

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

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Introduction

Qualifications Pack – Knotting Machine Operator

SECTOR: TEXTILE

SUB-SECTOR: WEAVING

OCCUPATION: WEAVING

REFERENCE ID: TSC/Q 2205

ALIGNED TO: NCO-2004 / 8262.80

Brief Job Description: A Knotting Machine Operator is a job-role in a weaving preparatory department. The responsibility of a Knotting Machine Operator is to Knot the warp ends in the run out beams with that of the fresh beams. efficiently so as to get quality output with minimum defects giving due importance to safety and environment aspects

Personal Attributes: A Knotting Machine Operator 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 2205		
	Job Role	Knotting Machine Operator		
	Credits (NSQF)	TBD	Version number	1.0
	Sector	Textile	Drafted on	15/12/14
	Sub-sector	Weaving	Last reviewed on	21/1/15
	Occupation	Weaving	Next review date	01/03/16
Job Role	Knotting Machine Operator			
Role Description	To knot warp ends from run out beams with that of fresh beams, efficiently so as to get quality output with minimum defects, giving due importance to safety & environmental aspects			
NSQF level	4			
Minimum Educational Qualifications	Preferably Class 10 th			
Maximum Educational Qualifications	N/A			
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/N2209 (Taking charge of shift and handing over shift to operator) TSC/N2210 (Operate knotting machine) TSC/N9001 (Maintain work area, tools and machines) TSC/N9002 (Working in a team) TSC/N9003 (Maintain health, safety and security at work place) TSC/N9004 (Comply with industry & organizational requirements) <p>Optional: Not Applicable</p>			
Performance Criteria	As described in the relevant OS units			

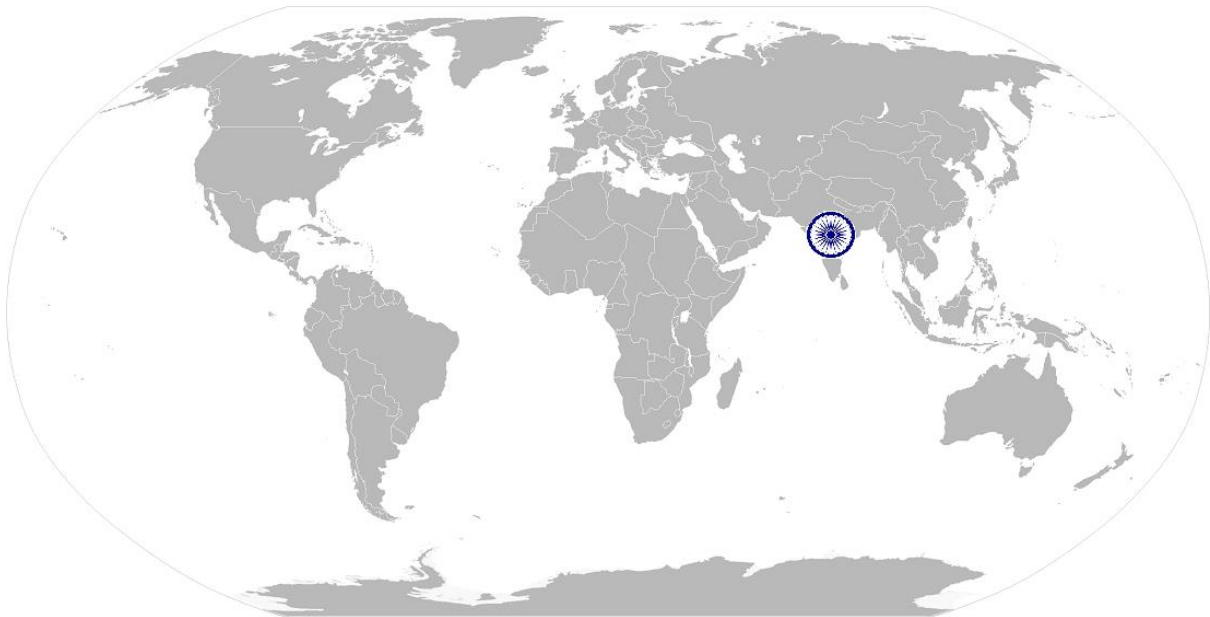
Table 1: Glossary of Key Terms

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 Qualifications Framework
NCO	National Classifications of Occupation
TBD	To Be Determined
TSC	Tactile Sector Skill Council
NSDC	National Skill Development Corporation

Acronyms

National Occupational Standard



Overview

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

TSC/N 2209

Taking charge of shift and handing over shift to operator

Unit Code	TSC/N 2209
Unit Title (Task)	Taking charge of shift and handing over shift to operator
Description	This unit is about taking charge of shift from previous shift operator and relieving the responsibilities to the next shift operator
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> ▪ Taking charge of the shift ▪ Handing over the shift
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Take Charge of the Shift	<p>To be competent, you must be able to:</p> <p>PC1. come at least 10 - 15 minutes earlier to the work spot.</p> <p>PC2. check for the necessary items like “gum tape”, “knotting comb”, “and knotting brush”, “knife” etc.</p> <p>PC3. meet the previous shift knotting machine operator, discuss with him/ her regarding the issues faced by them with respect to the quality or machine, knotting stand etc., or safety or any other specific instruction etc.</p> <p>PC4. check the run outs for his/ her shift.</p> <p>PC5. check whether any sort change program is there for the said run outs.</p> <p>PC6. check the availability of the beams and accordingly to inform the same to the higher authority.</p> <p>PC7. check the availability of the knotting needles required for the running counts of the running beams.</p> <p>PC8. check the condition of the knotting stand, knotting machine, knotting needles etc.</p>
Handing over the Shift	<p>PC9. make entries in the “knotting entry note” for all the knotting carried out in his/ her shift.</p> <p>PC10. hand over the shift to the incoming knotting machine operator in a proper manner & get clearance from the incoming counterpart before leaving the work spot</p> <p>PC11. report to his/ her shift superiors as well as that of the incoming shift, in case his/ her counterpart doesn't doesn't come for work for the incoming shift. in that case, the shift has to be properly handed over to the incoming shift superior & get clearance from him/ her, before leaving the work spot</p> <p>PC12. report to his/ her 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	<p>You need to know and understand:</p> <p>KA1. the organization's policies & standard operating procedures (SOP)</p>

TSC/N 2209

Taking charge of shift and handing over shift to operator

<p>(Knowledge of the company/ organization and its processes)</p>	<p>KA2. awareness & knowledge of customers KA3. potential hazards associated with the machines and the safety precautions must be taken KA4. protocol to obtain more information on work related tasks KA5. how to contact person in case of queries on procedure or products and for revolving issues related to defective machines, tools, materials & equipments KA6. details of the various job rolls & responsibilities KA7. documentation and reporting formats KA8. work targets & review machine with superiors KA9. protocol and format for reporting work related risks/ problems KA10. method of obtaining /giving feed back with respect to performance KA11. importance of team work .harmonious working relationships KA12. process for offering /obtaining work related assistance KA13. responsibilities under health, safety and environmental legislation KA14. guidelines for storage & disposal of waste materials</p>
<p>B. Technical Knowledge</p>	<p>The user/individual on the job needs to know and understand:</p> <p>KB1. minimum quality requirements of the product with respect to permissible/non-permissible defects KB2. about the needles to be used for the different materials, different counts etc. KB3. yarns from natural fibers - cotton, silk, wool KB4. yarns from manmade fibers - polyester, nylon, viscose KB5. blended yarns - polyester cotton, polyester viscose KB6. knotted warp tying machine KB7. “ j” tex warp tying machine KB8. “ hindte” warp tying machine KB9. “ uster “ warp tying machine KB10. shade variation KB11. soft sized beams KB12. size patches KB13. sunken ends KB14. sizing stain KB15. beam centre oil KB16. safety mechanisms of the machines & should ensure that the same are in order KB17. how to stop motions & should ensure that the same are in order KB18. about the functional operations of the machines, where he/ she is working</p>
<p>Skills (S)</p>	
<p>A. Core/ Generic Skills</p>	<p>Participation You need to know and understand how to: SA1. plan and manage work routine based on instructions from supervisor</p>

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Taking charge of shift and handing over shift to operator

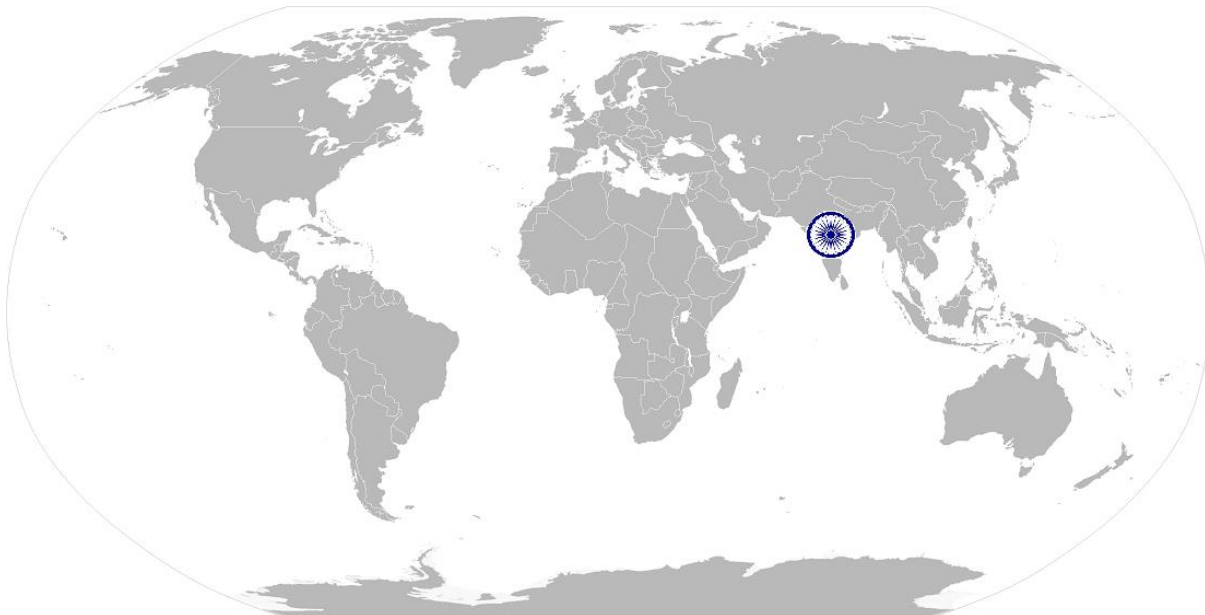
	<p>SA2. participate willingly in the various programs/ meetings that will be conducted by the superiors & put forth the suggestions in the interest of the company</p> <p>SA3. participate willingly in the " quality circles" that will be formed by the superiors</p> <p>SA4. extend voluntary supports and 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>Writing Skills</p>
	<p>You need to know and understand how to: SA5. Write clear and short sentences</p>
	<p>Reading Skills</p>
	<p>You need to know and understand how to: SA6. read and comprehend written instructions SA7. read any application sent by other colleagues</p>
	<p>Oral Communication (Listening and Speaking skills)</p>
	<p>You need to know and understand how to: SA8. communicate with supervisor appropriately SA9. talk to others to convey information effectively</p>
<p>B. Professional Skills</p>	<p>Problem Solving</p>
	<p>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</p>
	<p>Attention to Detail</p>
	<p>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</p>
<p>C. Technical Skills</p>	<p>You need to know and understand :</p> <p>SC1. how to see the knotting & running of machine by a maximum of 4 hrs, from time of run out. (for total ends of around 20,000)</p> <p>SC2. how to see that not more than 10 ends (for 20,000 ends) are left out in the beams due to double end or any other problem</p> <p>SC3. how to see that there is no cross ends in the knotted beams.</p>

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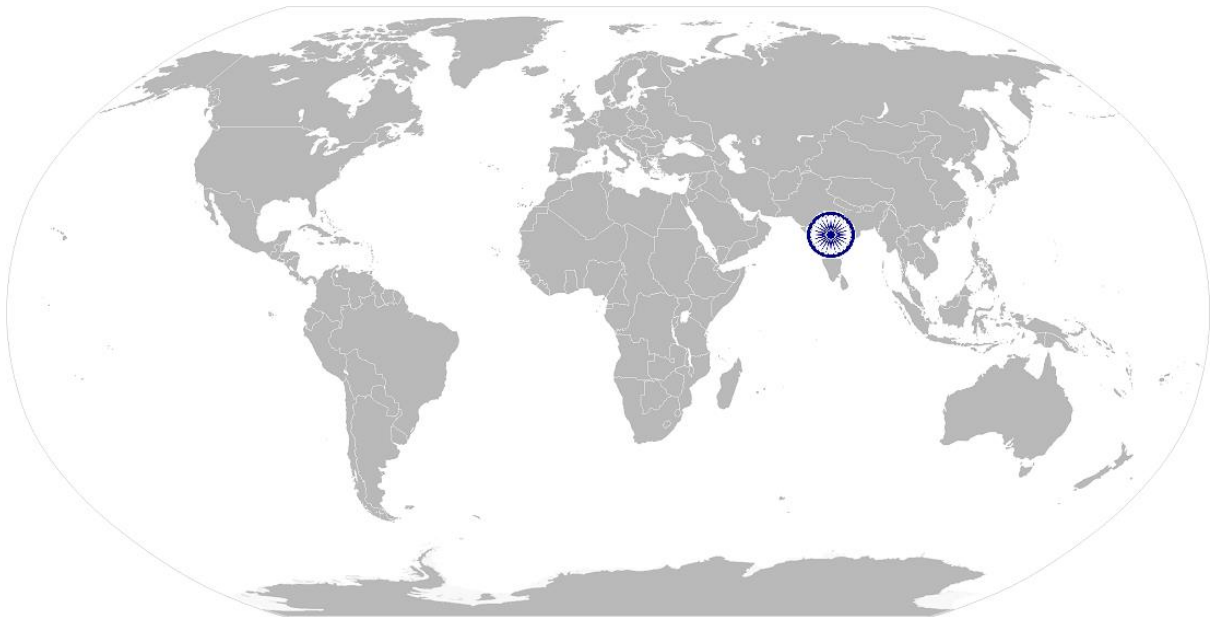
Taking charge of shift and handing over shift to operator

NOS Version Control

NOS Code	TSC/N 2209		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/1/15
Occupation	Weaving	Next review date	01/03/16



National Occupational Standard




Overview

This unit provides performance criteria, knowledge & understanding and skills & abilities required to operate knotting machine.

TSC/N2210

Operate the Knotting Machine

National Occupational Standard	Unit Code	TSC/N 2210
	Unit Title (Task)	Operate the Knotting Machine
	Description	This unit provides performance criteria ,knowledge & understanding and skills & abilities required to operate a knotting machine, so as to get quality output & minimum defects, without entertaining any damage to the people, the machine etc., & without spoiling the environmental aspects.
	Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> ▪ Mounting Of Beams on the Looms ▪ Dressing Of Beams ▪ Knotting ▪ Running of knotted looms
	Performance Criteria (PC) w.r.t. the Scope	
	Elements	Performance Criteria
	Mounting Of Beams on the Looms	<p>To be competent, you must be able to:</p> <p>PC1. check whether the loom is stopped with warp, just required for (around 2-3 meters) knotting. if not, it has to be ensured</p> <p>PC2. report to the higher authority, if the loom is stopped with excess warp, doe to beam complaint, </p> <p>PC3. report to the higher authority when the knotting has to be carried out in the looms with twin beams (in most of the cases), to see whether there is difference in the left our warp meters.</p> <p>PC4. correct the dropper crossing (if any)</p> <p>PC5. check whether any ends are left out in the run out beams, particularly near the selvages. to bring the same to the knowledge of the higher authority and act as per his/ her instructions.</p> <p>PC6. check the condition of the reed on the loom in the selvedge sides. for any deviation, the same has to be brought to the knowledge of the higher authority and act as per his/ her advice.</p> <p>PC7. check whether any bead formation is there in the droppers. if so ,the same has to be removed</p> <p>PC8. check the condition of the run out beams for the beam fault like“soft size”, “size patches”, “shade variation” etc. to check the suitability of the said beams for knotting. the same has to be brought to the knowledge of the higher authority and act as per his/ her advice.</p> <p>PC9. cut the old warp as to be cut in the run out looms , leaving 2-3 meters of warp length required for knotting.</p> <p>PC10. cover the left warp with card board or polythene sheet or with hope sack if the qty left out due to beam complaint is more as per the advice of the higher authority, in the run out beams. the following details have to be</p>

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Operate the Knotting Machine

	<p>written in a “ beam ticket “ and the same has to be pasted in the said beams, peel out the earlier beam tickets pasted in the said beams:-</p> <p>PC11. remove the cut empty beams from the loom shed and have to be brought to the place, where they have to be stored.</p> <p>PC12. clean thoroughly the loom, an all the places, as advised by the higher authority.</p> <p>PC13. ensure proper lubrication as per the advice of the higher authority.</p> <p>PC14. check whether the fresh beams are properly covered for any variation, the same has to be brought to the notice of the higher authority.</p> <p>PC15. check the loom card to ascertain the fresh beams to be loaded, by checking the following:- warp count total ends set no. beam nos (for the opposite sides) beam meters (there should not be any difference in meters)</p> <p>PC16. bring the fresh beams from the place they are stored to the loom, where knotting has to be carried out.</p> <p>PC17. check the condition of the fresh beams after removing the beam wrappers. for transit damages and accordingly the same has to be brought to the notice of the higher authority. lie that, the fresh beam has to be checked for beam complaint like “ sunken ends” “ soft size” , “ size patches “ etc., further action can be carried out as per the advice of the higher authority only.</p> <p>PC18. mount the fresh beams have on the loom carefully without imparting damage to the raw material, beams, machine , or for any person including himself or herself.</p> <p>PC19. ensure beam alignment , in case of “ twin beams”</p>
<p>Dressing Of Beams</p>	<p>PC19. ensure “no cross “in the old warp. a group of not more than 100 ends can be taken & brushed properly.</p> <p>PC20. check for the sizing tapes in the fresh beams</p> <p>PC21. cut the fresh warp in the second tape</p> <p>PC22. bring the fresh warp to the knotting stand without any cross using knotting comb.</p> <p>PC23. correct the cross in the old warp also using knotting comb, before bringing the same to the knotting stand.</p> <p>PC24. dress the warp sheet carefully without giving room for “cross “or“ends cit” etc.</p> <p>PC25. weigh the knotting waste & the same has to be recorded in the knotting entry note”</p>

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Operate the Knotting Machine

	<p>PC26. tie the “thrums “(sufficient enough till the run out) on the loom, neatly.</p> <p>PC27. collect the knotting waste & store in the place earmarked.</p>
Knitting	<p>PC28. use the needle that is earmarked for the beams mounted.</p> <p>PC29. check the machine & the needle by doing few knots. for any deviation to bring the same to the notice of the higher authority to do the knotting of the beams in the speed as advised by the higher authority.</p> <p>PC30. check for “double end”, “knot slippage” etc. through close monitoring of the performance of the knotting.</p>
Running Of Knotted Looms	<p>PC31. remove the knotting machine from the stand</p> <p>PC32. remove the knotting stand from the knotted loom collect the waste and to get the same stored in the place, earmarked.</p> <p>PC33. apply the beam locks (if any) & to see that the knotted beams are in tight condition so as to run the machine without any problem, till the knots reach the “ droppers zone”</p> <p>PC34. bring the knots out of the “ droppers” “ heald wires” “ reed “ etc., without entertaining breakage of much warp ends</p> <p>PC35. draw the broken warp ends</p> <p>PC36. ensure proper functioning of the warp stop motion</p> <p>PC37. apply “ colour cone” & to ensure no “ double end” is left out on the fabric</p> <p>PC38. see that the extra ends are routed through “ extra ends clips” & wound properly in the “ extra ends bobbin”</p> <p>PC39. see that the roll is doffed properly.</p> <p>PC40. see that the doffed roll is removed from the loom and brought to the place, earmarked.</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. 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. how to 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	<p>The user/individual on the job needs to know and understand:</p>

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Operate the Knotting Machine

Knowledge	<p>KB1. minimum quality requirements of the product with respect to permissible/non-permissible defects</p> <p>KB2. about the needles to be used for the different materials, different counts etc.</p> <p>KB3. yarns from natural fibers - cotton, silk, wool</p> <p>KB4. yarns from manmade fibers - polyester, nylon, viscose</p> <p>KB5. blended yarns - polyester cotton, polyester viscose</p> <p>KB6. knotted warp tying machine</p> <p>KB7. "j" tex warp tying machine</p> <p>KB8. "hindte" warp tying machine</p> <p>KB9. "uster" warp tying machine</p> <p>KB10. shade variation</p> <p>KB11. soft sized beams</p> <p>KB12. size patches</p> <p>KB13. sunken ends</p> <p>KB14. sizing stain</p> <p>KB15. beam centre oil</p> <p>KB16. safety mechanisms of the machines & should ensure that the same are in order</p> <p>KB17. how to stop motions & should ensure that the same are in order</p> <p>KB18. about the functional operations of the machines, where he/ she is working</p>
Skills (S)	
A. Core / Generic Skills	<p>Participation</p> <p>You need to know and understand how to:</p> <p>SA1. plan and manage work routine based on instructions from supervisor</p> <p>SA2. participate willingly in the various programs/ meetings that will be conducted by the superiors & put forth the suggestions in the interest of the company</p> <p>SA4. participate willingly in the " quality circles" that will be formed by the superiors</p> <p>SA5. 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", SA8001" GOTS certification " fair trade " etc.</p>
	<p>Writing Skills</p> <p>You need to know and understand how to:</p> <p>SA8. Write clear and short sentences</p>
	<p>Reading Skills</p> <p>You need to know and understand how to:</p> <p>SA9. read and comprehend written instructions</p> <p>SA10. read any application sent by other colleagues</p>
	<p>Oral Communication (Listening and Speaking skills)</p> <p>You need to know and understand how to:</p>

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Operate the Knotting Machine

	SA11. communicate with supervisor appropriately SA12. talk to others to convey information effectively
A. 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
B. Technical Skills	You need to know and understand : SC1. how to see the knotting & running of machine by a maximum of 4 hrs, from time of run out. (for total ends of around 20,000) SC2. how to see that not more than 10 ends (for 20,000 ends) are left out in the beams due to double end or any other problem SC3. how to see that there is no cross ends in the knotted beams

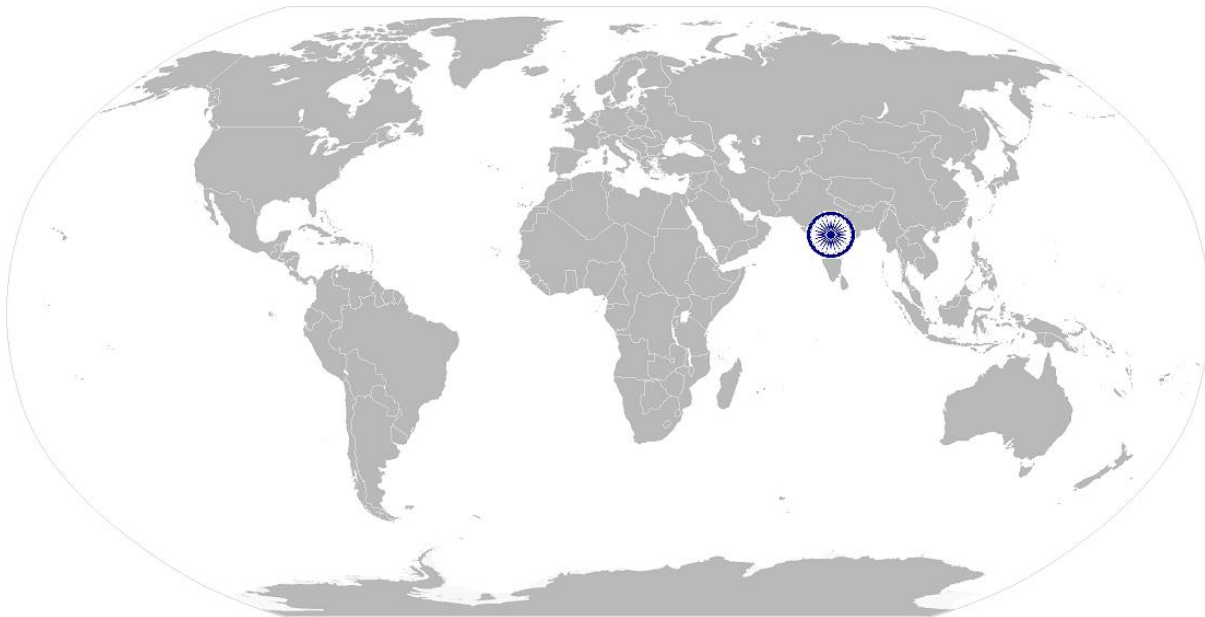


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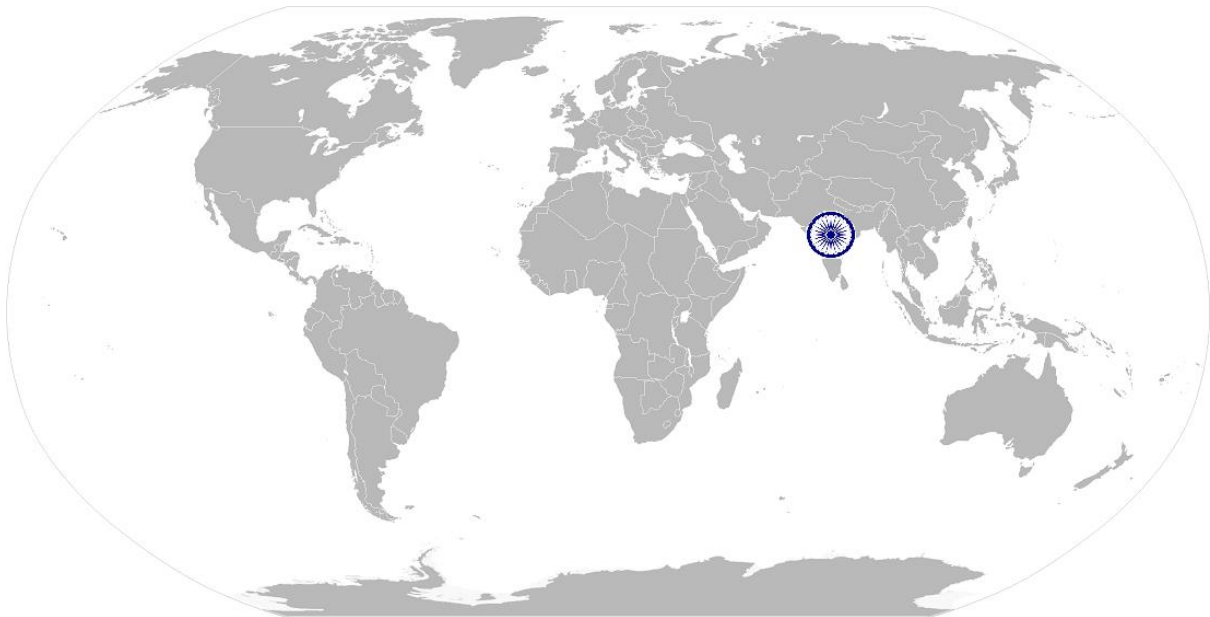
Operate the Knotting Machine

NOS Version Control

NOS Code	TSC/N 2210		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/1/15
Occupation	Weaving	Next review date	01/03/16



National Occupational Standard



Overview

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

TSC/N 9001

Maintaining work area, tools and machines

National Occupational Standard	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	<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/N 9001

Maintaining work area, tools and machines

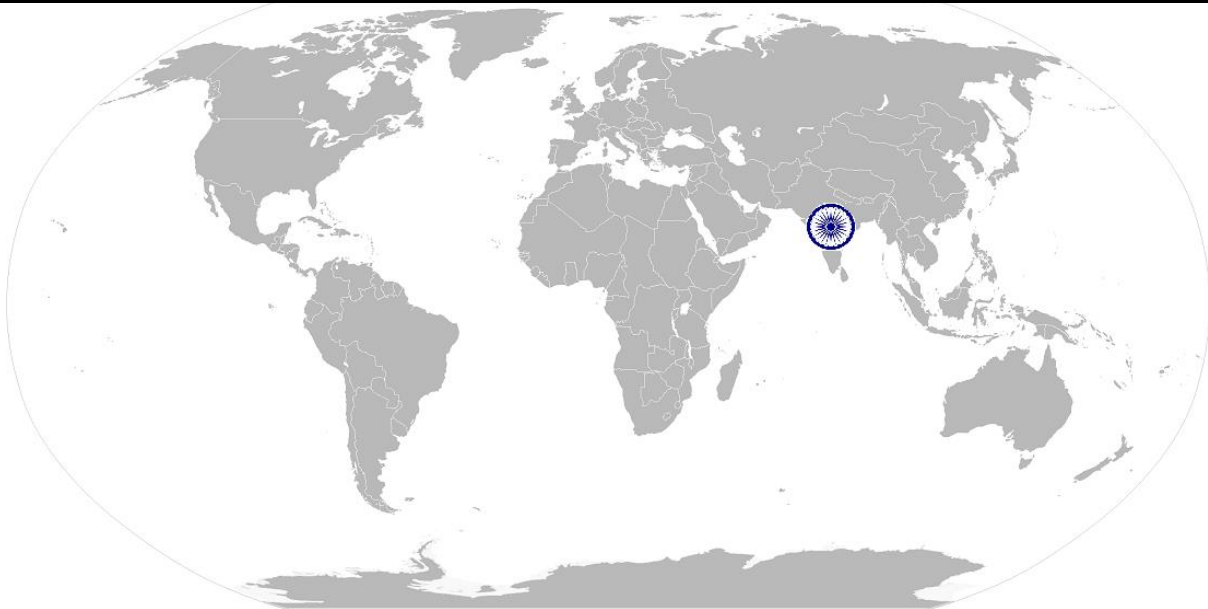
	KB5. different ways of minimizing waste KB6. the importance of running maintenance and regular cleaning KB7. effects of contamination on products i.e. machine oil, dirt, foreign materials KB8. common faults with equipment and the method to rectify KB9. maintenance procedures KB10. different types of 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
	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 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/N 9001

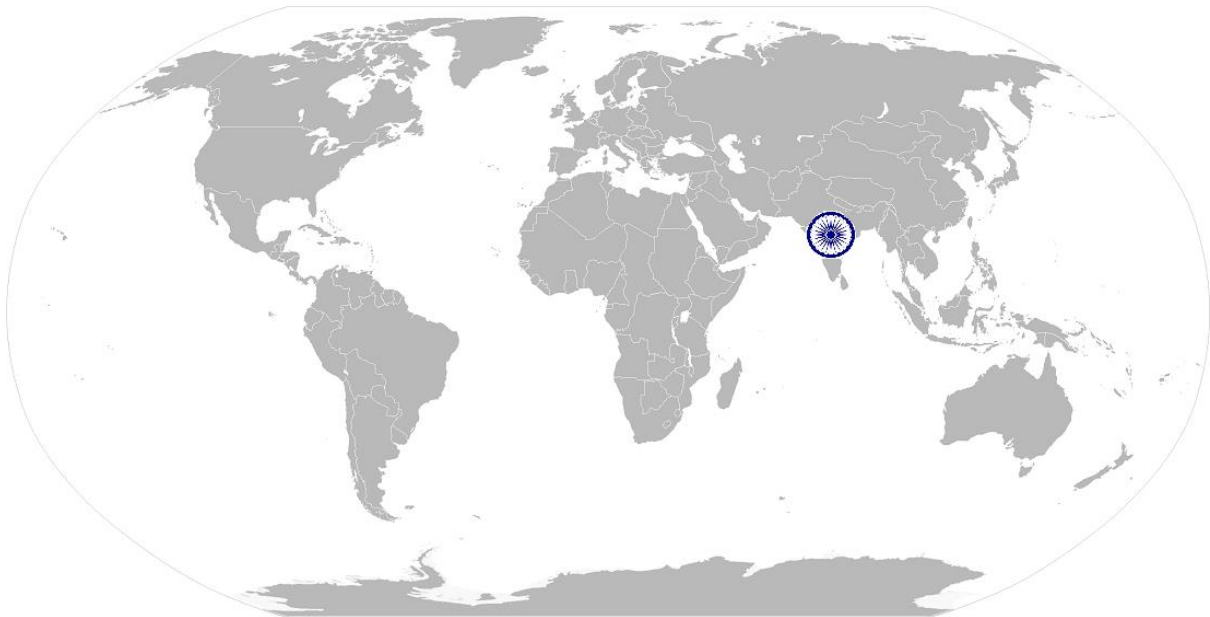
Maintaining work area, tools and machines

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	21/1/15
Occupation	Weaving	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/N 9002

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	This unit/task covers the following: <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	To be competent, you must be able to: PC1. be accountable to the own role in whole process PC2. perform all roles with full responsibility PC3. be effective and efficient at workplace
Communication	PC4. properly communicate about company policies PC5. report all problems faced during the process PC6. talk politely with other team members and colleagues PC7. submit daily report of own performance
Adaptability	PC8. adjust in different work situations PC9. give due importance to others' point of view PC10. avoid conflicting situations
Creative freedom	PC11. develop new ideas for work procedures PC12. improve upon the existing techniques to increase process efficiency
Knowledge and Understanding (K)	
A. Organizational Context	You need to know and understand: KA1. Standard operating procedures (SOP)and regulations in a textile mill KA2. procedure followed to get the final output in the mill KA3. safe working practices to be adopted in textile mill KA4. reporting to the supervisor or higher authority about any grievances faced
B. Technical Knowledge	KB1. the importance of the previous and next step of the process KB2. process flow in a textile mill and the concerned workers KB3. material flow in a textile mill and the required person KB4. functions of different parts of the machine KB5. tools and equipments used KB6. guidelines for operating the machine KB7. safety procedures to be followed in the machine
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to: SA1. Write clear and short sentences SA2. write daily work report SA3. write grievance complaint application
	Reading Skills

TSC/N 9002

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

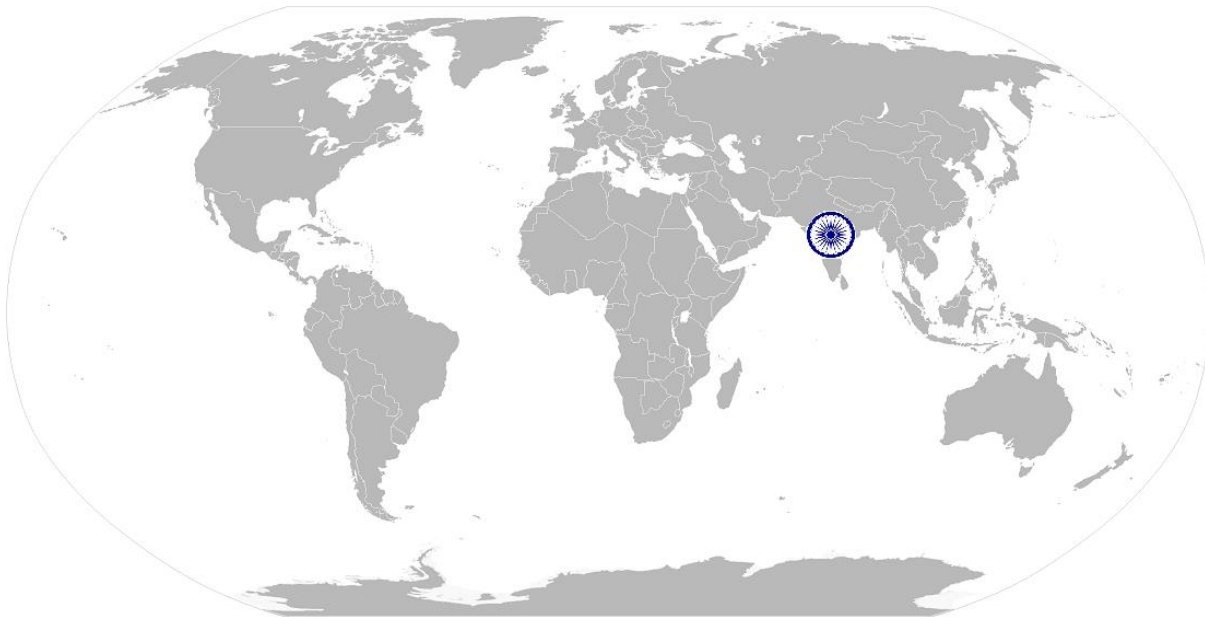


TSC/N 9002

Working in a team

NOS Version Control

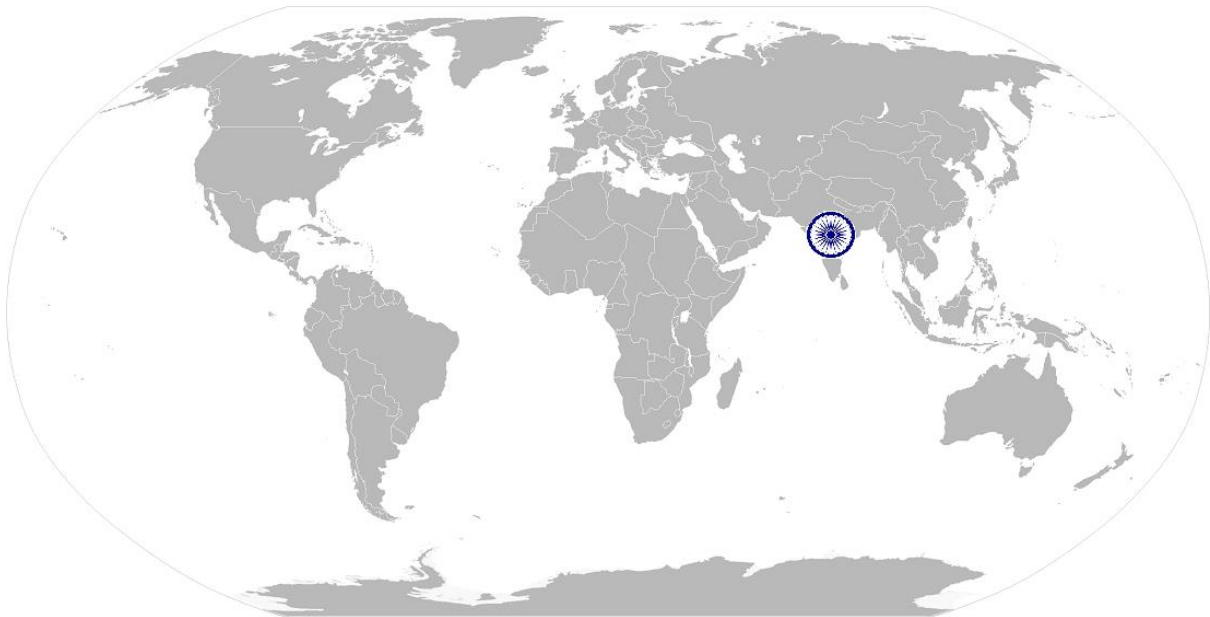
NOS Code	TSC/ N9002		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/1/15
Occupation	Weaving	Next review date	01/03/16



TSC/N 9003

Maintain health, safety and security at work place

National Occupational Standard



Overview

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

TSC/N 9003

Maintain health, safety and security at work place

National Occupational Standard	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	This unit/task covers the following: <ul style="list-style-type: none"> ▪ Comply with health, safety and security requirements at work ▪ Recognizing the hazards ▪ Planning the 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	To be competent, you must be able to: PC1. comply with health and safety related instructions applicable to the workplace PC2. use and maintain personal protective equipment such as “ear plug”, “ nose mask “, “ head cap” etc., as per protocol PC3. carry out own activities in line with approved guidelines and procedures PC4. maintain a healthy lifestyle and guard against dependency on intoxicants PC5. follow environment management system related procedures PC6. identify and correct (if possible) malfunctions in machinery and equipment PC7. report any service malfunctions that cannot be rectified PC8. store materials and equipment in line with organisational requirements PC9. safely handle and remove waste PC10. minimize health and safety risks to self and others due to own actions PC11. seek clarifications, from supervisors or other authorized personnel in case of perceived risks PC12. monitor the workplace and work processes for potential risks and threat PC13. carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned PC14. report hazards and potential risks/ threats to supervisors or other authorized personnel PC15. participate in mock drills/ evacuation procedures organized at the workplace PC16. undertake first aid, fire-fighting and emergency response training, if asked to do so PC17. take action based on instructions in the event of fire, emergencies or accidents PC18. follow organisation procedures for shutdown and evacuation when required
	Recognizing the hazards	PC19. identify different kinds of possible hazards (environmental, personal, ergonomic, chemical) of the industry PC20. recognise other possible security issues existing in the workplace
	Planning the safety	PC21. recognise different measures to curb the hazards

TSC/N 9003

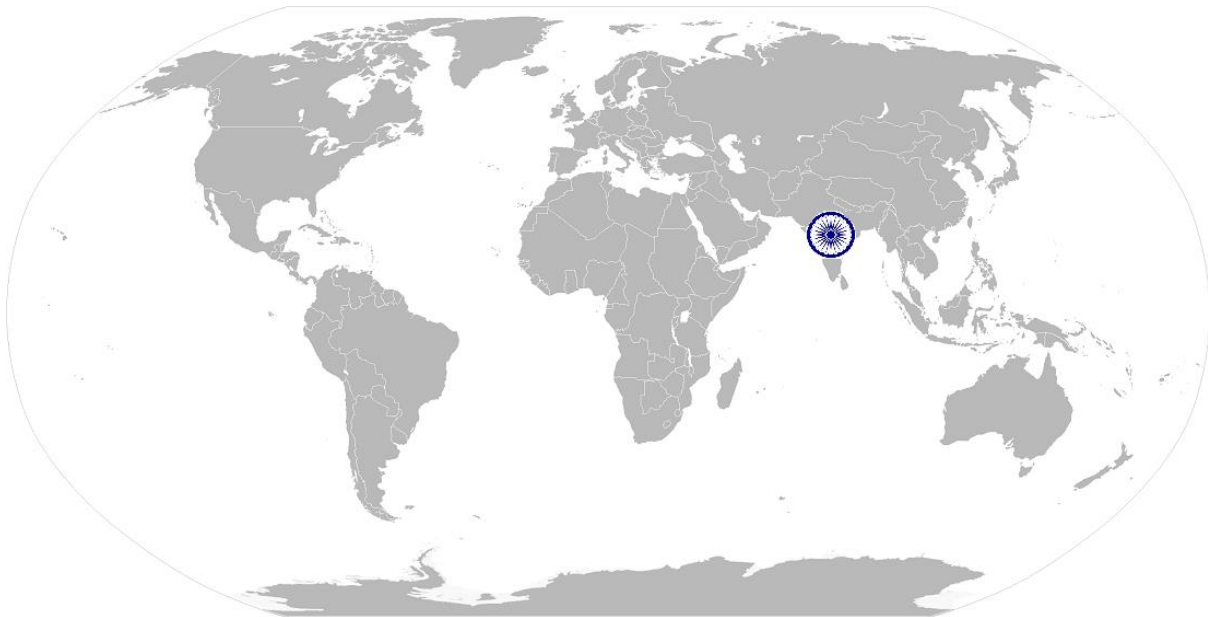
Maintain health, safety and security at work place

techniques	
Implementing the programs	PC22. communicate the safety plan to everyone PC23. attach disciplinary rules with the implementation
Knowledge and Understanding (K)	
C. 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. safe working practices to be adopted in textile mill</p> <p>KA3. quality systems and other processes practiced in the textile mill</p> <p>KA4. health and safety related practices applicable at the workplace</p> <p>KA5. potential hazards, risks and threats based on nature of operations</p> <p>KA6. organizational procedures for safe handling of equipment and machine operations</p> <p>KA7. potential risks due to own actions and methods to minimize these</p> <p>KA8. environmental management system related procedures at the workplace</p> <p>KA9. layout of the plant and details of emergency exits, escape routes, emergency equipment and assembly points</p> <p>KA10. potential accidents and emergencies and response to these scenarios</p> <p>KA11. reporting protocol and documentation required</p> <p>KA12. details of personnel trained in first aid, fire-fighting and emergency response</p> <p>KA13. actions to take in the event of a mock drills/ evacuation procedures or actual accident, emergency or fire</p>
D. Technical Knowledge	<p>You need to know and understand:</p> <p>KB1. occupational health and safety risks and methods</p> <p>KB2. personal protective equipment and method of use</p> <p>KB3. identification, handling and storage of hazardous substances</p> <p>KB4. proper disposal system for waste and by-products</p> <p>KB5. signage related to health and safety and their meaning</p> <p>KB6. importance of sound health, hygiene and good habits</p> <p>KB7. ill-effects of alcohol, tobacco and drugs</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
	SA2. read and understand the company instructions SA3. read and understand work instructions SA4. read and understand the safety guidelines
	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

TSC/N 9003

Maintain health, safety and security at work place

	SB2. make required safety plans as and when required
	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

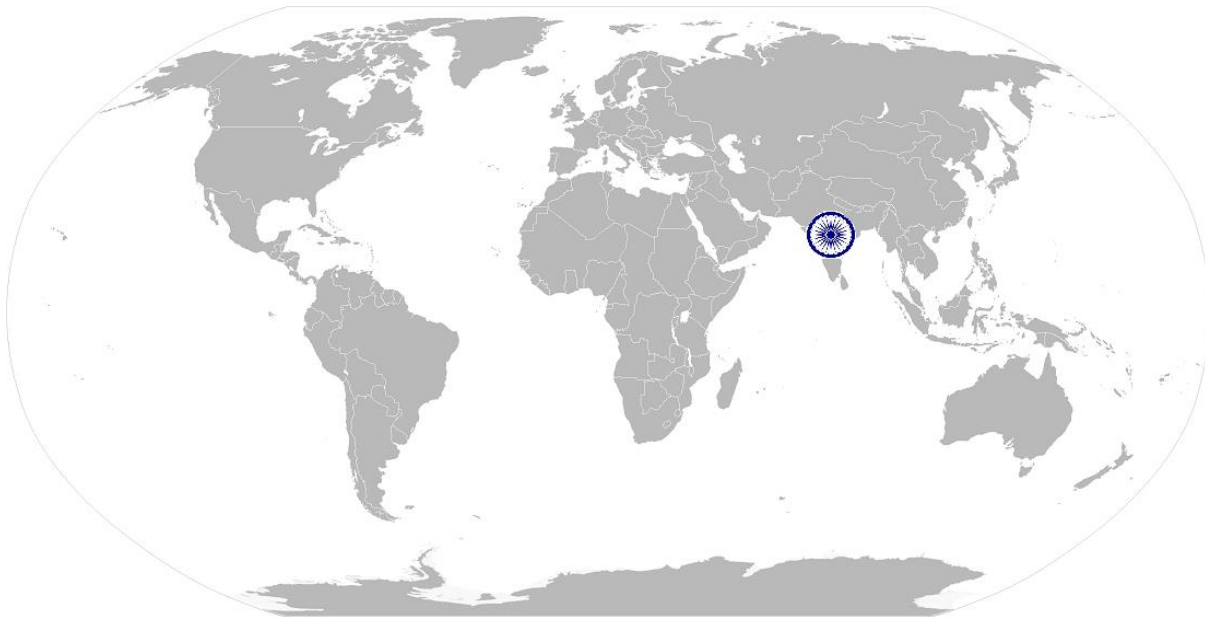


TSC/N 9003

Maintain health, safety and security at work place

NOS Version Control

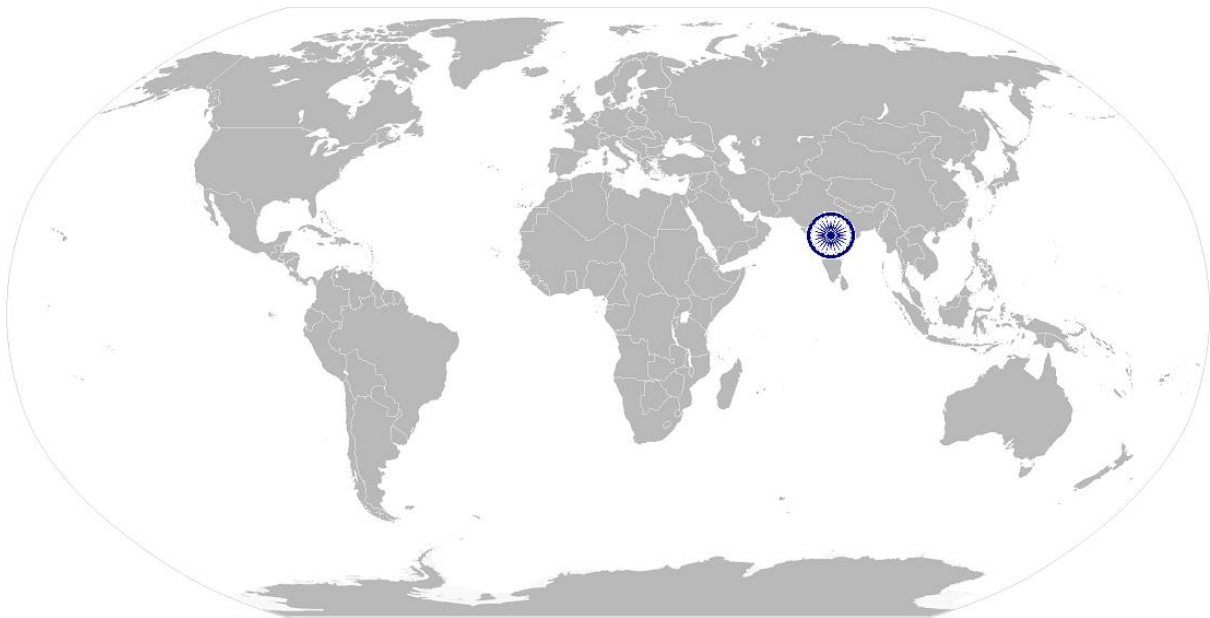
NOS Code	TSC/ N9003		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/1/15
Occupation	Weaving	Next review date	01/03/16



TSC/N 9004

Comply with industry and organizational requirements

National Occupational Standard



Overview

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

TSC/N 9004

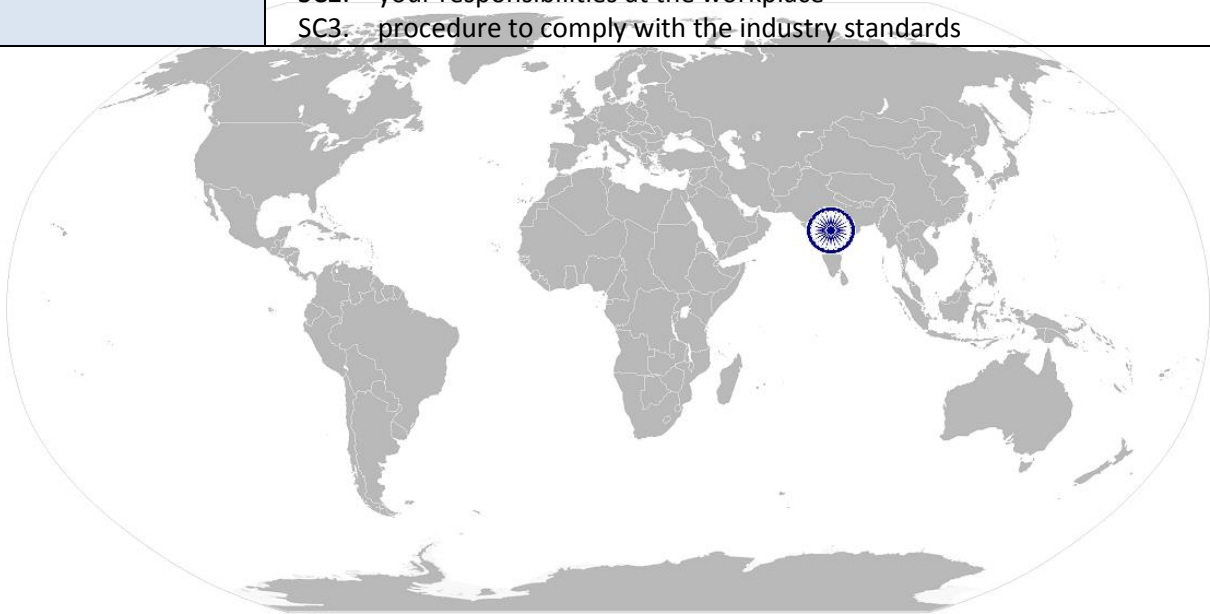
Comply with industry and organizational requirements

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)		
E. 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	
F. 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/	Writing Skills	
	You need to know and understand how to:	

TSC/N 9004

Comply with industry and organizational requirements

Generic Skills	SA1. Write clear and short sentences
	Reading Skills
	You need to know and understand how to: SA2. read the given instructions SA3. comprehend written instructions
	Oral Communication (Listening and Speaking skills)
	SA4. talk effectively with others SA5. put forward your point SA6. 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

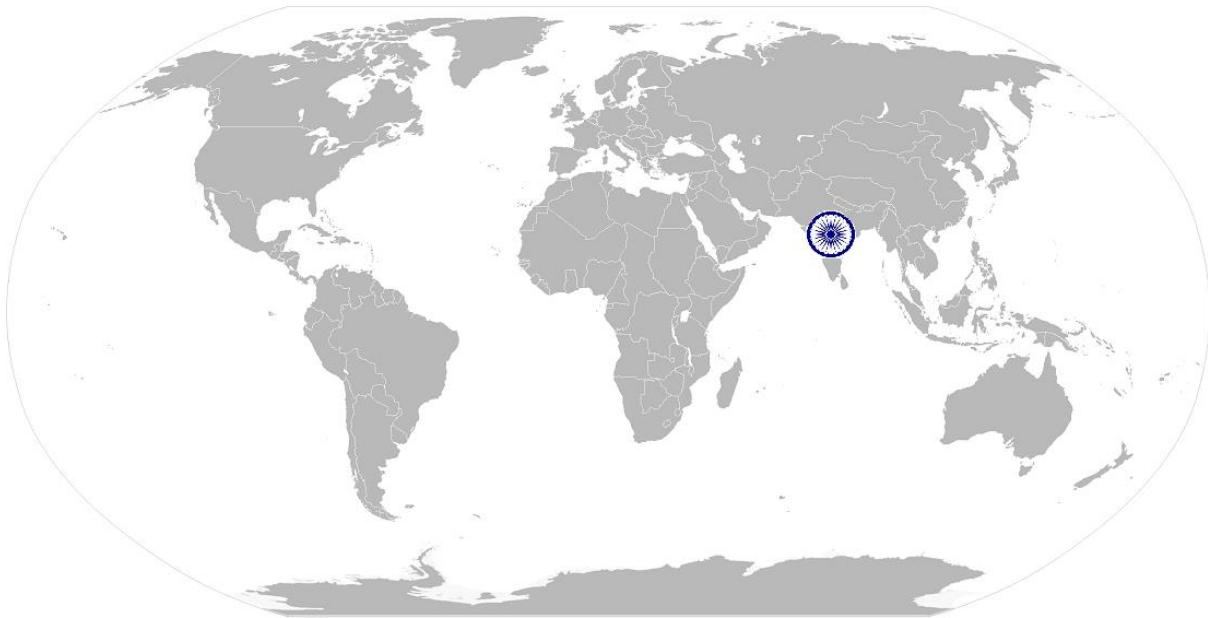


TSC/N 9004

Comply with industry and organizational requirements

NOS Version Control

NOS Code	TSC/ N9004		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Weaving	Last reviewed on	21/1/15
Occupation	Weaving	Next review date	01/03/16



Assessment Criteria

Job Role: Knotting Machine Operator
Qualification Pack: TSC/Q 2205
Sector Skill Council: Textile Sector Skill Council

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		
				Skills Practical	Theory	Viva
1.TSC/N2209 (Taking charge of shift and handing over shift to operator)	PC1. come at least 10 - 15 minutes earlier to the work spot.	160	13	11	0	2
	PC2. check for the necessary items like " gum tape", " knotting comb", " knotting brush", " knife" etc.		12	8	2	2
	PC3. meet the previous shift knotting machine operator, discuss with him/ her regarding the issues faced by them with respect to the quality or machine, knotting stand etc., or safety or any other specific instruction etc.		12	8	2	2
	PC4. check the run outs for his/ her shift.		12	6	3	3
	PC5. check whether any sort change program is there for the said run outs.		12	7	3	2
	PC6. check the availability of the beams and accordingly to inform the same to the higher authority.		15	7	5	3
	PC7. check the availability of the knotting needles required for the		15	7	5	3

Assessment Criteria

	running counts of the running beams.					
	PC8. check the condition of the knotting stand, knotting machine, knotting needles etc		12	6	3	3
	PC9. make entries in the "knotting entry note" for all the knotting carried out in his/ her shift.		12	10	2	0
	PC10. hand over the shift to the incoming knotting machine operator in a proper manner & get clearance from the incoming counterpart before leaving the work spot		15	10	5	0
	PC11. report to his/ her shift superiors as well as that of the incoming shift, in case his/ her counterpart doesn't come for work for the incoming shift. in that case, the shift has to be properly handed over to the incoming shift superior & get clearance from him/ her, before leaving the work spot		15	10	5	0
	PC12. report to his/ her 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		15	10	5	0
			160	100	40	20
	Total	Weight age %		63%	25%	12%
2. TSC/N2210 (Operate the Knotting Machine)	PC1. check whether the loom is stopped with warp, just required for (around 2-3 meters) knotting. if not, it has to be ensured		10	6	2	2
	PC2. report to the higher authority, if the loom is stopped with excess warp, due to beam complaint,		10	8	0	2

Assessment Criteria

PC3. report to the higher authority when the knotting has to be carried out in the looms with twin beams (in most of the cases), to see whether there is difference in the left our warp meters.	8	6	0	2
PC4. correct the dropper crossing (if any)	8	4	4	0
PC5. check whether any ends are left out in the run out beams, particularly near the selvages. to bring the same to the knowledge of the higher authority and act as per his/ her instructions.	10	5	5	0
PC6. check the condition of the reed on the loom in the selvage sides. for any deviation, the same has to be brought to the knowledge of the higher authority and act as per his/ her advice.	10	4	3	3
PC7. check whether any bead formation is there in the droppers. if so ,the same has to be removed	10	5	5	0
PC8. check the condition of the run out beams for the beam fault like“ soft size”, “ size patches” , “ shade variation” etc. to check the suitability of the said beams for knotting. the same has to be brought to the knowledge of the higher authority and act as per his/ her advice.	8	3	3	2
PC9. cut the old warp as to be cut in the run out looms, leaving 2-3 meters of warp length required for knotting.	10	4	3	3
PC10. cover the left warp with card board or polythene sheet or with hdpe sack if the qty left out due to beam complaint is more as per the advice of the higher authority, in the run out beams. the following details have to be written in a “ beam ticket “ and the same	8	6	0	2

Assessment Criteria

	has to be pasted in the said beams, peel out the earlier beam tickets pasted in the said beams:-					
	PC11. remove the cut empty beams from the loom shed and have to be brought to the place, where they have to be stored.	8	3	3	2	
	PC12. clean thoroughly the loom, an all the places, as advised by the higher authority.	10	8	0	2	
	PC13. ensure proper lubrication as per the advice of the higher authority.	8	6	2	0	
	PC14. check whether the fresh beams are properly covered for any variation, the same has to be brought to the notice of the higher authority.	8	6	2	0	
	PC15. check the loom card to ascertain the fresh beams to be loaded, by checking the following.:- warp count total ends set no. beam nos (for the opposite sides) beam meters (there should not be any difference in meters)	8	6	2	0	
	PC16. bring the fresh beams from the place they are stored to the loom, where knotting has to be carried out.	8	6	2	0	
	PC17. check the condition of the fresh beams after removing the beam wrappers. for transit damages and accordingly the same has to be brought to the notice of the higher authority. lie that, the fresh beam has to be checked for beam complaint like “ sunken ends” “ soft size” , “ size patches “ etc., further	8	5	3	0	

Assessment Criteria

	action can be carried out as per the advice of the higher authority only.					
	PC18. mount the fresh beams have on the loom carefully without imparting damage to the raw material, beams, machine , or for any person including himself or herself.	8	5	3	0	
	PC19. ensure beam alignment, in case of “twin beams” ensure “no cross “in the old warp. a group of not more than 100 ends can be taken & brushed properly.	8	4	2	2	
	PC20. check for the sizing tapes in the fresh beams	8	4	2	2	
	PC21. cut the fresh warp in the second tape	8	4	2	2	
	PC22. bring the fresh warp to the knotting stand without any cross using knotting comb.	8	4	2	2	
	PC23. correct the cross in the old warp also using knotting comb, before bringing the same to the knotting stand.	8	4	2	2	
	PC24. dress the warp sheet carefully without giving room for “ cross “ or“ ends cit” etc.	8	4	2	2	
	PC25. weigh the knotting waste & the same has to be recorded in the knotting entry note”	8	4	2	2	
	PC26. tie the “thrums “(sufficient enough till the run out) on the loom, neatly.	10	6	2	2	
	PC27. collect the knotting waste & store in the place earmarked.	10	6	2	2	
	PC28. use the needle that is earmarked for the beams mounted.	8	4	4	0	

Assessment Criteria

PC29. check the machine & the needle by doing few knots. for any deviation to bring the same to the notice of the higher authority to do the knotting of the beams in the speed as advised by the higher authority.	8	3	5	0
PC30. check for “double end”, “knot slippage” etc. through close monitoring of the performance of the knotting.	8	3	5	0
PC31. remove the knotting machine from the stand	8	2	6	0
PC32. remove the knotting stand from the knotted loom collect the waste and to get the same stored in the place, earmarked.	8	4	4	0
PC33. apply the beam locks (if any) & to see that the knotted beams are in tight condition so as to run the machine without any problem, till the knots reach the “ droppers zone”	10	3	7	0
PC34. bring the knots out of the “ droppers” “ heald wires” “ reed “ etc., without entertaining breakage of much warp ends	8	3	5	0
PC35. draw the broken warp ends	8	1	6	1
PC36. ensure proper functioning of the warp stop motion	8	1	6	1
PC37. apply “ color cone” & to ensure no “ double end” is left out on the fabric	8	4	4	0
PC38. see that the extra ends are routed through “ extra ends clips” & wound properly in the “ extra ends bobbin”	8	5	2	1
PC39. see that the roll is doffed properly.	8	7	1	0
PC40. see that the doffed roll is removed from the loom and brought to the place, earmarked.	8	6	2	0
	340	182	117	41

Assessment Criteria

	Total	Weight age %		54%	34%	12%
3. TSC/N 9001 (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
	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
Total		Weight age %		30%	42%	28%
4. TSC/N 9002 (Working in a team)	PC1. be accountable to the own role in whole process	50	5	3	1	1

Assessment Criteria

	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	16
	Total	Weight age %		34%	34%	32%
5. TSC/N 9003 (Maintain 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 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

Assessment Criteria

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 manufacturer's and organizational requirements	4	1	2	1
PC9. Safely handle and move waste and debris	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 threats	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 the workplace	4	2	2	0
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

Assessment Criteria

	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
			100	43	34	23
	Total	Weight age %		43%	34%	23%
6. TSC/N 9004 (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 miscommunication		4	1	2	1
	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	Weight age %		36%	38%	26%
	Total		750	373	247	130
Grand Total			750			