9004
	Unit Title (Task)	Comply with industry and organizational requirements
	Description	This unit is about knowing, understanding, and complying with the requirements of the organization and the textile industry
	Scope	This unit/task covers the following: <ul style="list-style-type: none"> ▪ self development ▪ team work ▪ organizational standards ▪ industry standards
	Performance Criteria (PC) w.r.t. the Scope	
	Elements	Performance Criteria
	Self- development	To be competent, you must be able to: PC1. perform own duties effectively PC2. take responsibility for own actions PC3. be accountable towards the job role and assigned duties PC4. take initiative and innovate the existing methods PC5. focus on self-learning and improvement
	Team work	PC6. co-ordinate with all the team members and colleagues PC7. communicate politely PC8. avoid conflicts and miscommunication
	Organizational standards	PC9. know the organisational standards PC10. implement them in your performance PC11. motivate others to follow them
	Industry standards	PC12. know the industry standards PC13. align them with organisation standards
	Knowledge and Understanding (K)	
	A. Organizational Context (Knowledge of the company/ organization and its processes)	You need to know and understand: KA1. Standard operating procedures (SOP) and regulations in a textile mill KA2. reporting to the supervisor or higher authority KA3. knowledge of organization standards KA4. knowledge of industry standards
	B. Technical Knowledge	You need to know and understand: KB1. process and material flow in a textile mill KB2. importance of complying with the standards KB3. guidelines for cleaning the various parts of machine
Skills (S)		
A. Core Skills/ Generic Skills	Writing Skills You need to know and understand how to: SA1. Write clear and short sentences	

AMH/N 9004

Comply with industry and organisational requirements

	Reading Skills
	You need to know and understand how to: SA2. comprehend written instructions
	Oral Communication (Listening and Speaking skills)
	SA3. talk effectively with others SA4. put forward your point SA5. listen to others
B. Technical skills	you need to know and understand : SC1. Organizational requirements SC2. your responsibilities at the workplace SC3. procedure to comply with the industry standards

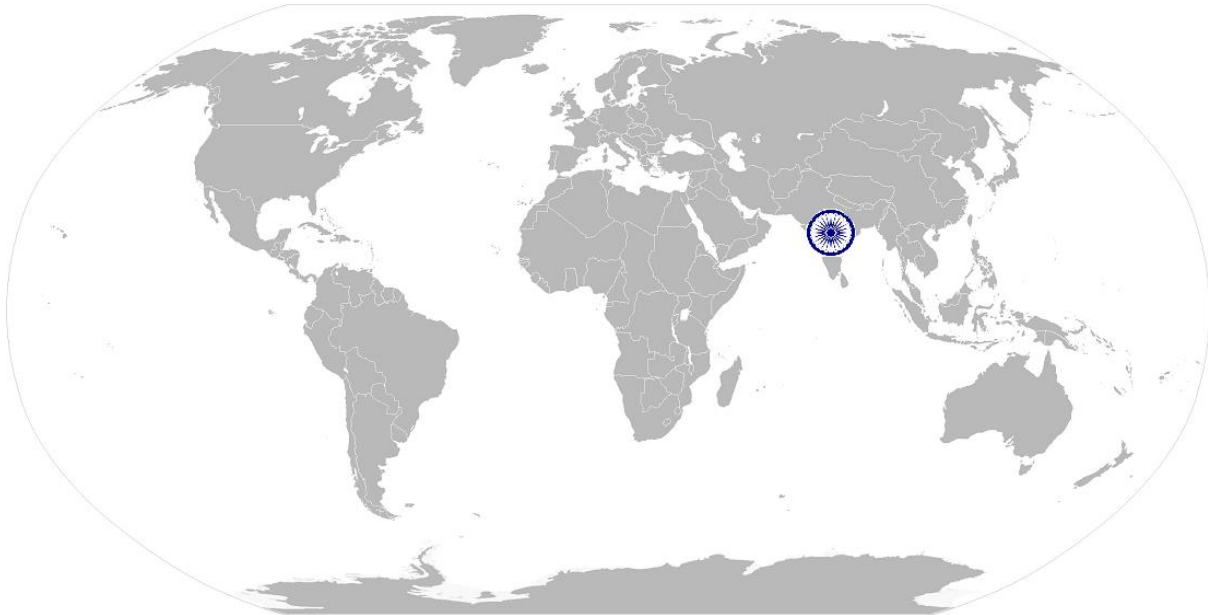


AMH/N 9004

Comply with industry and organisational requirements

NOS Version Control

NOS Code	TSC/N 9004		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/01/15
Occupation	Maintenance	Next review date	01/03/16



Assessment Criteria

Job Role: Fitter - Autoloom Weaving Machine Qualification Pack: Fitter - Autoloom Weaving Machine Sector Skill Council: Textile						
Guidelines for assessment: - 1. Criteria for assessment for each qualification pack will be created by the Sector Skill Council. Each performance criteria (PC) will be assigned marks proportional to its importance in NOS. SSC will also lay down proportion of marks for theory & skill practical for each PC. 2. The assessment for the theory part will be based on knowledge bank of question created by the SSC. 3. Individual assessment agencies will create unique evaluations for skill practical for every student at each examination/training centre (as per assessment criteria below). 4. To pass the qualification pack, every trainee should score a minimum of 80%.						
National Occupational Standards (NOS)	Performance Criteria (PC)	Total Marks	Out Of	Marks Allocation		
				Practical	Theory	Viva
1. TSC/N 2403 -Taking charge of shift and handing over shift to operator	PC1. come at least 15 - 20minutes earlier to the work spot	50	3	2	0	1
	PC2. ensure that the necessary tools, gauges etc, are in place.		4	2	2	0
	PC3. meet the previous shift fitter, discuss with him regarding the issues faced by him with respect to the quality or production or spare or safety or any other specific instruction etc.		4	2	1	1
	PC4. check for the availability of the weft & the condition of the same		2	1	1	0
	PC5. check the condition of the running beams , for cross ends, ends pulling out particularly at the selvages		3	2	1	0
	PC6. take “ rebound round” of the allotted looms		5	3	1	1
	PC7. check the shuttle condition in the allotted looms		3	2	1	0
	PC8. note down the break downs		2	2	0	0
	PC9. check for the size of the cloth		5	3	1	1

Assessment Criteria

	rolls & to see whether any indication is there in the cloth rolls					
	PC10. check the cleanliness of the machines & other work areas		3	2	1	0
	PC11. check whether any spare/raw material/ tool / fabric/ any other material are thrown under the machines or in the other work areas.		2	1	1	0
	PC12. question the previous shift fitter for any deviation in the above and bring the same to the knowledge of his/ her shift superior as well that of the previous shift as well.		3	2	0	1
	PC13. hand over the shift to the incoming fitter in a proper manner & get clearance from the incoming counterpart before leaving the work spot		3	3	0	0
	PC14. report to his shift superiors as well as that of the incoming shift, in case his/ her counterpart doesn't come for the incoming shift. in that case, the shift has to be properly handed over to the incoming shift superior & get clearance from him before leaving the work spot		3	2	0	1
	PC15. report to his shift superior about the quality / production / safety issues/ any other issue faced in his/ her shift and should leave the department only after getting concurrence for the same from His/ Her superiors		5	2	2	1
			50	31	12	7
	Total	Weightage %		62.00%	24.00%	14.00%
1						
2. TSC/N 2404 Maintaining Autoloom	PC1. ensure that the production is commenced only after the sample is	150	2	2	0	0

Assessment Criteria

Weaving Machine	approved					
	PC2. ensure that bulk production is started only after the first roll is approved	4	3	1	0	
	PC3. ensure that warp stop motion functions properly, so that no end problem , warp float etc. doesn't occur on the fabrics	5	3	1	1	
	PC4. ensure that centre weft fork functions properly so that fabrics don't get rejected due to weft crack,	2	2	0	0	
	PC5. ensure that scissor & temple cutter function properly so that fabrics don't get rejected due to lashing- in	4	3	1	0	
	PC6. maintain take – up & let-off mechanisms properly so that fabrics don't get rejected due to let-off faults, take-up faults etc.	3	2	1	0	
	PC7. ensure proper functioning of stop motions, back rest, shedding, anti crack motion & to ensure no play in sley, crank arm. etc., so that fabrics are free from defects like starting mark, bad shedding etc.	4	3	1	0	
	PC8. maintain temple setting , reed setting so that fabrics don't get rejected for reasons like “ temple cut”, temple mark”, reed mark”	3	2	1	0	
	PC9. see that automatic weft replenishment mechanism functions properly	2	2	0	0	
	PC10. see that shuttle condition is good	1	1	0	0	
	PC11. see that shuttle reaches the boxes without any “ rebound”	5	3	1	1	
	PC12. see that the condition of heald wires, heald frames , reed etc. are in good condition	2	2	0	0	
	PC13. see that the reversing mechanism functions properly	3	2	1	0	
	PC14. see that the loom runs with the actual required belts and should see that there is no slippage in the same, so as to ensure that the loom works	4	3	1	0	

Assessment Criteria

	in the recommended speed.				
	PC15. see that replenishment of spares or attending to break downs is done in the prescribed time.	3	3	0	0
	PC16. ensure required humidity in the loom shed	4	3	1	0
	PC17. check the knotted looms & ensure that knotting is carried out without cross ends	2	2	0	0
	PC18. check the sort change loom & ensure that drawing & reaching was carried out without any cross ends.	3	2	1	0
	PC19. ensure “looms breakage study” and check the quality of both warp & weft yarn. for any deviation the same has to be brought to the knowledge of the higher authority.	4	3	1	0
	PC20. check the sizing quality and for any deviation, the same has to be brought to the notice of the higher authority.	2	2	0	0
	PC21. ensure proper dropper cleaning	3	2	1	0
	PC22. ensure that the looms are cleaned properly as per the below schedule <ul style="list-style-type: none"> • Daily cleaning • Cleaning during knotting • Cleaning during sort changes 	4	2	2	0
	PC23. ensure that the looms are lubricated using grease, gear-tack oil etc., as per the schedule <ul style="list-style-type: none"> • Daily points • Weekly points • Monthly points • Once in 6 months • yearly once 	3	1	2	0

Assessment Criteria

PC24. To carry out preventive maintenance as per the schedule <ul style="list-style-type: none"> • Daily checking • Weekly once • Bi monthly • Monthly • 6 months once • Yearly 	5	2	3	0
PC25. apply new shuttle , in the looms where all maintenance schedules are strictly followed	4	3	1	0
PC26. ensure the life of all the spares through effective maintenance	3	2	1	0
PC27. control “ pirn breakages” & to maintain “ empty pirn stock” on weekly basis, so as to ensure of the life.	2	2	0	0
PC28. check “ shuttle condition” on weekly basis and initiate corrective action	3	2	1	0
PC29. maintain “ spare changing details ” note, for the following details. <ul style="list-style-type: none"> • Loom no. • Name of the spare • Side (if any) • Part no. • Name of the supplier • Make • Date of application • Date of removal • Reason for removal • Life of item 	6	3	3	0
PC30. salvage the “ broken spare “ & to avail new spare, only after producing the “ old spare to the Stores.	4	3	1	
PC31. maintain “ Sort Muster” as per the below details <ul style="list-style-type: none"> • Loom No. • Construction Details • Warp Material details • Warp Count • Warp Mill Name • Warp Yarn Test Report(Test 	5	2	3	0

Assessment Criteria

	Parameters) <ul style="list-style-type: none"> • Reed Used • Total Ends Used • Name Of The Sizing • Warping Breakage Rate • Average Warp Count • Size Pick Up • Warp break/ loom hour • Weft Material Details • Weft Count • Weft Mill Name • Weft Yarn Test Report(Test Parameters) • Reed Space • Weft breakage per loom hour] • Average Loom Efficiency • Loom Speed • Average Production in Kilo Picks/loom day • Production in meters/loom day • Date of knotting • Knotted meters • Date of exhaustion • Produced meters • Warp Crimp • Warp Consumption/meter (Excluding Size Add On) • Warp Wt in kgs/ meter (Including Size add on) • Weft Consumption/meter • Total cloth wt in kgs/ meter • GSM • Fabric doffed • Fabric inspected • Fabric Passed • Fabric Rejected • Rejection % • Reason For Rejection • Warp Waste % • Weft Waste % 					
	PC32. maintain effective working of “ Generator”	3	2	1	0	
	PC33. see that “ Air” is not misused Can use air for cleaning, only in the areas, where it is allowed	2	2	0	0	

Assessment Criteria

	PC34. ensure proper maintenance of " Air Compressor"	3	2	1	0
	PC35. ensure that " Loom Cards " for all the required details are placed on all the looms <ul style="list-style-type: none"> • Loom No. • Construction details • Reed Count • Reed Space • Weft Count • Pick Wheel • Winding Spindle No. • Drawing Method 	6	3	3	0
	PC36. see that the weft yarn is completely used , without giving room for additional wastage of raw materials. For any quality issue or defective cone etc., the same has to be brought to the notice of the Superiors.	3	2	1	0
	PC37. Maintain " Knotting Entry Note" with the following details <ul style="list-style-type: none"> • Loom No. • Construction Details • Date Of Knotting • Time of Exhaustion • Cleaning Completed Time • Beam Loading Completed Time • Knotting Completed Time • Loom Run Time • Total Stopped Time For Knotting • Name Of the Sizing • Set No. • Beam Nos. • Beam Meters • Old Warp Waste kgs • New Warp Waste kgs • Cleaning Quality • Knotting Quality 	5	2	3	0
	PC38. Ensure Relative Humidity in the Department is maintained	3	2	1	0
	PC39. ensure correct quality of thrums are there & see that the same are properly tied	4	2	2	0

Assessment Criteria

	PC40. check the knotted loom for knotting quality etc. Double ends have to be removed		4	3	1	0
	PC41. report to superiors for any deviation in the same & for any other quality issue		2	2	0	0
	PC42. ensure that cloth rolls are doffed whenever/ wherever necessary		3	2	1	0
	PC43. give preference to safety . Should not enter the area, where He/ She are not allowed. Should not do a job in which training has not being given		5	3	2	0
	PC44. ensure that no raw material/ cloth/ spare/ tool / any other material is thrown under/ near the machines or in the other work areas.		3	2	1	0
			150	101	47	2
	Total	Weight age %		67.33%	31.33%	1.33%
3.TSC/N9001(Maintaining work area, tools and machines)						
	PC1. handle materials, machinery, equipment and tools with care and use them in the correct way	50	4	1	2	1
	PC2. use correct lifting and handling procedures		4	1	2	1
	PC3. use materials to minimize waste		3	1	1	1
	PC4. maintain a clean and hazard free working area		3	1	1	1
	PC5. maintain tools and equipment		4	2	1	1
	PC6. carry out running maintenance within agreed schedules		4	1	2	1
	PC7. carry out maintenance and/or cleaning within one's responsibility		4	1	2	1
	PC8. report unsafe equipment and other dangerous occurrences		4	1	2	1
	PC9. ensure that the correct machine guards are in place		3	1	1	1
	PC10. work in a comfortable position with the correct posture		3	1	1	1

Assessment Criteria

	PC11. use cleaning equipment and methods appropriate for the work to be carried out		3	1	1	1
	PC12. dispose of waste safely in the designated location		4	1	2	1
	PC13. store cleaning equipment safely after use		3	1	1	1
	PC14. carry out cleaning according to schedules and limits of responsibility		4	1	2	1
			50	15	21	14
	Total	Weight age %	50	30	42	28
4.TSC/N9002 (Working in a team)	PC1. be accountable to the own role in whole process	50	5	3	1	1
	PC2. perform all roles with full responsibility		4	2	1	1
	PC3. be effective and efficient at workplace		4	1	2	1
	PC4. properly communicate about company policies		4	1	1	2
	PC5. report all problems faced during the process		4	1	1	2
	PC6. talk politely with other team members and colleagues		4	1	1	2
	PC7. submit daily report of own performance		5	2	2	1
	PC8. adjust in different work situations		4	2	1	1
	PC9. give due importance to others' point of view		4	1	1	2
	PC10. avoid conflicting situations		4	1	2	1
	PC11. develop new ideas for work procedures		4	1	2	1
	PC12. improve upon the existing techniques to increase process efficiency		4	1	2	1
				50	17	17
Total	Weight age %	50	34	34	32	

Assessment Criteria

5.TSC/N9003 (Comply with health, safety and security at work place)	PC1. comply with health and safety related instructions applicable to the workplace	100	5	2	2	1
	PC2. use and maintain personal protective equipment such as “ ear plug” “ nose mask “ “ head cap” etc., as per protocol		5	2	2	1
	PC3. carry out own activities in line with approved guidelines and procedures		4	2	1	1
	PC4. maintain a healthy lifestyle and guard against dependency on intoxicants		4	2	1	1
	PC5. follow environment management system related procedures		4	2	1	1
	PC6. identify and correct (if possible) malfunctions in machinery and equipment		5	2	2	1
	PC7. report any service malfunctions that cannot be rectified		4	2	1	1
	PC8. store materials and equipment in line with organizational requirements		4	1	2	1
	PC9. safely handle and remove waste		4	1	2	1
	PC10. minimize health and safety risks to self and others due to own actions		5	2	2	1
	PC11. seek clarifications, from supervisors or other authorized personnel in case of perceived risks		4	2	0	2
	PC12. monitor the workplace and work processes for potential risks and threat		5	2	2	1
	PC13. carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned		5	2	2	1
	PC14. report hazards and potential risks/ threats to supervisors or other authorized personnel		4	1	2	1
	PC15. participate in mock drills/ evacuation procedures organized at		4	2	2	0

Assessment Criteria

	the workplace					
	PC16. undertake first aid, fire-fighting and emergency response training, if asked to do so		5	2	2	1
	PC17. take action based on instructions in the event of fire, emergencies or accidents		5	2	2	1
	PC18. follow organization procedures for shutdown and evacuation when required		4	2	1	1
	PC19. identify different kinds of possible hazards (environmental, personal, ergonomic, chemical) of the industry		4	2	1	1
	PC20. recognize other possible security issues existing in the workplace		4	2	1	1
	PC21. recognize different measures to curb the hazards		4	2	1	1
	PC22. communicate the safety plan to everyone		4	2	1	1
	PC23. attach disciplinary rules with the implementation		4	2	1	1
			10	43	34	23
	Total	Weightage %	100	43	34	23
7.TSC/N9004 (Comply with industry and organizational requirements)	PC1. perform own duties effectively	50	4	1	2	1
	PC2. take responsibility for own actions		4	1	2	1
	PC3. be accountable towards the job role and assigned duties		4	2	1	1
	PC4. take initiative and innovate the existing methods		3	1	1	1
	PC5. focus on self-learning and improvement		4	1	2	1
	PC6. co-ordinate with all the team members and colleagues		4	1	2	1
	PC7. communicate politely		4	1	1	2
	PC8. avoid conflicts and		4	1	2	1

Assessment Criteria

	miscommunication					
	PC9. know the organizational standards		4	2	1	1
	PC10. implement them in your performance		4	1	2	1
	PC11. motivate others to follow them		3	1	1	1
	PC12. know the industry standards		4	3	1	0
	PC13. align them with organization standards		4	2	1	1
			50	18	19	13
	Total	Weightage %	50	36	38	26
	Total		450	225	150	75
Grand Total			450			