

## 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 – Speed Frame Operator-Tenter and Doffer

**SECTOR: TEXTILE**

**SUB-SECTOR: SPINNING**

**OCCUPATION: SPINNING PREPARATORY**

**REFERENCE ID: TSC/ Q 0106**

**ALIGNED TO: NCO-2004 / 8261.50**

**Brief Job Description:** A speed frame operator is responsible for carrying out tenting and doffing activities in a speed frame machine. A speed frame operator should be able to piece the sliver, piece the roving and carry out routine cleaning and preventive maintenance activities, doff the roving bobbins and ensure that quality roving bobbin is produced in speed frame machine.

This job requires the individual to have thorough knowledge of process flow and material flow in a spinning mill for yarn production and should know about the important functions and operations of a speed frame machine.

**Personal Attributes:** A speed frame operator should have good eyesight, hand-eye-leg coordination, motor skills and vision. He/she should also have good interpersonal skills.

Job Details	<b>Qualifications Pack Code</b>	<b>TSC/Q 0106</b>		
	<b>Job Role</b>	<b>Speed Frame Operator – Tenter &amp; Doffer</b>		
	<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
	<b>Sector</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
	<b>Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
	<b>Occupation</b>	<b>Spinning</b>	<b>Next review date</b>	<b>01/03/16</b>
<b>Job Role</b>	<b>Speed Frame Operator - Tenter &amp; Doffer</b>			
<b>Role Description</b>	To carry out tenting and doffing activities in a speed frame machine ensuring minimum machine stoppage and achieving maximum production, along with minimum time for carrying out doffing activities and ensure proper functioning of speed frame machine.			
<b>NSQF level</b>	4			
<b>Minimum Educational Qualifications</b>	5 <sup>th</sup> standard, preferably			
<b>Maximum Educational Qualifications</b>	N/A			
<b>Training</b> (Suggested but not mandatory)	Not Applicable			
<b>Experience</b>	Preferably 1-2 years of work experience in a textile mill			
<b>National Occupational Standards (NOS)</b>	<p><b>Compulsory:</b></p> <ol style="list-style-type: none"> <li><a href="#">TSC/ N 0116 Taking charge of shift and handing over shift to operator</a></li> <li><a href="#">TSC/N 0117 Piecing the broken sliver</a></li> <li><a href="#">TSC/N 0118 Piecing the broken roving</a></li> <li><a href="#">TSC/N 0119 Preparing for doffing</a></li> <li><a href="#">TSC/N 0120 Carryout doffing activity</a></li> <li><a href="#">TSC/N 0121 Tenting responsibilities</a></li> <li><a href="#">TSC/N 0122 Carry out additional tenting responsibilities effectively</a></li> <li><a href="#">TSC/ N9001 Maintain work area,tools and machines</a></li> <li><a href="#">TSC/ N9002 Working in a team</a></li> <li><a href="#">TSC/ N9003 Maintain health, safety and security at workplace</a></li> <li><a href="#">TSC/ N9004 Comply with industry and organizational requirement</a></li> </ol> <p><b>Optional:</b> Not Applicable</p>			
<b>Performance Criteria</b>	As described in the relevant OS units			

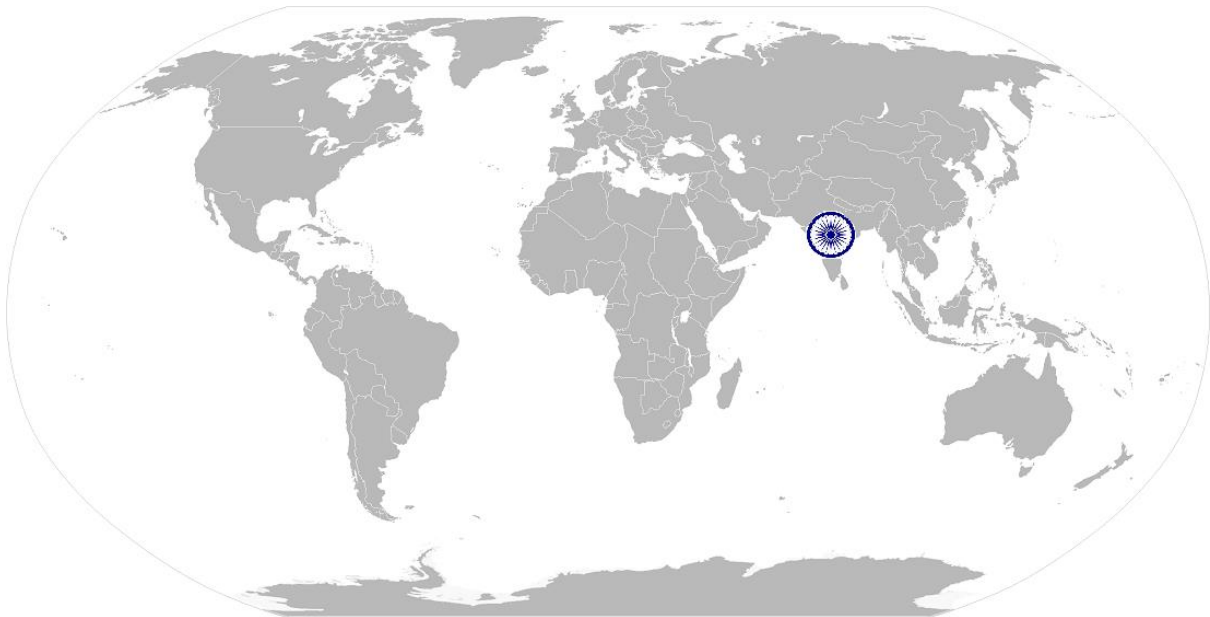
**Table 1: Glossary of Key Terms**

Definitions	Keywords /Terms	Description
	Sector	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.
<b>Keywords /Terms</b>	<b>Description</b>
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	Textile 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/ N0116**

**Taking charge of shift and handing over shift to operator**

National Occupational Standard	<b>Unit Code</b>	<b>TSC/ N0116</b>
	<b>Unit Title (Task)</b>	<b>Taking charge of shift and handing over shift to operator</b>
	<b>Description</b>	This unit is about taking charge of shift from previous shift operator and relieving the responsibilities to the next shift operator
	<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ Taking charge of shift</li> <li>▪ Handing over shift</li> </ul>
	<b>Elements</b>	<b>Performance Criteria</b>
	<b>Taking charge of shift</b>	<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. bring the necessary operational tools to the department</p> <p>PC3. meet the previous shift operator and discuss with him/ her regarding the issues faced by them with respect to the quality or production or spare or safety or any other specific instruction etc.</p> <p>PC4. understand the count produced, colour coding, followed in the speed frames for his allocated number of spindles or machines</p> <p>PC5. ensure the technical details are mentioned in the display board in the speed frame machine</p> <p>PC6. should check for the availability of the spare roving bobbins</p> <p>PC7. should check the availability of bobbin trolley with technical details mentioned regarding the count being produced</p> <p>PC8. check the condition of running travellers</p> <p>PC9. check the roving passage and yarn formation is proper</p> <p>PC10. should check for the run outs, availability of the roving bobbins</p> <p>PC11. ensure all the spindles are running properly, if not should be enquired for the reason for idle spindle and report to the superiors regarding the same</p> <p>PC12. should check the condition of different running boobbins</p> <p>PC13. ensure proper functioning of speed frame machine parts and machine</p> <p>PC14. ensure all allocated spindles are running with uniform length of roving is wound on bobbin, variations if any should be discussed with operator and reported to superiors</p> <p>PC15. check the condition of running spindles, damages if any should be reported</p> <p>PC16. check the cleanliness of the machines &amp; other work areas</p> <p>PC17. check whether any spare/raw material/ tool / yarn / any other material are thrown under the machines or in the other work areas.</p> <p>PC18. question the previous shift operator for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as well that of the previous shift as well.</p> <p>PC19. ensure no roller lapping in speed frame</p> <p>PC20. remove the roller lapping manually if any without damaging the cots</p> <p>PC21. ensure that only the correct size of spacer is used for replacement</p> <p>PC22. ensure the wastes collection boxes are empty while taking charge of shift</p> <p>PC23. ensure the work spot is clean</p>

**TSC/ N0116**

**Taking charge of shift and handing over shift to operator**

<p><b>Handing over shift</b></p>	<p>PC24. should hand over the shift to the incoming speed frame tenter in a proper manner</p> <p>PC25. ensure in providing the details regarding hank / count produced, colour coding followed in the speed frames for his allocated number of spindles or machines</p> <p>PC26. to provide all relevant information regarding the count produced, idle spindles, damaged machine parts if any</p> <p>PC27. should get clearance from the incoming counterpart before leaving the work spot</p> <p>PC28. should report to his/ her shift superiors as well as that of the incoming shift operator in case his/ her counterpart doesn't report for the incoming shift</p> <p>PC29. ensure the shift has to be properly handed over to the incoming shift operator</p> <p>PC30. should 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> <p>PC31. should collect the wastes from waste collection bags, weigh them and transport to storage area</p> <p>PC32. ensure the work spot is clean</p>
<p><b>Knowledge and Understanding (K)</b></p>	
<p><b>A. Organizational Context</b>              (Knowledge of the company/ organization and its processes)</p>	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning mill</p> <p>KA2. safe working practices to be adopted in spinning mill</p> <p>KA3. quality systems and other processes practiced in the spinning mill</p> <p>KA4. reporting to the supervisor or higher authority in case of emergency</p> <p>KA5. color coding adopted for different counts in the spinning mill</p>
<p><b>B. Technical Knowledge</b></p>	<p>KB1. understanding the importance of</p> <ul style="list-style-type: none"> <li>• types of fibres</li> <li>• roving hank</li> <li>• importance of roving quality</li> <li>• types of roving defects</li> </ul> <p>KB2. process flow in a spinning mill</p> <p>KB3. material flow in a spinning mill</p> <p>KB4. importance of mixing, count change</p> <p>KB5. functions of different parts of speed frame machine</p> <p>KB6. importance of colour coding followed for different counts in spinning mill</p> <p>KB7. knowledge of waste collection system &amp; equipments used</p> <p>KB8. importance of material handling and types of material handling equipments used</p> <p>KB9. functions and methodology for operating different material handling equipments</p> <p>KB10. guidelines for operating the speed frame machine</p> <p>KB11. guidelines for taking charge of shift from previous shift operator</p> <p>KB12. guidelines for handing over the shift to the next shift operator</p> <p>KB13. importance of cleanliness at workplace</p> <p>KB14. safety procedures to be followed in a speed frame machine</p>

**TSC/ N0116**

**Taking charge of shift and handing over shift to operator**

Skills (S)	
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>
	You need to know and understand how to: SA1. write clear and short sentences
	<b>Reading Skills</b>
	SA2. read and comprehend written instructions
	<b>Oral Communication (Listening and Speaking skills)</b>
	SA3. communicate with supervisor appropriately SA4. talk to others to convey information effectively
<b>B. Professional Skills</b>	<b>Problem Solving</b>
	You need to know and understand how to: SB1. apply problem-solving approaches in different situations SB2. refer anomalies to the supervisor SB3. seek clarification on problems from others
	<b>Attention to Detail</b>
	SB1. apply good attention to detail SB2. check your work is complete and free from errors
<b>C. Technical Skills</b>	You need to know and understand how to: SC1. patrol around the speed frame machine and identify sliver breakage, sliver exhaust, roving breakage or bobbin exhaust SC2. operatedifferent material handling tools and equipments SC3. patrol around the speed frame departments ad identifying worn out or damaged machine parts SC4. check the quality of sliver, roving bobbins, proper functioning of machine parts in speed frame machine SC5. maintain neatness at work

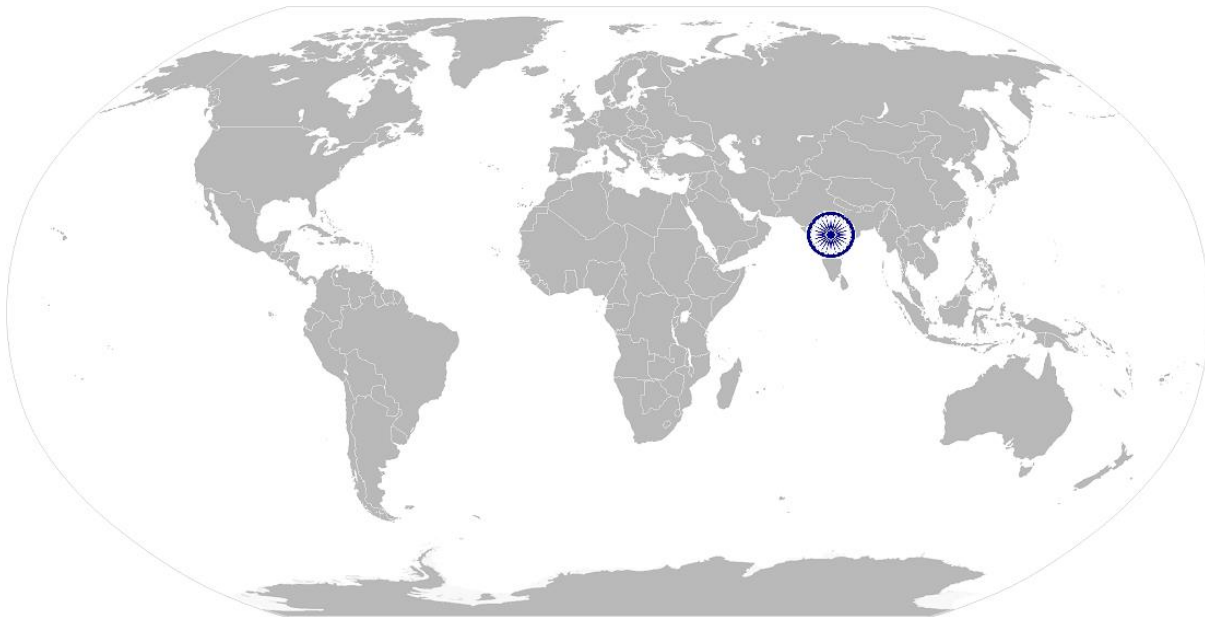


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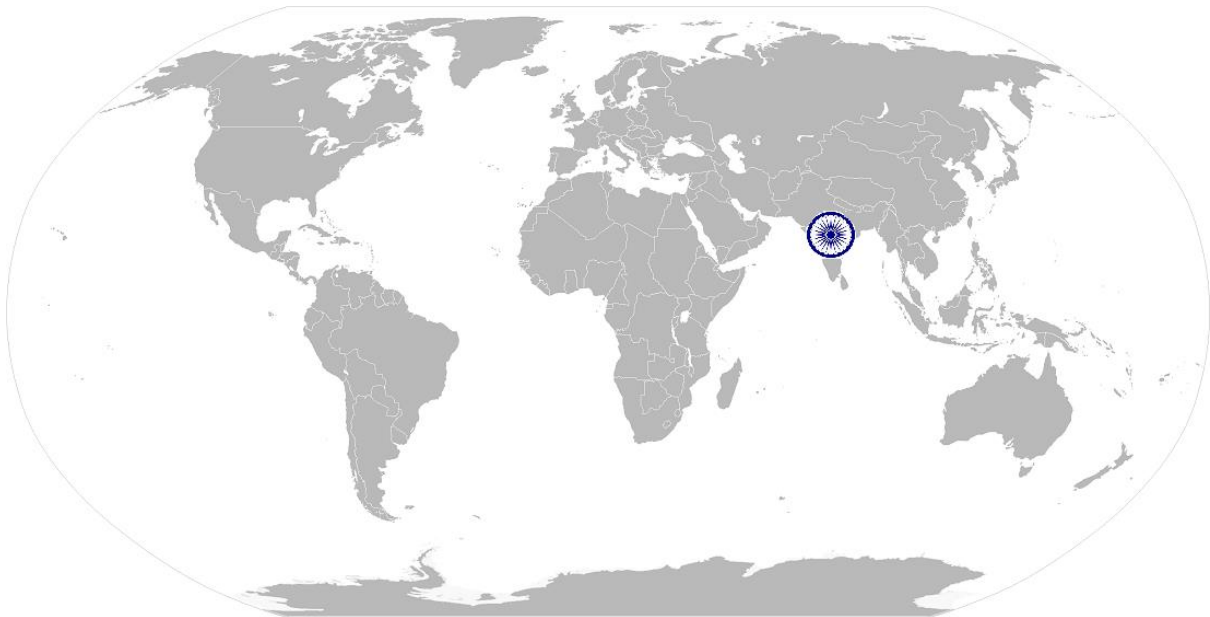
**Taking charge of shift and handing over shift to operator**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/ N0116</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



# National Occupational Standard



## Overview

This unit is about carrying out the piecing activities in a speed frame machine in the event of a sliver breakage.

**TSC/Q 0117**

**Piecing the broken sliver**

<b>Unit Code</b>	<b>TSC/Q 0117</b>
<b>Unit Title (Task)</b>	<b>Piecing the broken sliver</b>
<b>Description</b>	This unit is about following the procedure for carrying out piecing activities in the event of a sliver breakage
<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ attending the machine on sliver breakage</li> <li>▪ piecing the broken sliver</li> <li>▪ feeding / replacing sliver can</li> <li>▪ material handling of the sliver</li> <li>▪ checking the quality of sliver piecing and starting the machine</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
Attending the machine on sliver breakage	To be competent, you must be able to: PC1. Identify whether the machine stoppage is due to a sliver breakage or roving breakage PC2. move in the creel and identify which sliver is broken PC3. identify the reasons for sliver breakage by viewing the breakage spot i.e., whether sliver is broken at creel or sliver is exhausted in the sliver can PC4. ensure minimum time is taken for attending the sliver breakage
Piecing the broken sliver	PC5. ensure that the sliver passes through the creeling section without affecting the quality of sliver PC6. ensure proper length of sliver is available for piecing PC7. piece the broken sliver together in the event of sliver breakage at creel section PC8. piece the sliver between cans in the event of sliver exhaust in sliver can and replacement with a full sliver can PC9. keep the sliver waste in the waste collection pocket provided to each tenter and then put in the waste in waste collection box PC10. ensure standard piecing procedure is adopted and quality of piecing is as per standards PC11. ensure minimum time is taken for piecing the sliver
Feeding / Replacing sliver can	PC12. inspect the creeling section and identify the empty can and sliver cans which are about to be exhausted PC13. remove the empty can and replace with the full can PC14. Dispose empty can to storage location/draw frame department PC15. bring the full cans from draw frame department or from the drawn sliver can storage location PC16. ensure colour coding of sliver can fed in the creel is correct
Material handling of the sliver	PC17. properly handle the sliver PC18. ensure sliver surface doesn't get damaged PC19. use appropriate trolley to move/transport the sliver cans
Checking the quality of piecing and starting the machine	PC20. verify the quality of piecing done in the sliver PC21. ensure sliver tension in the creeling section is appropriate PC22. ensure proper functioning of the machine

**TSC/Q 0117**

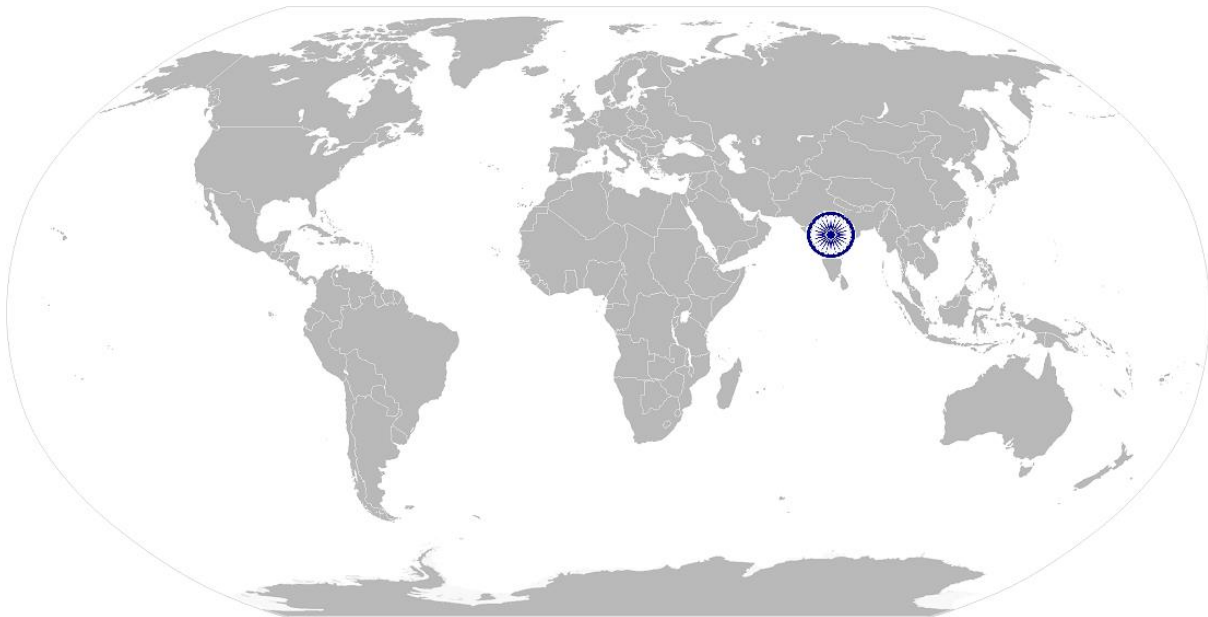
**Piecing the broken sliver**

Knowledge and Understanding (K)	
<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning mill</p> <p>KA2. safe working practices to be adopted in spinning mill</p> <p>KA3. quality systems and other processes practiced in the spinning mill</p> <p>KA4. reporting to the supervisor or higher authority in case of emergency</p> <p>KA5. color coding adopted for different counts in the spinning mill</p>
<b>B. Technical Knowledge</b>	<p>KB1. understanding the importance of</p> <ul style="list-style-type: none"> <li>• types of fibres</li> <li>• types of yarn</li> <li>• yarn count</li> <li>• types of sliver</li> <li>• sliver hank</li> <li>• importance of sliver quality</li> <li>• types of sliver defects</li> <li>• reasons for sliver breakage</li> </ul> <p>KB2. process flow in a spinning mill</p> <p>KB3. material flow in a spinning mill</p> <p>KB4. functions of different parts of a speed frame machine</p> <p>KB5. colour coding for sliver cans followed for different counts in spinning mill</p> <p>KB6. tools and equipments used</p> <p>KB7. knowledge of waste collection system &amp; equipments</p> <p>KB8. types of material handling equipments used</p> <p>KB9. functions and methodology for operating different material handling equipments</p> <p>KB10. understanding the functions of different signal lamps</p> <p>KB11. guidelines for operating the speed frame machine</p> <p>KB12. safety procedures to be followed in a speed frame machine</p>
Skills (S)	
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>
	You need to know and understand how to:
	SA1. write clear and short sentences
	<b>Reading Skills</b>
	SA2. read and comprehend written instructions
	<b>Oral Communication (Listening and Speaking skills)</b>
	SA3. communicate with supervisor appropriately
	SA4. talk to others to convey information effectively
<b>B. Professional Skills</b>	<b>Problem Solving</b>
	You need to know and understand how to:
	SB1. apply problem-solving approaches in different situations
	SB2. refer anomalies to the supervisor
	SB3. seek clarification on problems from others
	<b>Attention to Detail</b>

**TSC/Q 0117**

**Piecing the broken sliver**

	SB4. apply good attention to detail SB5. check your work is complete and free from errors
<b>C. Technical Skills</b>	You need to know and understand how to: SC1. follow standard operating procedures for creeling the sliver SC2. move in the sliver shed to identify the broken sliver SC3. transport the filled and empty can SC4. procedure for unraveling the sliver from the sliver can SC5. adopt standard piecing technique for piecing the broken sliver SC6. analyze the sliver tension with hand SC7. check the quality of piecing SC8. identify the reasons for sliver breakage SC9. maintain neatness at work

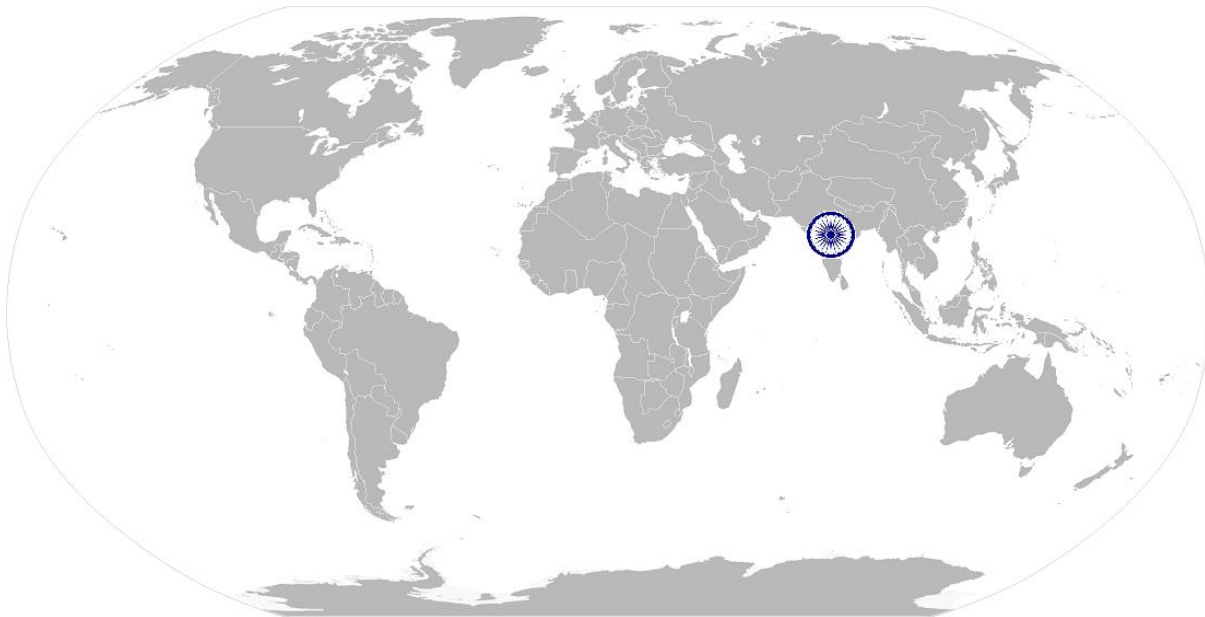


**TSC/Q 0117**

**Piecing the broken sliver**

**NOS Version Control**

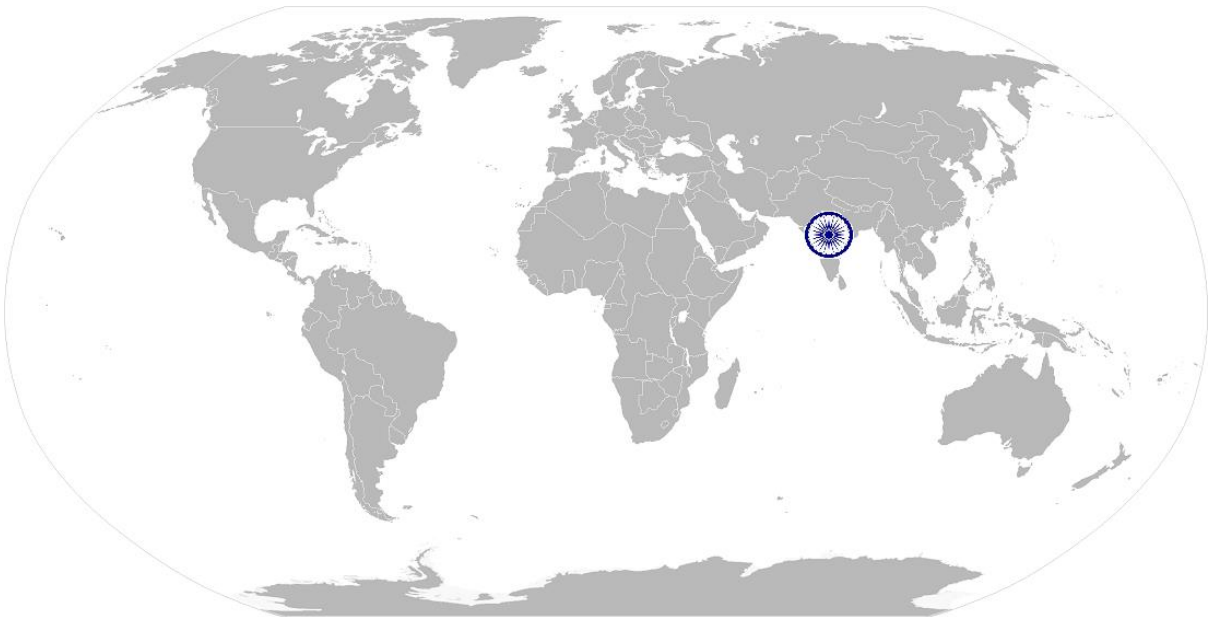
<b>NOS Code</b>	<b>TSC/Q 0117</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
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<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



**TSC/N 0118**

**Piecing the broken roving**

# National Occupational Standard



## Overview

This unit is about carrying out the piecing activities in a speed frame machine in the event of a roving breakage.

**TSC/N 0118**

**Piecing the broken roving**

National Occupational Standard	<b>Unit Code</b>	<b>TSC/N 0118</b>
	<b>Unit Title (Task)</b>	<b>Piecing the broken roving</b>
	<b>Description</b>	This unit is about carrying out procedure for piecing activities in the event of a roving breakage
	<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ attending the machine and identifying roving breakage</li> <li>▪ piecing the broken roving</li> <li>▪ material handling of roving bobbin</li> <li>▪ check the quality of pieced roving, preparing and starting the machine</li> </ul>
	<b>Performance Criteria (PC) w.r.t. the Scope</b>	
	<b>Elements</b>	<b>Performance Criteria</b>
	Attending the machine and identifying roving breakage	To be competent, you must be able to: PC1. identify the reason for machine stoppage by seeing the signal lamps. PC2. patrol and identify in which spindle the roving is broken PC3. check and identify the reasons for roving breakage by viewing at the breakage spot i.e., whether the roving is broken at spindle or flyer or drafting zone PC4. ensure minimum time is taken for attending and identifying the roving breakage
	Piecing the broken roving	PC5. carryout Inching and trim drafted rove for piecing PC6. lift the bobbin slightly from spindle to unwind the broken roving PC7. unwind or remove the broken roving from the bobbin PC8. unwind extra length of roving from the bobbin PC9. fix the bobbin in a proper manner in the spindle and pass the roving through the false twister making it ready for piecing PC10. Use blow horn to pass the rove end in flyer PC11. piece the roving between false twister and drafting zone by standard piecing techniques PC12. ensure minimum time is taken for piecing the rove
	Material handling of roving bobbin	PC13. ensure in proper material handling of roving and roving bobbin PC14. ensure surface of roving doesn't get damaged PC15. ensure to avoid usage of damaged or defective bobbins
	Check the quality of pieced roving, preparing and starting the machine	PC16. ensure the quality of piecing is as per standard PC17. ensure the tension of the pieced roving is proper PC18. ensure the bobbin is perfectly fitted in the spindle PC19. verify proper material passage from drafting zone till the roving wound on bobbin PC20. Run machine and check PC21. remove the sliver waste and roving waste and deposit in the respective waste collection bags PC22. ensure proper functioning of the machine PC23. ensure and maintain Colour code
<b>Knowledge and Understanding (K)</b>		
<b>A. Organizational Context</b>	You need to know and understand: KA1. standard operating procedures (SOP) and regulations in a spinning mill	



**TSC/N 0118**

**Piecing the broken roving**

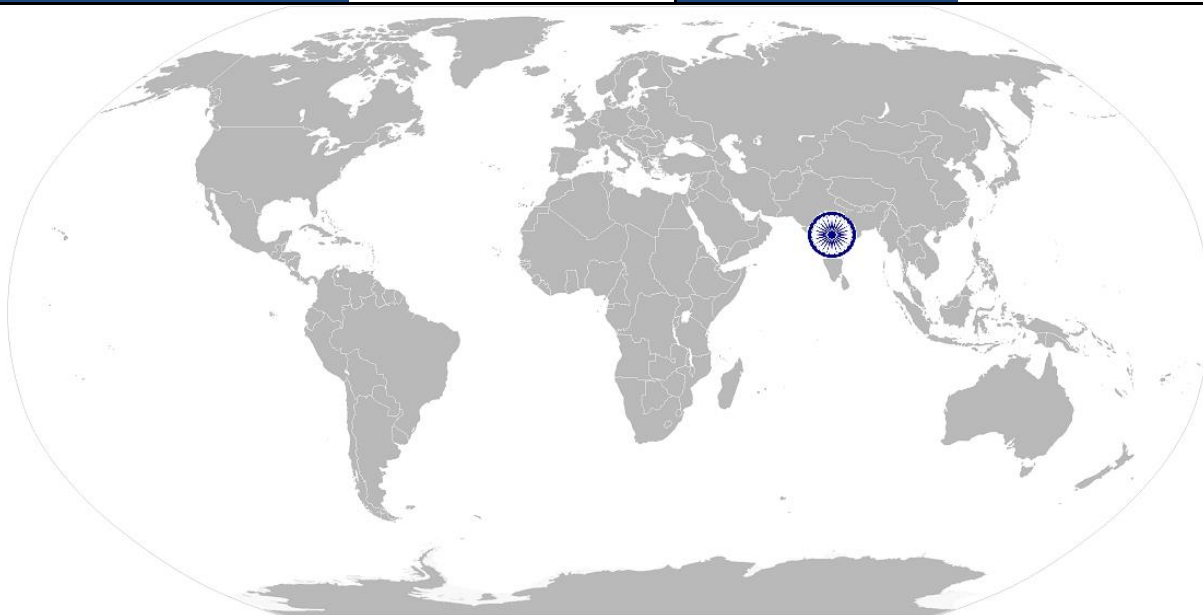
(Knowledge of the company/ organization and its processes)	KA2. safe working practices to be adopted in spinning mill KA3. quality systems and other processes practiced in the spinning mill KA4. reporting to the supervisor or higher authority in case of emergency KA5. color coding adopted for different counts in the spinning mill
<b>B. Technical Knowledge</b>	You need to know and understand: KB1. understanding the importance of different types of fibres, sliver, roving, yarn, hank and count. KB2. understand the types of roving defects and reason for roving breakage KB3. process and material flow in a spinning mill KB4. functions of different parts of a speed frame machine KB5. importance of piecing KB6. tools and equipments used for piecing KB7. knowledge of waste collection system & material handling equipments used KB8. functions of different signal lamps and control buttons KB9. guidelines for operating the speed frame machine KB10. safety procedures to be followed in a speed frame machine
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<p><b>Writing Skills</b></p> You need to know and understand how to: <ul style="list-style-type: none"> <li>SA1. write clear and short sentences</li> </ul> <p><b>Reading Skills</b></p> <ul style="list-style-type: none"> <li>SA2. comprehend written instructions</li> </ul> <p><b>Oral Communication (Listening and Speaking skills)</b></p> <ul style="list-style-type: none"> <li>SA3. communicate with supervisor appropriately</li> <li>SA4. talk to others to convey information effectively</li> </ul>
<b>B. Professional Skills</b>	<p><b>Problem Solving</b></p> You need to know and understand how to: <ul style="list-style-type: none"> <li>SB1. apply problem-solving approaches in different situations</li> <li>SB2. refer anomalies to the supervisor</li> <li>SB3. seek clarification on problems from others</li> </ul> <p><b>Attention to Detail</b></p> You need to know and understand how to: <ul style="list-style-type: none"> <li>SB4. apply good attention to detail</li> <li>SB5. check your work is complete and free from errors</li> </ul>
<b>C. Technical Skills</b>	You need to know and understand : <ul style="list-style-type: none"> <li>SC1. procedure for finding the broken roving</li> <li>SC2. procedure to patrol across the speed frame machine</li> <li>SC3. procedure to unwind and remove the broken roving</li> <li>SC4. procedure to unwind extra length of roving from the bobbin</li> <li>SC5. procedure for mounting the bobbin in the spindle</li> <li>SC6. standard piecing technique for piecing the broken rove</li> <li>SC7. procedure to check the quality of piecing</li> <li>SC8. maintain neatness at work</li> </ul>

**TSC/N 0118**

**Piecing the broken roving**

**NOS Version Control**

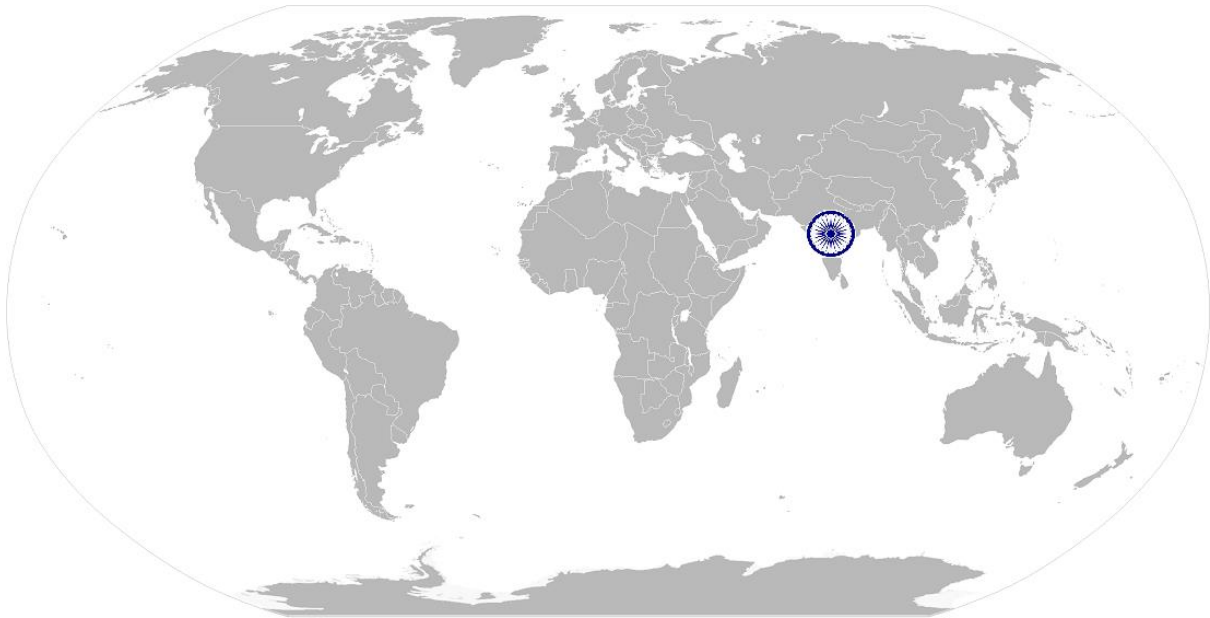
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<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



**TSC/N 0119**

**Preparing for doffing**

# National Occupational Standard



## Overview

This unit is about preparing the speed frame machine for carrying out doffing activities.

TSC/N 0119

Preparing for doffing

National Occupational Standard

<b>Unit Code</b>	<b>TSC/N 0119</b>
<b>Unit Title (Task)</b>	<b>Preparing for doffing</b>
<b>Description</b>	This unit is about doing the preparation for carrying out doffing activity
<b>Scope</b>	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> <li>▪ identify the machine for carrying out doffing activity</li> <li>▪ collect the empty bobbins from storage area</li> <li>▪ load the empty bobbins in the bobbin trolley</li> <li>▪ support in preparing the creel zone in case of count change</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
Identify the machine for carrying out doffing	<p>To be competent you must be able to:</p> <p>PC1. follow the plan as instructed by superior for performing doffing activities at various machines in speed frame department</p> <p>PC2. identify which machine in speed frame departments is ready for doffing</p>
Collect the empty bobbins from storage area	<p>PC3. identify the empty bobbin required for next doff and segregate it size wise, count wise and type wise</p> <p>PC4. ensure the bobbins are clean, clean the empty bobbins if needed</p> <p>PC5. ensure the empty bobbins in good condition</p> <p>PC6. remove the damaged bobbins and store in a separate place</p> <p>PC7. ensure correct sized and colour coded empty bobbin is to be loaded in the bobbin trolley</p> <p>PC8. ensure proper material handling of empty bobbin</p>
Load the empty bobbins in the bobbin trolley	<p>PC9. load the empty bobbins in the bobbin trolley in an organised manner</p> <p>PC10. load the required number of empty bobbins as per requirement in different bobbin trolleys</p> <p>PC11. move and arrange the bobbin trolleys in an organised manner near the speed frame machine</p> <p>PC12. ensure minimum time is taken out for carrying the activities</p>
support in preparing the creel zone in case of count change	<p>PC13. support the tenter in bringing the new sliver cans from the draw frame department to the speed frame creeling zone</p> <p>PC14. to ensure correct sliver can is taken from the draw frame department</p> <p>PC15. arrange the sliver cans in an organised manner near the creel zone</p> <p>PC16. distribute the existing slivers without waste to sliver cans at the time of starting new count or run out or any other time as required</p> <p>PC17. ensure proper material handling of sliver and sliver can</p>
<b>knowledge and understanding (k)</b>	
<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning mill</p> <p>KA2. safe working practices to be adopted in spinning mill</p> <p>KA3. quality systems and other processes practiced in the spinning mill</p> <p>KA4. reporting to the supervisor or higher authority in case of emergency</p> <p>KA5. color coding adopted for different counts in the spinning mill</p>

**TSC/N 0119**

**Preparing for doffing**

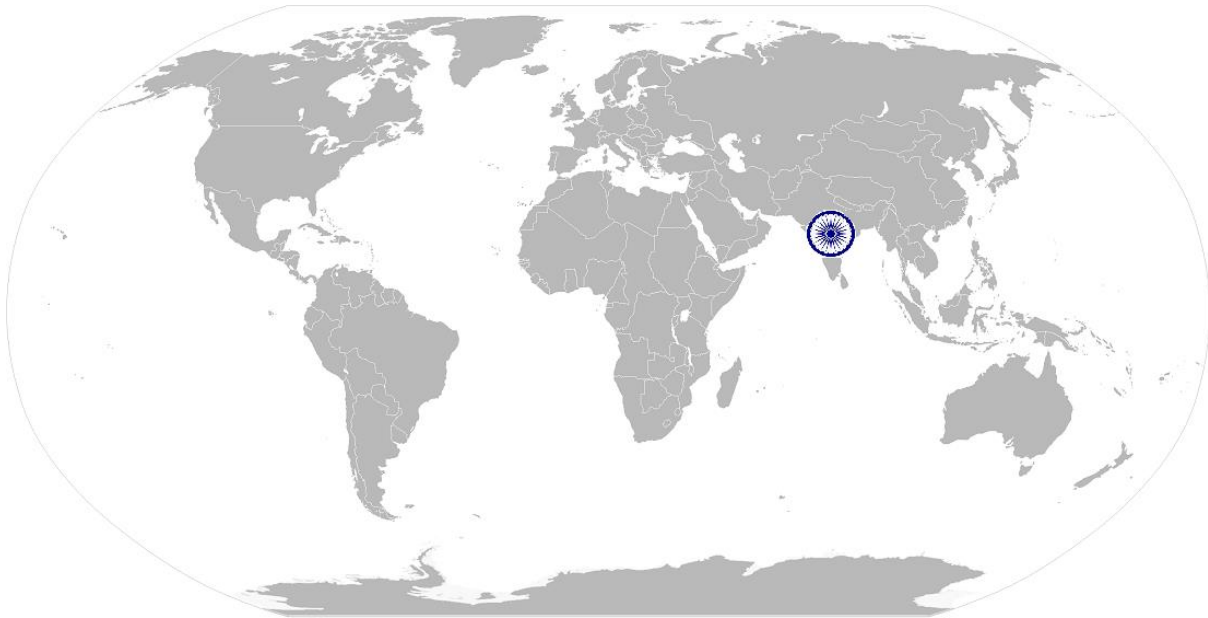
<p><b>B. Technical Knowledge</b></p>	<p>KA1. process and material flow in a spinning mill          KA2. functions of different parts of a speed frame machine          KA3. understanding the importance of fibres, types of yarn, yarn count, types of sliver, sliver hank, importance of sliver and roving quality          KA4. knowledge of different type of bobbin          KA5. importance of colour coding          KA6. importance of material handling          KA7. types of material handling equipments used          KA8. functions and methodology for operating different material handling equipments          KA9. importance of cleanliness at work place          KA10. safety procedures to be followed in a speed frame machine</p>
<p><b>skills (s)</b></p>	
<p><b>A. Core Skills/ Generic Skills</b></p>	<p><b>Writing Skills</b>          You need to know and understand how to:          SA1. Write clear and short sentences</p> <p><b>Reading Skills</b>          SA2. comprehend written instructions</p> <p><b>Oral Communication (Listening and Speaking skills)</b>          SA3. communicate with supervisor appropriately          SA4. talk to others to convey information effectively</p>
<p><b>B. Professional Skills</b></p>	<p><b>Problem Solving</b>          You need to know and understand how to:          SB1. apply problem-solving approaches in different situations          SB2. refer anomalies to the supervisor          SB3. seek clarification on problems from others</p> <p><b>Attention to Detail</b>          SB5. apply good attention to detail          SB6. check your work is complete and free from errors</p>
<p><b>C. Technical Skills</b></p>	<p>You need to know and understand:          SC1. skill to identify the defects in empty bobbin          SC2. procedure to arrange empty bobbin in the bobbin trolley          SC3. procedure to operate different material handling equipments          SC4. proper material handling of empty bobbin and sliver can          SC5. procedure to distribute the existing slivers without waste to sliver cans          SC6. procedure for proper material handling of sliver          SC7. standard piecing technique for piecing the sliver          SC8. maintainance of neatness at work place</p>

**TSC/N 0119**

**Preparing for doffing**

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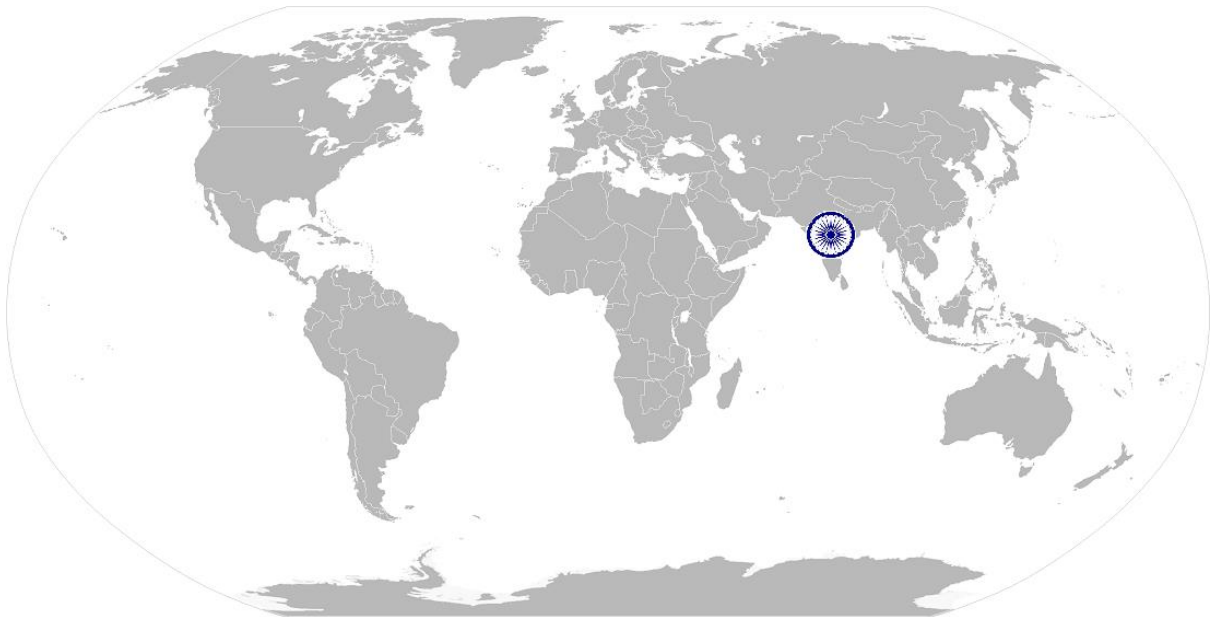
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<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



**TSC/N 0120**

**Carrying out doffing activity**

# National Occupational Standard



## Overview

This unit is about carrying out the doffing activities in a speed frame machine.

**TSC/N 0120**

**Carrying out doffing activity**

National Occupational Standard	<b>Unit Code</b>	TSC/N 0120
	<b>Unit Title (Task)</b>	Carrying out doffing activity
	<b>Description</b>	This unit is about carrying out the doffing in the speed frame machine
	<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>transport the empty bobbin trolley to the speed frame machine</li> <li>carrying out doffing</li> <li>Check for completion of doffing activity</li> </ul>
	<b>Performance Criteria (PC) w.r.t. the Scope</b>	
	<b>Elements</b>	<b>Performance Criteria</b>
	Transport the empty bobbin trolley to the speed frame machine	To be competent you must be able to: PC1. transport the empty bobbin trolley to the front part of speed frame machine PC2. arrange the empty bobbin trolley in an organized manner PC3. stop the machine
	Carrying out doffing	PC4. ensure the machine is completely stopped and open the safety door PC5. remove the fully bobbin from spindle and store in the bobbin trolley PC6. fix the empty bobbin in the spindle PC7. repeat the doffing activity for specified number of spindles as instructed by his / her superior PC8. gait the roving end with the empty bobbin PC9. ensure proper material handling of roving and full bobbin PC10. ensure minimum time is taken for carrying out doffing activity
	Check for completion of doffing activity	PC11. ensure all the full bobbins are replaced with empty bobbins PC12. ensure gaiting is done for all the spindles in a proper manner PC13. ensure all the full bobbins are placed in the bobbin trolley
	<b>Knowledge and Understanding (K)</b>	
<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	You need to know and understand: KA1. standard operating procedures (SOP) and regulations in a spinning mill KA2. safe working practices to be adopted in spinning mill KA3. quality systems and other processes practiced in the spinning mill KA4. reporting to the supervisor or higher authority in case of emergency KA5. color coding adopted for different counts in the spinning mill	
<b>B. Technical Knowledge</b>	You need to know and understand: KB1. the importance of different types of fibres, sliver, roving, yarn, hank and count. KB2. the types of roving defects and reason for roving breakage KB3. process and material flow in a spinning mill KB4. functions of different parts of a speed frame machine KB5. functions of different signal lamps and control buttons KB6. knowledge on doffing KB7. guidelines for operating the speed frame machine KB8. operational procedure for carrying out doffing activity KB9. importance of material handling KB10. safety procedures to be followed in a speed frame machine	



**TSC/N 0120**

**Carrying out doffing activity**

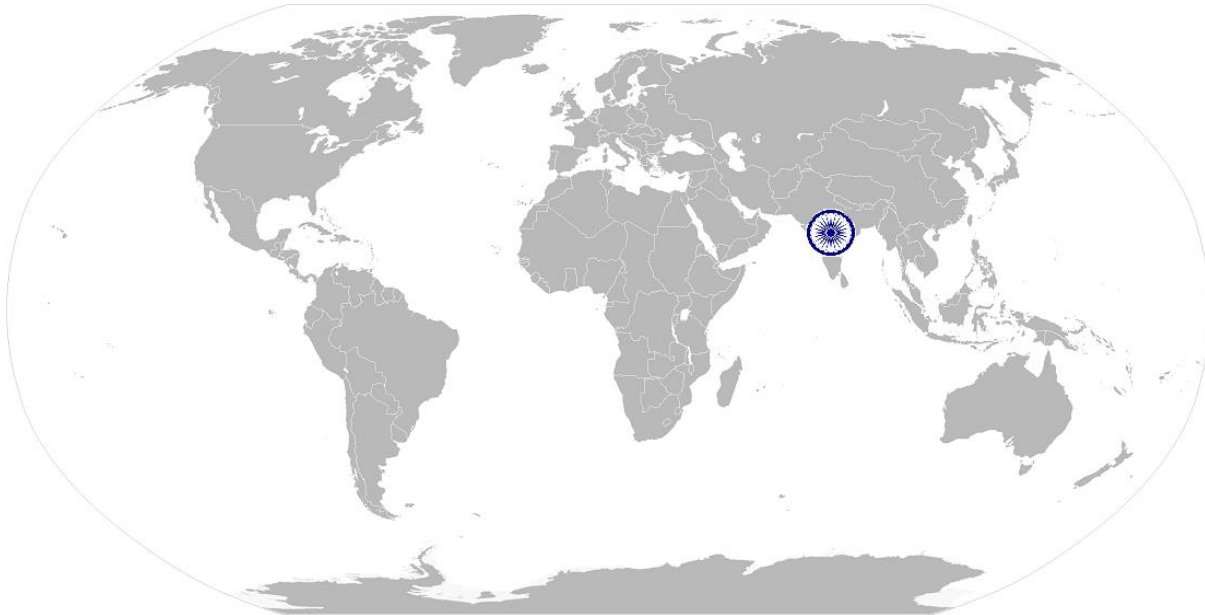
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>
	You need to know and understand how to: SA1. write clear and short sentences
	<b>Reading Skills</b>
	SA2. comprehend written instructions
	<b>Oral Communication (Listening and Speaking skills)</b>
	SA3. communicate with supervisor appropriately SA4. talk to others to convey information effectively
<b>B. Professional Skills</b>	<b>Problem Solving</b>
	You need to know and understand how to: SB1. apply problem-solving approaches in different situations SB2. refer anomalies to the supervisor SB3. seek clarification on problems from others
	<b>Attention to Detail</b>
	You need to know and understand how to: SB4. apply good attention to detail SB5. check your work is complete and free from errors
<b>C. Technical Skills</b>	You need to know and understand : SC1. standard operation procedure for transporting & arranging the empty bobbin trolley near speed frame machine SC2. standard operating procedure for carrying out doffing activity SC3. procedure for cleaning different in delivery zone SC4. proper material handling roving and roving bobbin SC5. maintain neatness at work

**TSC/N 0120**

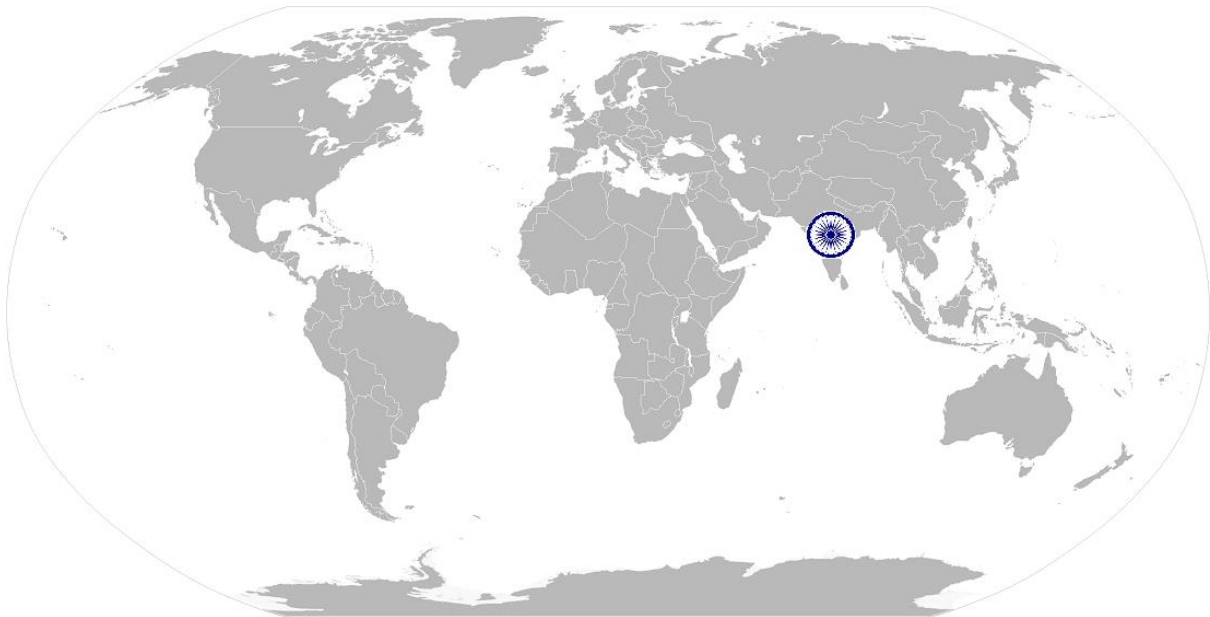
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**NOS Version Control**

<b>NOS Code</b>	<b>TSC/N 0120</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



# National Occupational Standard



## Overview

This unit is about carrying out responsibilities of a speed frame doffer post doffing activity

**TSC/Q 0121**

**Tenting responsibilities**

National Occupational Standard	<b>Unit Code</b>	<b>TSC/Q 0121</b>
	<b>Unit Title (Task)</b>	<b>Tenting responsibilities</b>
	<b>Description</b>	The unit is about carrying out the responsibilities of a speed frame doffer post doffing activity
	<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ Post doffing activities</li> <li>▪ Transporting &amp; storing the filled bobbin</li> <li>▪ Other responsibilities</li> </ul>
	<b>Performance Criteria (PC) w.r.t. the Scope</b>	
	<b>Elements</b>	<b>PerformanceCriteria</b>
	Post doffing responsibilities	To be competent you must be able to: PC1. ensure the doffing is carried out in a proper manner PC2. ensure the delivery zone is clean PC3. support the tenter by bringing draw frame can for creeling, creeling activities and piecing in the event of a count change PC4. ensuring the machine is ready to start PC5. ensure proper functioning of machine PC6. report to the supervisor / maintenance team if the machine is not functioning properly
	Transporting & storing the filled bobbin	PC7. ensure proper transportation of filled bobbin trolley PC8. ensure count wise storage of filled roving bobbin in storage area PC9. ensure proper material handling of roving bobbin PC10. Ensure material is covered post doffing
	Other responsibilities	PC11. ensure in keeping the empty bobbins clean and arranged in proper manner PC12. clean the defective roving bobbins in the respective shift PC13. segregate the sliver waste and roving waste count wise and store in the respective waste bins PC14. weigh the different types of waste collected in the speed frame departments PC15. transport the collected wastes to the waste room PC16. support tenter in carrying out tenting activities then and there as instructed by supervisor PC17. support the maintenance team while machine is under maintenance PC18. clean the gear end, off end, spindle rails, spindles, bobbin rail, clearer rollers and other parts of machine as instructed by supervisor using proper cleaning tools PC19. take part doffs wherever necessary as instructed by the supervisor PC20. transport the empty cans to the draw frame can storage area after count change PC21. ensure cleanliness at work place
	<b>Knowledge and Understanding (K)</b>	
<b>A. Organizational Context</b> (Knowledge of the	You need to know and understand: KA1. standard operating procedures (SOP) and regulations in a spinning mill KA2. safe working practices to be adopted in spinning mill	

**TSC/Q 0121**

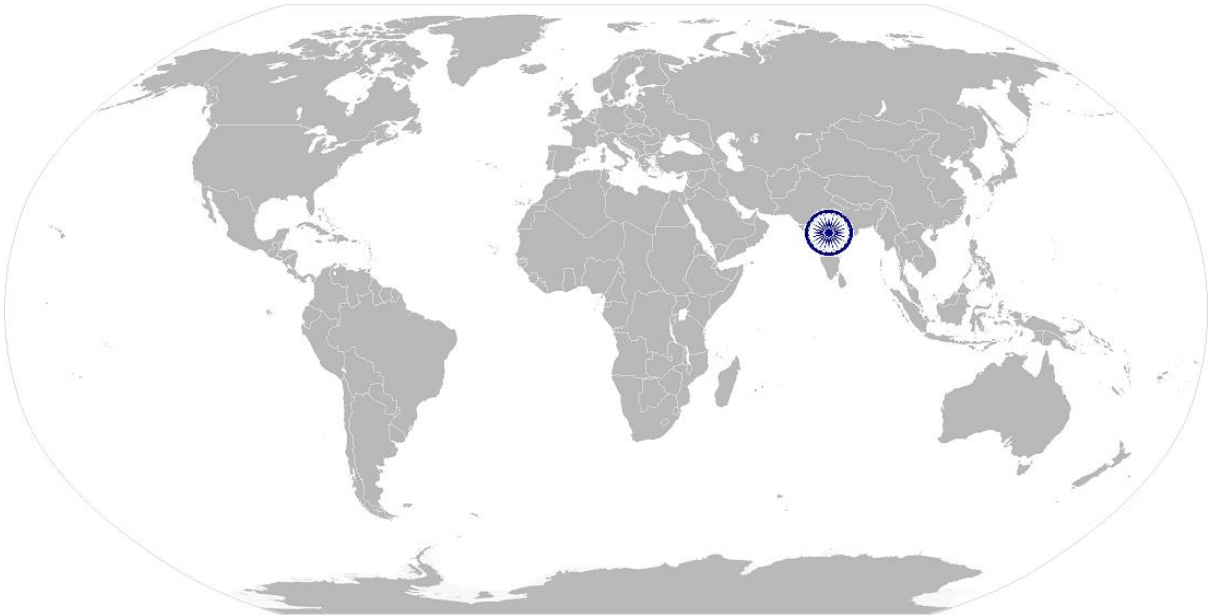
**Tenting responsibilities**

company/ organization and its processes)	KA3. quality systems and other processes practiced in the spinning mill KA4. report to the supervisor or higher authority in case of emergency KA5. color coding adopted for different counts in the spinning mill
<b>B. Technical Knowledge</b>	You need to know and understand: KB1. process and material flow in a spinning mill KB2. functions of different parts of a speed frame machine KB3. knowledge of different types of roving defects KB4. importance of removing the defective roving KB5. types of waste collected from the speed frame machine KB6. importance of cleaning KB7. types and functions of various cleaning tools and equipments KB8. guidelines for cleaning the various part of speed frame machine KB9. operational schedule for cleaning different parts of speed frame machine KB10. knowledge on the tenting activities to be followed in a speed frame machine KB11. importance of machine maintenance KB12. knowledge of basic maintenance activities to be carried out in a speed frame machine KB13. guidelines for carrying out routine preventive maintenance activities
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<p><b>Writing Skills</b></p> You need to know and understand how to: SA1. write clear and short sentences
<b>B. Professional Skills</b>	<p><b>Reading Skills</b></p> SA2. read and comprehend written instructions
<b>C. Technical Skills</b>	<p><b>Oral Communication (Listening and Speaking skills)</b></p> SA3. communicate with supervisor appropriately SA4. talk to others to convey information effectively
<b>B. Professional Skills</b>	<p><b>Problem Solving</b></p> You need to know and understand how to: SB1. apply problem-solving approaches in different situations SB2. refer anomalies to the supervisor SB3. seek clarification on problems from others
<b>C. Technical Skills</b>	<p><b>Attention to Detail</b></p> You need to know and understand how to: SB4. apply good attention to detail SB5. check your work is complete and free from errors
<b>C. Technical Skills</b>	You need to know and understand how to: SC1. clean the empty bobbin SC2. arrange the empty bobbins in storage area SC3. remove the defects in roving bobbin SC4. clean different parts of machine SC5. clean the doffing zone SC6. handle different material handling tools

**TSC/Q 0121**

**Tenting responsibilities**

	<p>SC7. follow standard piecing procedure SC8. follow standard doffing procedure SC9. transport filled bobbin trolley SC10. segregate the different types of waste SC11. do material handling of sliver cans</p>
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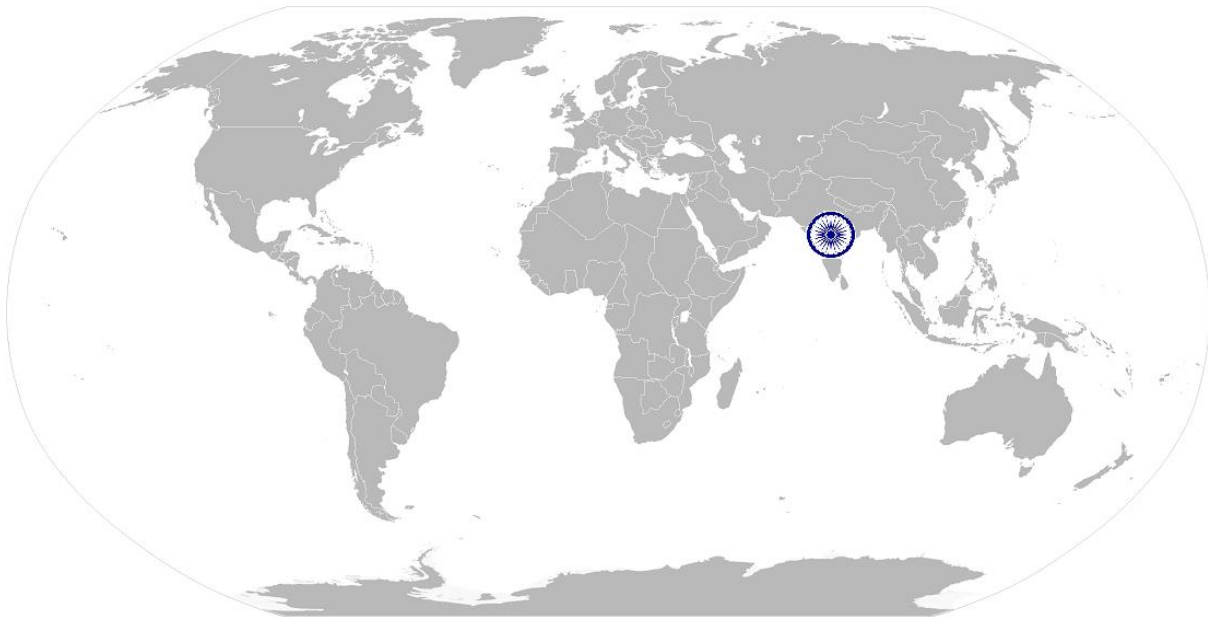


**TSC/Q 0121**

**Tenting responsibilities**

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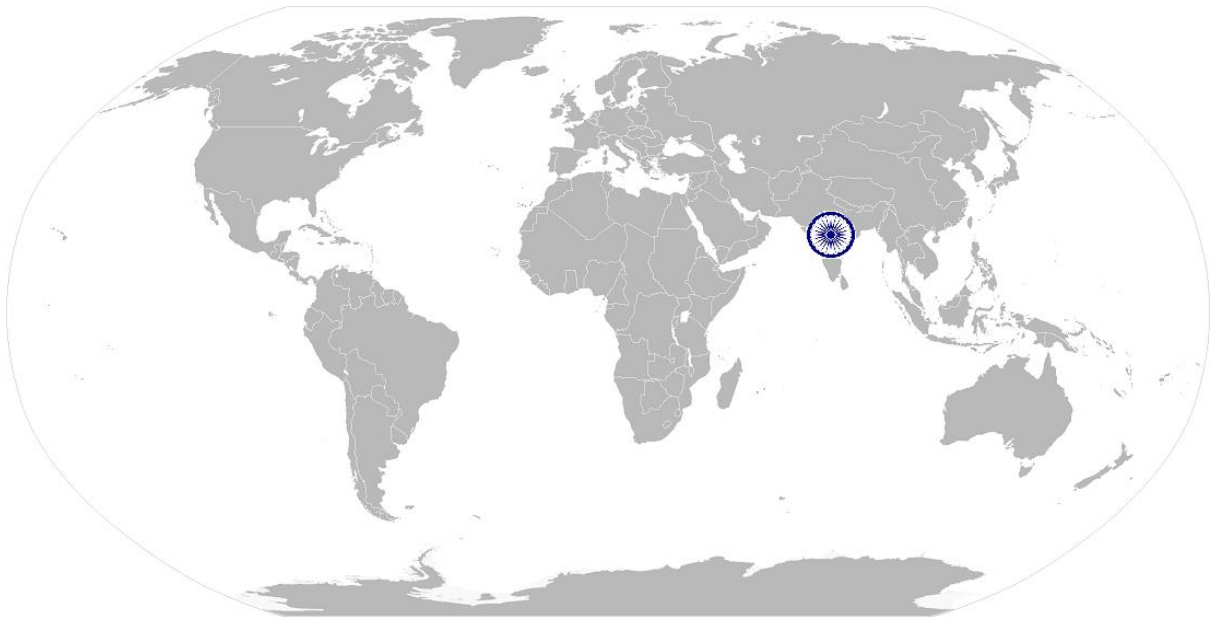
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<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



TSC/Q 0122

Carry out additional tenting responsibilities effectively

# National Occupational Standard



## Overview

This unit is about carrying out the tenting responsibilities in a speed frame machine other than piecing the sliver and rove



**TSC/ N0122 Carry out additional tenting responsibilities effectively**

National Occupational Standard	<b>Unit Code</b>	<b>TSC/Q 0122</b>
	<b>Unit Title (Task)</b>	<b>Carryout additional tenting responsibilities effectively</b>
	<b>Description</b>	This unit is about carrying out the tenting responsibilities in a speed frame machine other than piecing the sliver and rove
	<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ Carryout cleaning &amp; maintenance activities</li> <li>▪ Carryout preventive maintenance activities</li> <li>▪ other tenting responsibilities</li> </ul>
	<b>Performance Criteria (PC) w.r.t. the Scope</b>	
	<b>Elements</b>	<b>PerformanceCriteria</b>
	Carry out cleaning & maintenance activities	To be competent, you must be able to: <ul style="list-style-type: none"> <li>PC1. clean the creeling area</li> <li>PC2. ensure proper removal of dusts from the creeling zone</li> <li>PC3. clean the front and back portion of the machine</li> <li>PC4. clean the back portion of the drafting arrangement</li> <li>PC5. clean the front portion of drafting arrangement</li> <li>PC6. ensure proper cleaning of drafting zone</li> <li>PC7. clean the flyer, bobbin rail and spindle rail</li> <li>PC8. collect the wastes in the waste collection chamber and depositing in the waste collection box</li> <li>PC9. remove the wastes in the clearer rollers on a timely basis</li> <li>PC10. ensure the wastes collected from different parts of machine are deposited in the respective dustbins</li> <li>PC11. clean the alley around the speed frame machine using proper cleaning equipments</li> <li>PC12. ensure the speed frame department is neat and clean</li> </ul>
	Carry out preventive maintenance activities	<ul style="list-style-type: none"> <li>PC13. ensure proper functioning of machine</li> <li>PC14. check and verify the quality of different machine parts</li> <li>PC15. remove the worn out parts and replace with new parts in speed frame machine</li> <li>PC16. carry out preventive maintenance activities at the specified intervals</li> <li>PC17. oil the different parts of speed frame machine if necessary</li> </ul>
	Other tenting responsibilities	<ul style="list-style-type: none"> <li>PC18. Verify the proper build of the roving bobbin</li> <li>PC19. support the doffer while carrying out doffing activities</li> <li>PC20. record the production details in the production report</li> <li>PC21. report to the supervisor in case of emergency stoppage of machine</li> <li>PC22. report to the supervisor and maintenance incharge if the operator was able to replace the worn out machine part with a new one.</li> <li>PC23. support the maintenance team while machine is under maintenance</li> <li>PC24. ensure all details related to production are provided the next shift operator while relieving</li> <li>PC25. ensure count wise storage of wound bobbin without damaging the roving</li> </ul>
	<b>Knowledge and Understanding (K)</b>	

**TSC/Q 0122**

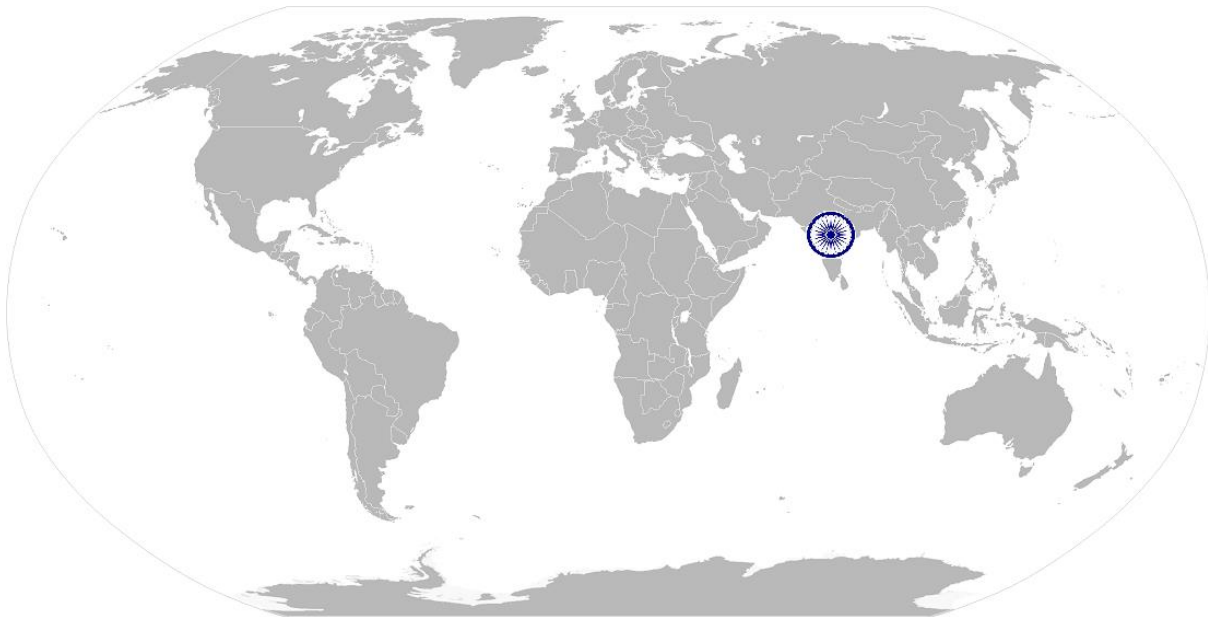
**Carry out additional tenting responsibilities effectively**

<p><b>B. Organizational Context</b> (Knowledge of the company/ organization and its processes)</p>	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning mill KA2. safe working practices to be adopted KA3. quality systems and other processes practiced in the spinning mill KA4. reporting to the supervisor or higher authority in case of emergency</p>
<p><b>B. Technical Knowledge</b></p>	<p>You need to know and understand:</p> <p>KB1. process and material flow in a spinning mill KB2. functions of different parts of a speed frame machine KB3. importance of cleaning KB4. types and functions of various cleaning tools and equipments KB5. types of waste collected from the speed frame machine KB6. guidelines for cleaning the various part of speed frame machine KB7. operational schedule for cleaning different parts of speed frame machine KB8. operational schedule for collecting wastes from waste collection chamber KB9. types of possible worn out parts in a speed frame machine KB10. guidelines for carrying out routine preventive maintenance activities KB11. knowledge on the function of building mechanism in speed frame machine KB12. knowledge of the types of oil used for preventive maintenance KB13. understanding the safety precautions to be followed in a speed frame department</p>
<p><b>Skills (S)</b></p>	
<p><b>D. Core Skills/ Generic Skills</b></p>	<p><b>Writing Skills</b> You need to know and understand how to: SA1. write clear and short sentences</p> <p><b>Reading Skills</b> SA2. comprehend written instructions</p> <p><b>Oral Communication (Listening and Speaking skills)</b> SA3. communicate with supervisor appropriately SA4. talk to others to convey information effectively</p>
<p><b>E. Professional Skills</b></p>	<p><b>Problem Solving</b> You need to know and understand how to: SB1. apply problem-solving approaches in different situations SB2. refer anomalies to the supervisor SB3. seek clarification on problems from others</p> <p><b>Attention to Detail</b> SB4. apply good attention to detail SB5. check your work is complete and free from errors</p>
<p><b>D. Technical Skills</b></p>	<p>You need to know and understand :</p> <p>SC1. procedure for operating the various cleaning tools and equipments SC2. procedure for cleaning the creeling area SC3. procedure for cleaning the drafting zone SC4. procedure for cleaning the flyer, bobbin rail and spindle rails</p>

**TSC/Q 0122**

**Carry out additional tenting responsibilities effectively**

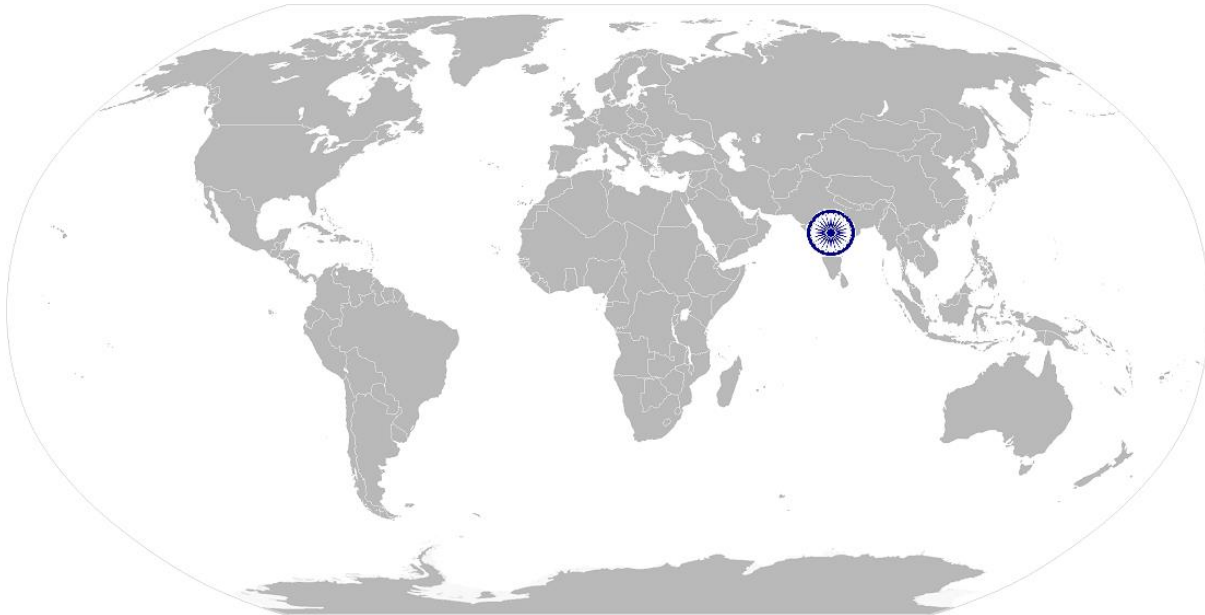
	<p>SC5. procedure for collection of wastes from waste collection chamber</p> <p>SC6. procedure for cleaning the waste collection chamber</p> <p>SC7. procedure for cleaning the other parts of speed frame machine</p> <p>SC8. procedure for cleaning the alley around the speed frame machine</p> <p>SC9. procedure for proper material handling of cleaning equipments</p> <p>SC10. Maintainance of neatness at work</p> <p>SC11. procedure to identify and remove worn out parts in speed frame machine</p> <p>SC12. procedure to replace the worn out parts with a new machine part</p> <p>SC13. procedure for carrying our preventive maintenance activities</p> <p>SC14. procedure for oiling different parts of speed frame machine</p> <p>SC15. procedure to store the full bobbin in the storage area without damaging the roving</p>
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**TSC/ N0122      Carry out additional tenting responsibilities effectively**

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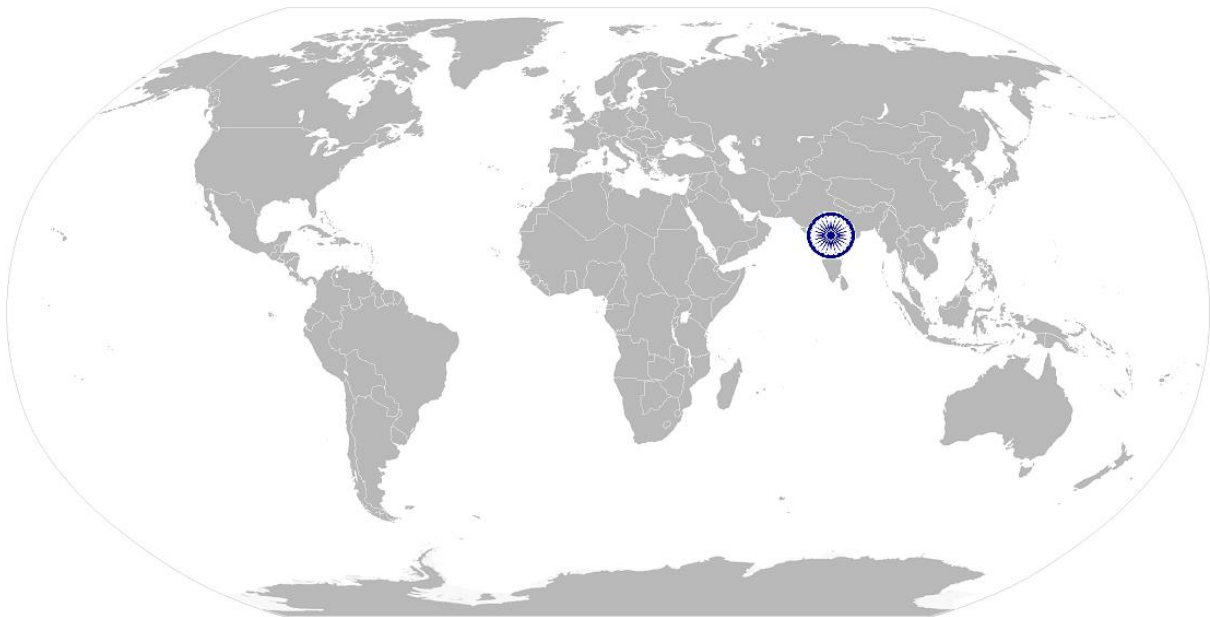
<b>NOS Code</b>	<b>TSC/Q 0122</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



**TSC/ N9001**

**Maintain 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**

**Maintain work area, tools and machines**

<b>Unit Code</b>	<b>TSC/ N9001</b>
<b>Unit Title (Task)</b>	<b>Maintain work area, tools and machines</b>
<b>Description</b>	This unit provides performance criteria, knowledge & understanding and skills & abilities required to organise/ maintain work areas and activities to ensure tools and machines are maintained as per norms
<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ Maintain the work area, tools and machines</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
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>
<b>Knowledge and Understanding (K)</b>	
<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. personal hygiene and duty of care</p> <p>KA2. organization's standard operating procedures (SOP)</p> <p>KA3. limits of your own responsibility</p> <p>KA4. ways of resolving with problems within the work area</p> <p>KA5. the production process and the specific work activities that relate to the whole process</p> <p>KA6. the importance of effective communication with supervisors</p> <p>KA7. the lines of communication, authority and reporting procedures</p> <p>KA8. the organisation's rules, codes and guidelines (including timekeeping)</p> <p>KA9. the company's quality standards</p> <p>KA10. the importance of complying with written instructions</p> <p>KA11. equipment operating procedures / supervisor's instructions</p>
<b>B. Technical Knowledge</b>	<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>

**TSC/ N9001**

**Maintain work area, tools and machines**

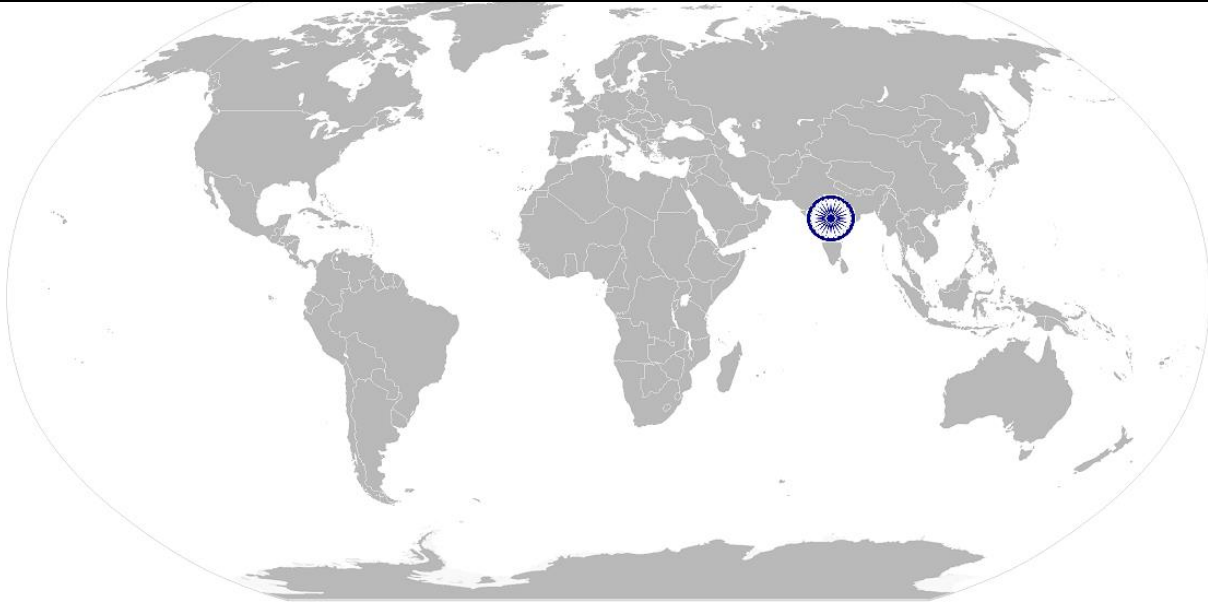
	<p>KB3. hazards likely to be encountered when conducting routine maintenance</p> <p>KB4. the importance of taking action when problems are identified</p> <p>KB5. different ways of minimising waste</p> <p>KB6. the importance of running maintenance and regular cleaning</p> <p>KB7. effects of contamination on products i.e. machine oil, dirt, foreign materials</p> <p>KB8. common faults with equipment and the method to rectify</p> <p>KB9. maintenance procedures</p> <p>KB10. different types of cleaning equipment and substances and their use</p> <p>KB11. safe working practices for cleaning and the method of carrying them out</p>
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<b>Reading Skills</b>
	You need to know and understand how to:
	<p>SA1. comprehend written instructions</p> <p>SA2. read any application sent by other colleagues</p>
<b>B. Professional Skills</b>	<b>Oral Communication (Listening and Speaking skills)</b>
	You need to know and understand how to:
	<p>SA3. Communicate effectively in local language</p> <p>SA4. communicate with supervisor appropriately</p> <p>SA5. talk to others to convey information effectively</p>
<b>C. Technical Skills</b>	<b>Problem Solving</b>
	You need to know and understand how to:
	<p>SB1. identify the real reason of problem faced</p> <p>SB2. apply problem-solving approaches in different situations</p> <p>SB3. refer anomalies to the supervisor</p> <p>SB4. seek clarification on problems from others</p>
<b>C. Technical Skills</b>	<b>Attention to Detail</b>
	You need to know and understand how to:
	<p>SB5. apply good attention to detail</p> <p>SB6. check your work is complete and free from errors</p> <p>SB7. make sure every kind of communication is error free</p>
<b>C. Technical Skills</b>	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**

**Maintain work area, tools and machines**

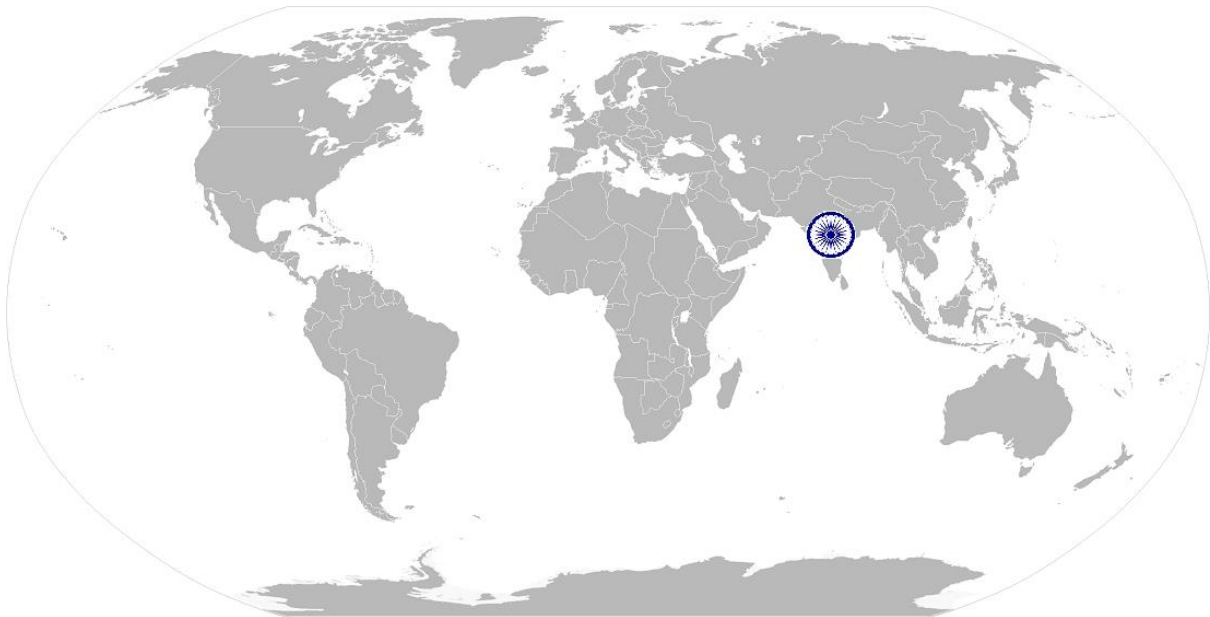
**NOS Version Control**

<b>NOS Code</b>	<b>TSC/ N9001</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>





# National Occupational Standard



## Overview

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

**TSC/ N9002**

**Working in a team**

<b>Unit Code</b>	<b>TSC/ N9002</b>
<b>Unit Title (Task)</b>	<b>Working in a team</b>
<b>Description</b>	This unit is about working as a team member in the textile industry
<b>Scope</b>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ commitment and trust</li> <li>▪ communication</li> <li>▪ adaptability</li> <li>▪ creative freedom</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
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
<b>Knowledge and Understanding (K)</b>	
<b>A. Organizational Context</b>	You need to know and understand: <ul style="list-style-type: none"> <li>KA1. standard operating procedures (SOP) and regulations in a textile mill</li> <li>KA2. procedure followed to get the final output in the mill</li> <li>KA3. safe working practices to be adopted in textile mill</li> <li>KA4. reporting to the supervisor or higher authority about any grievances faced</li> </ul>
<b>B. Technical Knowledge</b>	<ul style="list-style-type: none"> <li>KB1. the importance of the previous and next step of the process</li> <li>KB2. process flow in a textile mill and the concerned workers</li> <li>KB3. material flow in a textile mill and the required person</li> <li>KB4. functions of different parts of the machine</li> <li>KB5. tools and equipments used</li> <li>KB6. guidelines for operating the machine</li> <li>KB7. safety procedures to be followed in the machine</li> </ul>
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>
	You need to know and understand how to: <ul style="list-style-type: none"> <li>SA1. write clear and short sentences</li> <li>SA2. write daily work report</li> <li>SA3. write grievance complaint application</li> </ul>
	<b>Reading Skills</b>

**TSC/ N9002**

**Working in a team**

	SA4. comprehend written instructions SA5. read any application sent by other colleagues
	<b>Oral Communication (Listening and Speaking skills)</b>
	SA6. communicate with supervisor appropriately SA7. talk to co-workers to convey information effectively
<b>B. Professional Skills</b>	<b>Problem Solving</b>
	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
	<b>Attention to Detail</b>
	SB3. apply good attention to detail SB4. ensure every kind of communication is error free
<b>C. Technical Skills</b>	You need to know and understand how to: SC10. communicate effectively SC11. apply leadership skills wherever required SC12. take initiative at the right place SC13. understand the requirement to be creative

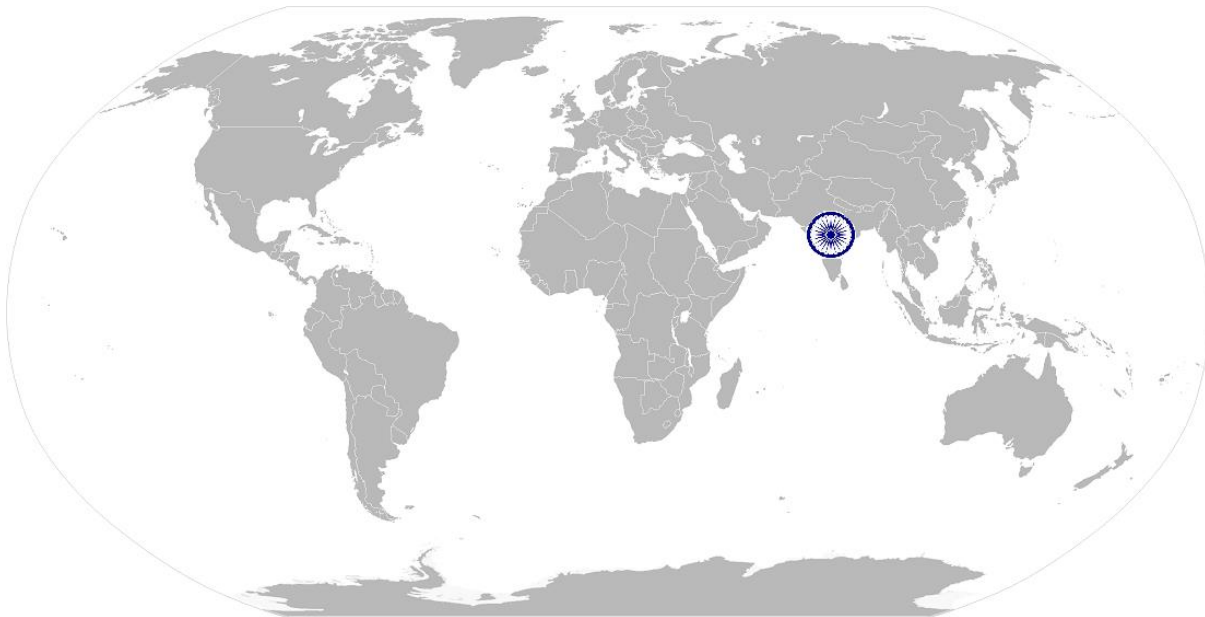


**TSC/ N9002**

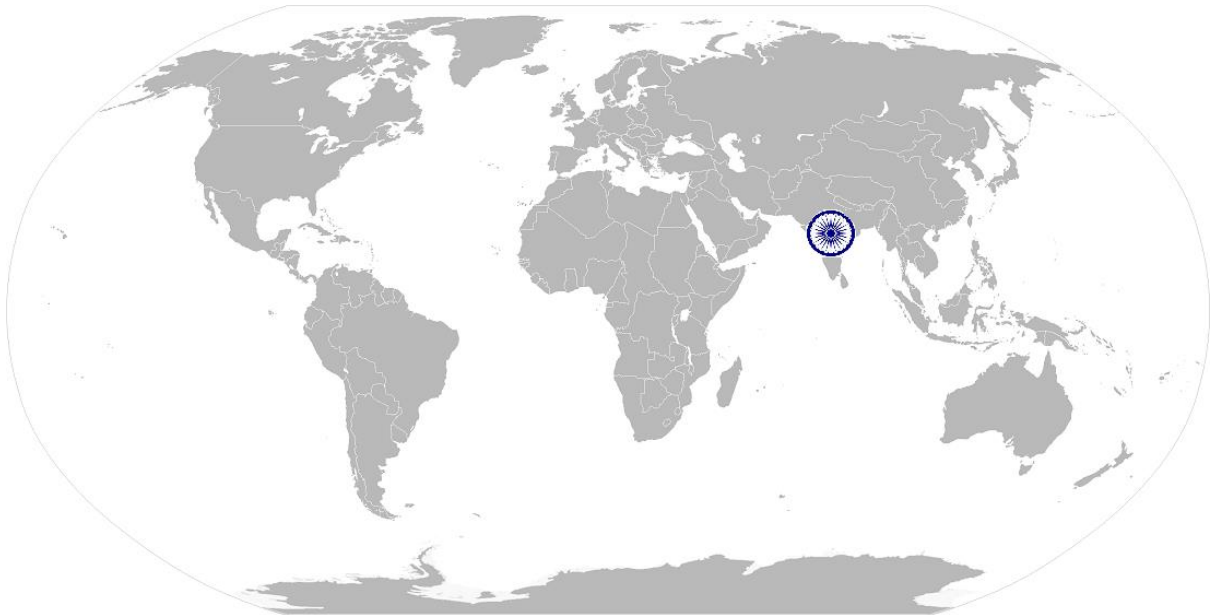
**Working in a team**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/ N9002</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



# 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**

National Occupational Standard

<b>Unit Code</b>	<b>TSC/ N9003</b>
<b>Unit Title (Task)</b>	<b>Maintain health, safety and security at work place</b>
<b>Description</b>	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.
<b>Scope</b>	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> <li>▪ Comply with health, safety and security requirements at work</li> <li>▪ Recognizing the hazards</li> <li>▪ Planning the safety techniques</li> <li>▪ Implementing the programs</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
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>
Planning the safety	PC21. recognise different measures to curb the hazards

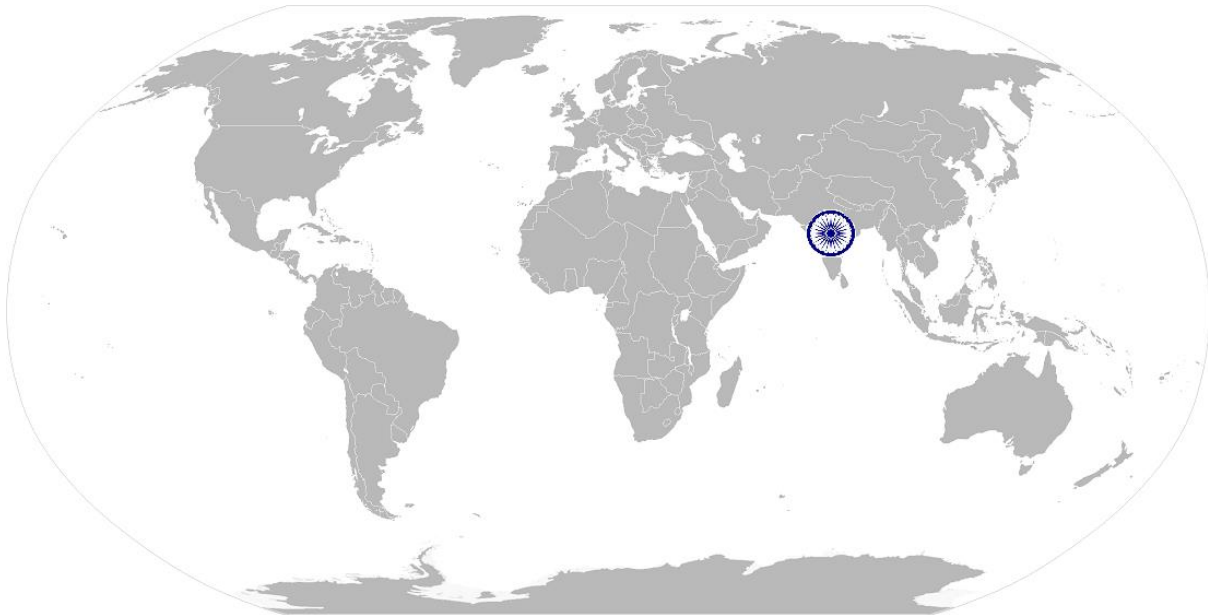
**TSC/ N9003 Maintain health, safety and security at work place**

techniques	
Implementing the programs	PC22. communicate the safety plan to everyone PC23. attach disciplinary rules with the implementation
<b>Knowledge and Understanding (K)</b>	
<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	You need to know and understand: KA1. standard operating procedures (SOP) and regulations in a spinning mill KA2. safe working practices to be adopted in spinning mill KA3. quality systems and other processes practiced in the spinning 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>B. Technical Knowledge</b>	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
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>
	You need to know and understand how to: SA1. write clear and short sentences
	<b>Reading Skills</b>
	You need to know how to: SA2. read and understand the company instructions SA3. read and understand the local language SA4. read and understand the safety guidelines
	<b>Oral Communication (Listening and Speaking skills)</b>
	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>B. Professional Skills</b>	<b>Decision Making</b>

**TSC/ N9003**

**Maintain health, safety and security at work place**

	SB1. identify correct safety measure for particular hazard
	SB2. make required safety plans as and when required
	SB3. raise alarm in case of emergency
	<b>Analytical Thinking</b>
	SB4. know the use of correct safety measure whenever required
	<b>Attention to Detail</b>
	SB5. be attentive to details
	SB6. be careful to avoid occurrence of hazards
<b>C. Technical Skills</b>	You need to know and understand how to: SC1. maintain neatness at work SC2. procedure for reporting unwanted behavior



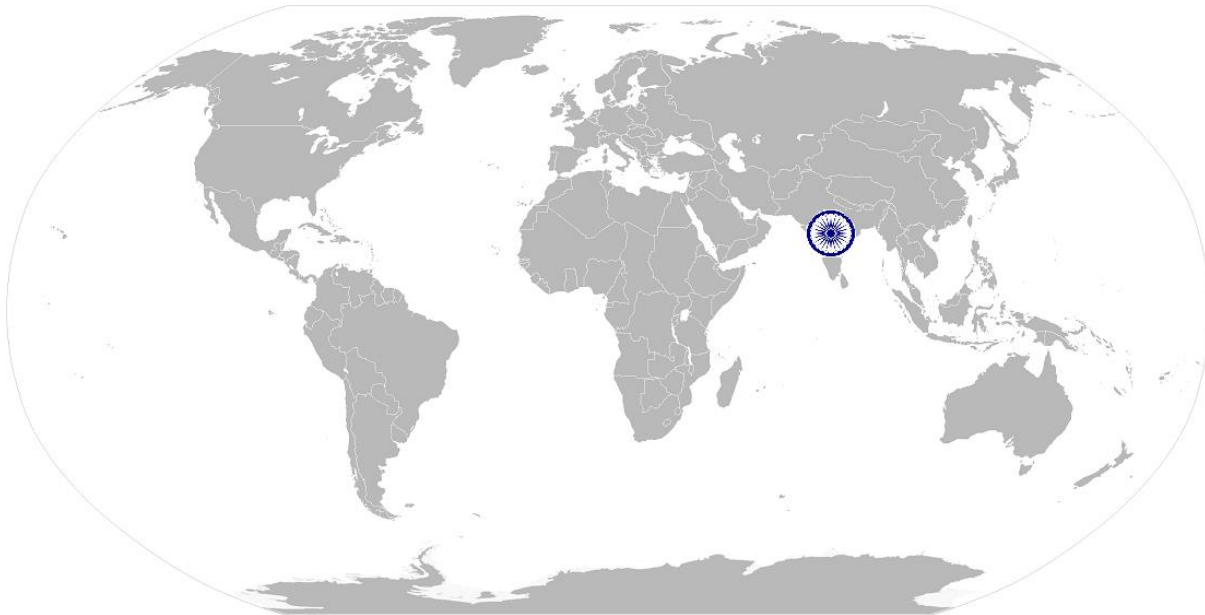


**TSC/ N9003**

**Maintain health, safety and security at work place**

**NOS Version Control**

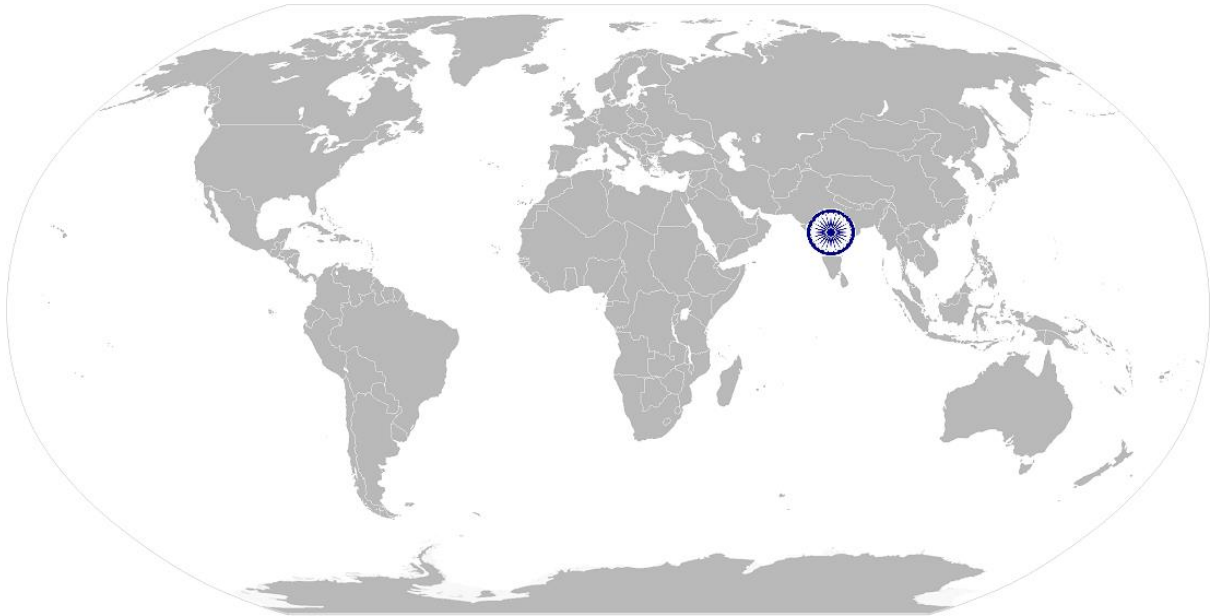
<b>NOS Code</b>	<b>TSC/ N9003</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



TSC/ N9004

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/ N9004

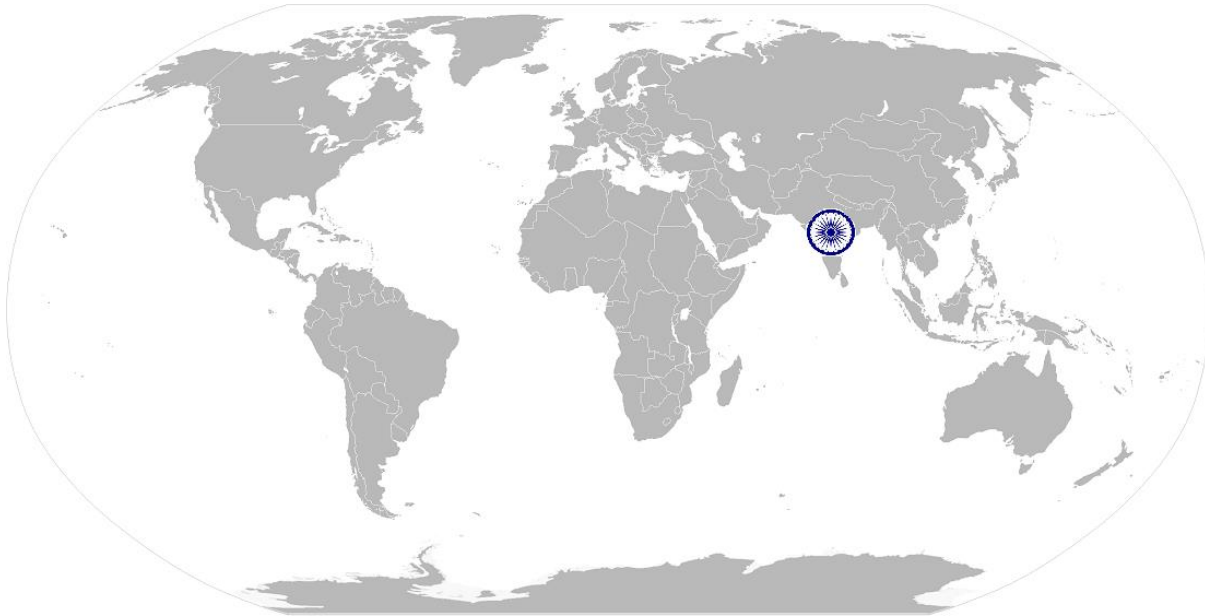
Comply with industry and organizational requirements

National Occupational Standard	<b>Unit Code</b>	TSC/ N9004
	<b>Unit Title (Task)</b>	Comply with industry and organizational requirements
	<b>Description</b>	This unit is about knowing, understanding, and complying with the requirements of the organization and the textile industry
	<b>Scope</b>	<p><b>This unit/task covers the following:</b></p> <ul style="list-style-type: none"> <li>▪ self development</li> <li>▪ team work</li> <li>▪ organizational standards</li> <li>▪ industry standards</li> </ul>
	<b>Performance Criteria (PC) w.r.t. the Scope</b>	
	<b>Elements</b>	<b>PerformanceCriteria</b>
	Self- development	<p>To be competent, you must be able to:</p> <p>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</p>
	Team work	<p>PC6. co-ordinate with all the team members and colleagues            PC7. communicate politely            PC8. avoid conflicts and miscommunication</p>
	Organisational standards	<p>PC9. know the organisational standards            PC10. implement them in your performance            PC11. motivate others to follow them</p>
	Industry standards	<p>PC12. know the industry standards            PC13. align them with organisation standards</p>
	<b>Knowledge and Understanding (K)</b>	
	<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a textile mill            KA2. reporting to the supervisor or higher authority            KA3. knowledge of organisational standards            KA4. knowledge of industry standards</p>
	<b>B. Technical Knowledge</b>	<p>You need to know and understand:</p> <p>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</p>
<b>Skills (S)</b>		
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>	
	<p>You need to know and understand how to:</p> <p>SA1. write clear and short sentences</p>	

TSC/ N9004

Comply with industry and organizational requirements

	<b>Reading Skills</b>
	You need to know and understand how to: SA2. read the given instructions SA3. comprehend written instructions
	<b>Oral Communication (Listening and Speaking skills)</b>
	SA4. talk effectively with others SA5. put forward your point SA6. listen to others
<b>B. Technical skills</b>	you need to know and understand : SC12. Organizational requirements SC13. your responsibilities at the workplace SC14. procedure to comply with the industry standards

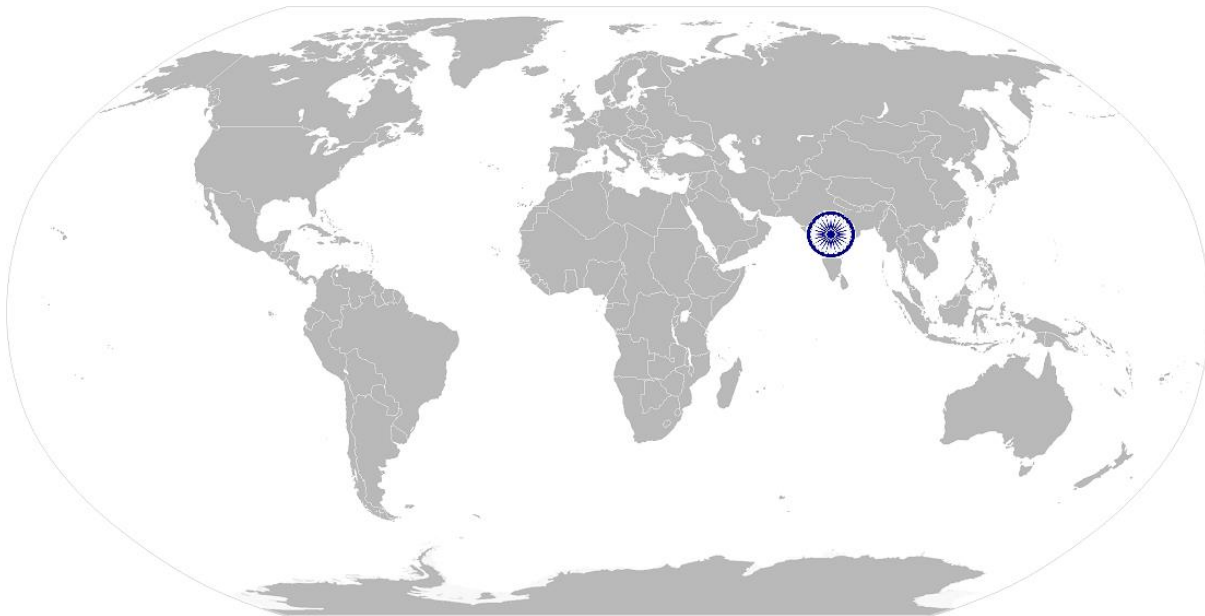


**TSC/ N9004**

**Comply with industry and organizational requirements**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/N 9004</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Spinning</b>	<b>Last reviewed on</b>	<b>25/02/15</b>
<b>Occupation</b>	<b>Spinning Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



**Assessment Criteria**

<b>Job Role: Speed Frame Operator – Tenter &amp; Doffer</b> <b>Qualification Pack: TSC/ Q 0106</b> <b>Sector Skill Council: Textile Sector Skill Council</b>						
<b>Guidelines for assessment :-</b>  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		
				Theory	Skills Practical	Viva
<b>1. TSC/ N 0116 Taking charge of shift and handing over shift to operator</b>	PC1. Come atleast 10 - 15 minutes earlier to the work spot	<b>100</b>	2	1	1	0
	PC2. Bring the necessary operational tools to the department		4	1	2	1
	PC3. Meet the previous shift operator and discuss with him/ her regarding the issues faced by them with respect to the quality or production or spare or safety or any other specific instruction etc.		4	1	1	2
	PC4. Understand the count produced, colour coding, followed in the speed frames for his allocated number of spindles or machines		4	1	1	2
	PC5. Ensure the technical details are		3	1	1	1

**Assessment criteria**

mentioned in the display board in the speed frame machine				
PC6. Should check for the availability of the spare roving bobbins	2	1	1	0
PC7. Should check the availability of bobbin trolley with technical details mentioned regarding the count being produced	2	1	1	0
PC9. Check the roving passage and yarn formation is proper	4	1	2	1
PC10. Should check for the run outs , availability of the roving bobbins	3	1	1	1
PC11. Ensure all the spindles are running properly, if not should be enquired for the reason for idle spindle and report to the superiors regarding the same	4	2	1	1
PC12. Should check the condition of different running boobbins	3	1	1	1
PC13. Ensure proper functioning of speed frame machine parts and machine	4	1	2	1
PC14. Ensure all allocated spindles are running with uniform length of roving is wound on bobbin, variations if any should be discussed with operator and reported to superiors	3	1	1	1
PC15. Check the condition of running spindles, damages if any should be reported	3	1	1	1

**Assessment criteria**

PC16. Check the cleanliness of the machines & other work areas		3	1	1	1
PC17. Check whether any spare/raw material/ tool / yarn / any other material are thrown under the machines or in the other work areas.		4	2	1	1
PC18. Question the previous shift operator for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as well that of the previous shift as well.		4	1	2	1
PC19. Ensure no roller lapping in speed frame		3	1	1	1
PC20. Remove the roller lapping manually if any without damaging the cots		4	1	2	1
PC21. Ensure that only the correct size of spacer is used for replacement		3	1	1	1
PC22. Ensure the wastes collection boxes are empty while taking charge of shift		3	1	1	1
PC23. ensure the work spot is clean					
PC24. Should hand over the shift to the incoming speed frame tenter in a proper manner		4	1	1	2
PC25. Ensure in providing the details regarding hank / count produced, colour coding followed in the speed frames for his allocated		4	1	2	1



**Assessment criteria**

	number of spindles or machines				
	PC26. To provide all relevant information regarding the count produced, idle spindles, damaged machine parts if any	4	1	1	2
	PC27. Should get clearance from the incoming counterpart before leaving the work spot	3	1	1	1
	PC28. Should report to his/ her shift superiors as well as that of the incoming shift operator in case his/ her counterpart doesn't report for the incoming shift	4	1	1	2
	PC29. Ensure the shift has to be properly handed over to the incoming shift operator	3	1	1	1
	PC30. Should 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	4	1	1	2
	PC31. Should collect the wastes from waste collection bags, weigh them and transport to storage area	3	1	1	1
	PC32. Ensure the work spot is clean	2	1	1	0
	<b>Total</b>	<b>100</b>	<b>32</b>	<b>36</b>	<b>32</b>

**Assessment criteria**

		Weightage %	32%	36%	32%	
<b>2. TSC/N 0117- Piecing the broken sliver</b>	PC1. Identify whether the machine stoppage is due to a sliver breakage or roving breakage	<b>100</b>	5	2	2	1
	PC2. Move in the creel and identify which sliver is broken		5	2	2	1
	PC3. Identify the reasons for sliver breakage by viewing the breakage spot i.e., whether sliver is broken at creel or sliver is exhausted in the sliver can		6	2	3	1
	PC4. Ensure minimum time is taken for attending the sliver breakage		4	1	2	1
	PC5. Ensure that the sliver passes through the creeling section without affecting the quality of sliver		4	1	2	1
	PC6. Ensure proper length of sliver is available for piecing		5	2	3	0
	PC7. Piece the broken sliver together in the event of sliver breakage at creel section		6	2	3	1
	PC8. Piece the sliver between cans in the event of sliver exhaust in sliver can and replacement with a full sliver can		6	2	3	1
	PC9. Keep the sliver waste in the waste collection pocket provided to each tenter		5	2	2	1

**Assessment criteria**

	and then put in the waste in waste collection box				
	PC10. Ensure standard piecing procedure is adopted and quality of piecing is as per standards	6	2	3	1
	PC11. Ensure minimum time is taken for piecing the sliver	4	1	2	1
	PC12. Inspect the creeling section and identify the empty can and sliver cans which are about to be exhausted	4	1	2	1
	PC13. Remove the empty can and replace with the full can	5	2	2	1
	PC14. Dispose empty can to storage location/draw frame department	2	1	1	0
	PC15. Bring the full cans from draw frame department or from the drawn sliver can storage location	3	1	1	1
	PC16. Ensure colour coding of sliver can fed in the creel is correct	5	2	2	1
	PC17. Properly handle the sliver	5	2	2	1
	PC18. Ensure sliver surface doesn't gets damaged	4	2	1	1
	PC19. Use appropriate trolley to move/transport the sliver cans	2	1	1	0
	PC20. Verify the quality of piecing done in the sliver	5	1	3	1
	PC21. Ensure sliver tension in the creeling	5	2	2	1

**Assessment criteria**

	section is appropriate					
	PC22. Ensure proper functioning of the machine		4	1	2	1
	<b>Total</b>		<b>100</b>	<b>35</b>	<b>46</b>	<b>19</b>
		<b>Weightage %</b>		34%	47%	19%
<b>3 . TSC/N0118 - Piecing the broken roving</b>						
	PC1. Identify the reason for machine stoppage by seeing the signal lamps.	<b>75</b>	4	1	1	2
	PC2. Patrol and identify in which spindle the roving is broken		3	1	2	1
	PC3. Check and identify the reasons for roving breakage by viewing at the breakage spot i.e., whether the roving is broken at spindle or flyer or drafting zone		3	1	2	1
	PC4. Ensure minimum time is taken for attending and identifying the roving breakage		2	1	1	1
	PC5. Carryout Inching and trim drafted rove for piecing		2	0	1	0
	PC6. Lift the bobbin slightly from spindle to unwind the broken roving		2	0	1	0
	PC7. Unwind or remove the broken roving from the bobbin		3	1	1	1
	PC8. Unwind extra length of roving from the bobbin		4	1	1	1
	PC9. Fix the bobbin in a proper manner in the		4	1	1	1

**Assessment criteria**

spindle and pass the roving through the false twister making it ready for piecing				
PC10. Use blow horn to pass the rove end in flyer	3	1	1	0
PC11. Piece the roving between false twister and drafting zone by standard piecing techniques	3	2	2	1
PC12. Ensure minimum time is taken for piecing the rove	4	1	1	1
PC13. Ensure in proper material handling of roving and roving bobbin	4	1	2	1
PC14. Ensure surface of roving doesn't gets damaged	4	1	2	1
PC15. Ensure to avoid usage of damaged or defective bobbins	3	1	1	1
PC16. Ensure the quality of piecing is as per standard	4	1	2	1
PC17. Ensure the tension of the pieced roving is proper	4	1	2	1
PC18. Ensure the bobbin is perfectly fitted in the spindle	4	1	2	1
PC19. Verify proper material passage from drafting zone till the roving wound on bobbin	3	1	2	1
PC20. Run machine and check	2	0	2	0
PC21. Remove the sliver waste and roving waste and deposit in the respective waste collection bags	2	1	1	1
PC22. Ensure proper	4	0	2	1

**Assessment criteria**

	functioning of the machine					
	PC23. Ensure and maintain colour code		4	1	2	1
	<b>Total</b>		<b>75</b>	<b>20</b>	<b>35</b>	<b>20</b>
	<b>Weightage %</b>			27%	47%	27%
<b>4 . TSC/N 0119(Preparing for doffing)</b>						
	PC1. Follow the plan as instructed by superior for performing doffing activities at various machines in speed frame department	<b>75</b>	5	1	1	3
	PC2. Identify which machine in speed frame departments is ready for doffing		5	1	2	2
	PC3. Identify the empty bobbin required for next doff and segregate it size wise, count wise and type wise		4	1	2	1
	PC4. Ensure the bobbins are clean, clean the empty bobbins if needed		4	1	2	1
	PC5. Ensure the empty bobbins in good condition		4	1	2	1
	PC6. Remove the damaged bobbins and store in a separate place		5	2	2	1
	PC7. Ensure correct sized and colour coded empty bobbin is to be loaded in the bobbin trolley		4	1	2	1
	PC8. Ensure proper material handling of empty bobbin		4	1	2	1
	PC9. Load the empty bobbins in the bobbin trolley in an organised		5	1	3	1

**Assessment criteria**

manner					
PC10. Load the required number of empty bobbins as per requirement in different bobbin trolleys		5	2	2	1
PC11. Move and arrange the bobbin trolleys in an organised manner near the speed frame machine		5	1	3	1
PC12. Ensure minimum time is taken out for carrying the activities		4	1	2	1
PC13. Support the tenter in bringing the new sliver cans from the draw frame department to the speed frame creeling zone		4	1	2	1
PC14. ensure correct sliver can is taken from the draw frame department		4	1	2	1
PC15. Arrange the sliver cans in an organised manner near the creel zone		4	1	2	1
PC16. Distribute the existing slivers without waste to sliver cans at the time of starting new count or run out or any other time as required		4	1	2	1
PC17. Ensure proper material handling of sliver and sliver can		5	2	2	1
<b>Total</b>		<b>75</b>	<b>20</b>	<b>35</b>	<b>20</b>
	<b>Weightage %</b>		27%	47%	27%

**Assessment criteria**

<b>5 . TSC/N 0120(Carryout doffing activity)</b>	PC1. Transport the empty bobbin trolley to the front part of speed frame machine	<b>50</b>	3	1	1	1
	PC2. Arrange the empty bobbin trolley in an organized manner		4	1	2	1
	PC3. Stop the machine		2	0	2	0
	PC4. Ensure the machine is completely stopped and open the safety door		4	1	2	1
	PC5. Remove the fully bobbin from spindle and store in the bobbin trolley		4	1	2	1
	PC6. Fix the empty bobbin in the spindle		4	1	2	1
	PC7. Repeat the doffing activity for specified number of spindles as instructed by his / her superior		4	1	2	1
	PC8. Gait the roving end with the empty bobbin		4	1	2	1
	PC9. Ensure proper material handling of roving and full bobbin		4	1	2	1
	PC10. Ensure minimum time is taken for carrying out doffing activity		4	1	2	1
	PC11. Ensure all the full bobbins are replaced with empty bobbins		6	2	2	2
	PC12. Ensure gaiting is done for all the spindles in a proper manner		4	1	2	1
	PC13. Ensure all the full bobbins are placed in the bobbin trolley		3	1	1	1
	<b>Total</b>		<b>50</b>	<b>13</b>	<b>24</b>	<b>13</b>
	<b>Weightage %</b>		26%	48%	26%	



**Assessment criteria**

<b>6 . TSC/N 0121 (Tenting responsibility)</b>	PC1. Ensure the doffing is carried out in a proper manner	<b>100</b>	5	1	1	3
	PC2. Ensure the delivery zone is clean		5	1	2	2
	PC3. Support the tenter by bringing draw frame can for creeling, creeling activities and piecing in the event of a count change		5	1	3	1
	PC4. Ensuring the machine is ready to start		4	1	2	1
	PC5. Ensure proper functioning of machine		4	1	2	1
	PC6. Report to the supervisor / maintenance team if the machine is not functioning properly		6	1	2	3
	PC7. Ensure proper transportation of filled bobbin trolley		4	1	2	1
	PC8. Ensure count wise storage of filled roving bobbin in storage area		5	1	2	2
	PC9. Ensure proper material handling of roving bobbin		4	1	2	1
	PC10. Ensure material is covered post doffing		5	2	2	1
	PC11. Ensure in keeping the empty bobbins clean and arranged in proper manner		4	1	2	1
	PC12. Clean the defective roving bobbins in the respective shift		6	1	3	2
	PC13. Segregate the sliver waste and roving waste count wise and store in the respective		6	2	3	1

**Assessment criteria**

	waste bins						
	PC14. Weigh the different types of waste collected in the speed frame departments		5	2	2	1	
	PC15. Transport the collected wastes to the waste room		4	1	2	1	
	PC16. Support tenter in carrying out tenting activities then and there as instructed by supervisor		4	1	2	1	
	PC17. Support the maintenance team while machine is under maintenance		5	2	2	1	
	PC18. Clean the gear end, off end, spindle rails, spindles, bobbin rail, clearer rollers and other parts of machine as instructed by supervisor using proper cleaning tools		6	2	3	1	
	PC19. Take part doffs wherever necessary as instructed by the supervisor		5	1	3	1	
	PC20. Transport the empty cans to the draw frame can storage area after count change		4	1	2	1	
	PC21. Ensure cleanliness at work place		4	1	2	1	
	<b>Total</b>		<b>100</b>	<b>26</b>	<b>46</b>	<b>28</b>	
		<b>Weightage %</b>		26%	46%	28%	
<b>7. TSC/N 0122 (Carry out additional tenting responsibilities)</b>	PC1. Clean the creeling area	<b>100</b>	3	1	1	1	
	PC2. Ensure proper		3	1	1	1	

**Assessment criteria**

effectively)	removal of dusts from the creeling zone				
	PC3. Clean the front and back portion of the machine	4	1	2	1
	PC4. Clean the back portion of the drafting arrangement	4	1	2	1
	PC5. Clean the front portion of drafting arrangement	4	1	2	1
	PC6. Ensure proper cleaning of drafting zone	4	1	2	1
	PC7. Clean the flyer, bobbin rail and spindle rail	4	1	2	1
	PC8. Collect the wastes in the waste collection chamber and depositing in the waste collection box	4	1	2	1
	PC9. Clean the waste collection chamber	4	1	2	1
	PC10. Ensure the wastes collected from different parts of machine are deposited in the respective dustbins.	5	2	2	2
	PC11. Clean the alley around the speed frame machine using proper cleaning equipments	4	1	1	1
	PC12. Ensure the speed frame department is neat and clean	4	1	2	1
	PC13. Ensure proper functioning of machine	4	1	2	1
	PC14. Check and verify the quality of different machine parts	4	1	2	0
	PC15. Remove the worn out parts and replace with new parts in speed frame machine	4	1	2	2

**Assessment criteria**

PC16. Carry out preventive maintenance activities at the specified intervals		5	1	2	1
PC17. Oil the different parts of speed frame machine		4	1	2	2
PC18. Verify the proper build of the roving bobbin		4	1	1	1
PC19. Support the doffer while carrying out doffing activities		4	1	2	1
PC20. Record the production details in the production report		4	1	2	1
PC21. Report to the supervisor in case of emergency stoppage of machine		4	1	2	2
PC22. Report to the supervisor and maintenance incharge if the operator was able to replace the worn out machine part with a new one.		4	1	2	1
PC23. Support the maintenance team while machine is under maintenance		4	1	2	1
PC24. Ensure all details related to production are provided the next shift operator while relieving		4	1	2	1
PC25. Ensure count wise storage of wound bobbin without damaging the roving		4	1	2	1
<b>Total</b>		<b>100</b>	<b>26</b>	<b>46</b>	<b>28</b>
	<b>Weightage %</b>		26%	46%	28%

**Assessment criteria**

<b>8.TSC/N9001(Maintaining work area, tools and machines)</b>	PC1. handle materials, machinery, equipment and tools with care and use them in the correct way	<b>50</b>	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

**Assessment criteria**

		<b>Total</b>	<b>50</b>	<b>15</b>	<b>21</b>	<b>14</b>	
		<b>Weightage %</b>		30%	42%	28%	
<b>9.TSC/N9002 (Working in a team)</b>	PC1. be accountable to the own role in whole process	<b>50</b>	4	2	1	1	
	PC2. perform all roles with full responsibility		5	3	1	1	
	PC3. be effective and efficient at workplace		5	1	3	1	
	PC4. properly communicate about company policies		5	2	1	2	
	PC5. report all problems faced during the process		5	1	1	3	
	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		3	1	1	1	
	PC9. give due importance to others' point of view		3	1	1	1	
	PC10. avoid conflicting situations		3	1	1	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	
	<b>Total</b>			<b>50</b>	<b>17</b>	<b>17</b>	<b>16</b>
			<b>Weightage %</b>		34%	34%	32%
<b>10.TSC/N9003 (Maintain health, safety and security at work place)</b>	PC1. comply with health and safety related instructions applicable to the workplace	<b>100</b>	5	2	2	1	

**Assessment criteria**

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 organisational 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

**Assessment criteria**

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 organisation 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. recognise other possible security issues existing in the workplace	4	2	1	1
PC21. recognise 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
<b>Total</b>	<b>100</b>	<b>43</b>	<b>34</b>	<b>23</b>
<b>Weightage</b>		43%	34%	23%



**Assessment criteria**

		%				
<b>11.TSC/N9004 (Comply with industry and organizational requirements)</b>	PC1. perform own duties effectively	<b>50</b>	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 organisational 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 organisation standards		4	2	1	1
	<b>Total</b>		<b>50</b>	<b>18</b>	<b>19</b>	<b>13</b>
	<b>Weihtage %</b>		36%	38%	26%	
<b>Grand Total</b>			<b>850</b>			