

## QUALIFICATIONS PACK - OCCUPATIONAL STANDARDS FOR TEXTILE SECTOR

### What are Occupational Standards(OS)?

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

#### Contact Us:

Textile SSC

E-mail: [info@texskill.in](mailto:info@texskill.in)



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### Introduction

## Qualifications Pack – Warper - Direct Warping Machine

**SECTOR: TEXTILE**

**SUB-SECTOR: WEAVING**

**OCCUPATION: WEAVING PREPARATORY**

**REFERENCE ID: TSC/Q 2101**

**ALIGNED TO: NCO-2004 / 8262.81**

**Brief Job Description:** A Warper is a job-role in a weaving preparatory department. The responsibility of a Warper is to run the Warping Machine efficiently so as to get maximum output with minimum defects giving due importance to safety and environment aspects.

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

<b>Job Details</b>	<b>Qualifications Pack Code</b>	<b>TSC/Q 2101</b>		
	<b>Job Role</b>	<b>Warper – Direct Warping Machine</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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
	<b>Occupation</b>	<b>Weaving Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>
<b>Job Role</b>	<b>Warper – Direct Warping Machine</b>			
<b>Role Description</b>	To run a Warping Machine efficiently so as to get maximum output with minimum defects, giving due importance to safety & environmental aspects			
<b>NSQF level</b>	4			
<b>Minimum Educational Qualifications</b>	Preferably 8 <sup>th</sup> standard			
<b>Maximum Educational Qualifications</b>	N/A			
<b>Training</b> (Suggested but not mandatory)	Preferably training in weaving preparatory department.			
<b>Experience</b>	Not essential			
<b>National Occupational Standards (NOS)</b>	<p><b>Compulsory:</b></p> <ol style="list-style-type: none"> <li><a href="#">TSC/ N2101 Taking charge of shift and handing over shift to operator</a></li> <li><a href="#">TSC/ N2102 Operating a Warping Machine</a></li> <li><a href="#">TSC/ N2103 Piecing the broken yarn</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> N/A</p>			
<b>Performance Criteria</b>	As described in the relevant OS units			

## Glossary of Key Terms

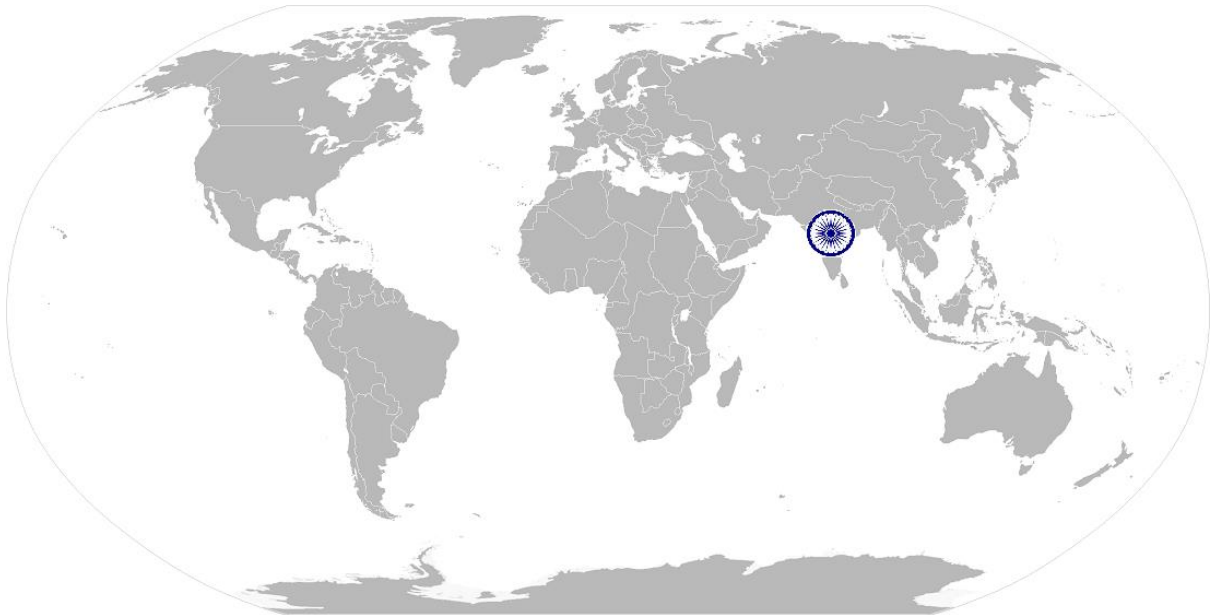
Table 1: Glossary of Key Terms

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

Description	Description gives a short summary of the unit content. This would be helpful to anyone searching on a database to verify that this is the appropriate OS they are looking for.
Scope	Scope is the set of statements specifying the range of variables that an individual may have to deal with in carrying out the function which have a critical impact on the quality of performance required.
Knowledge and Understanding	Knowledge and Understanding are statements which together specify the technical, generic, professional and organizational specific knowledge that an individual needs in order to perform to the required standard.
Organizational Context	Organizational Context includes the way the organization is structured and how it operates, including the extent of operative knowledge managers have of their relevant areas of responsibility.
Technical Knowledge	Technical Knowledge is the specific knowledge needed to accomplish specific designated responsibilities.
Core Skills/Generic Skills	Core Skills or Generic Skills are a group of skills that are key to learning and working in today's world. These skills are typically needed in any work environment. In the context of the OS , these include communication related skills that are applicable to most job roles.
<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/ N2101**

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

<b>Unit Code</b>	<b>TSC/ N 2101</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>	<p><b>This unit/task covers the following:</b></p> <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>
Taking charge of shift	<p>To be competent, the user/individual on the job must be able to:</p> <p>PC1. come at least 10 - 15 minutes earlier to the work spot</p> <p>PC2. check for the necessary items like " chalk", " pen", " knife" etc.</p> <p>PC3. meet the previous shift warper , 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. check the condition of the running beams , machine, performance of the yarn running for the running program</p> <p>PC5. check whether all the stop motions work in good condition</p> <p>PC6. take " job cards" for the next programs, from the higher authority.</p> <p>PC7. check availability of the cones/ cheeses &amp; empty warping beams required for the next programs .</p> <p>PC8. check the cleanliness of the machines &amp; other work areas .</p> <p>PC9. check whether any spare/raw material/ tool /any other material are thrown under the machines or in the other work areas.</p> <p>PC10. ask question to the previous shift warper for any deviation in the above and bring the same to the knowledge of his/ her shift superior as well that of the previous shift as well.</p>
Handing over the Shift	<p>PC11. hand over the shift to the incoming warper in a proper manner &amp; get clearance from the incoming counterpart before leaving the work spot.</p> <p>PC12. report to his/ her shift superiors as well as that of the incoming shift, in case his/ her counterpart doesn't come for work for the incoming shift. in that case, the shift has to be properly handed over to the incoming shift superior &amp; get clearance from him/ her, before leaving the work spot.</p> <p>PC13. 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>
<b>Knowledge and Understanding (K)</b>	
<b>A. Organizational Context</b> (Knowledge of the company/ organization and its processes)	<p>The individual on the job needs to know and understand:</p> <p>KA1. the organization's policies &amp; procedures</p> <p>KA2. awareness, knowledge of customers</p> <p>KA3. potential hazards associated with the machines and the safety precautions must be taken</p> <p>KA4. protocol to obtain more information on work related tasks</p> <p>KA5. contact Person in case of queries on procedure or products and for revolving</p>



**TSC/ N2101**

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

	<p>issues related to defective machines, tools, materials &amp; equipments</p> <p>KA6. details of the various job rolls &amp; responsibilities.</p> <p>KA7. documentation and reporting formats.</p> <p>KA8. work targets &amp; review machine with superiors</p> <p>KA9. protocol and format for reporting work related risks/ problems</p> <p>KA10. method of obtaining /giving feed back with respect to performance</p> <p>KA11. importance of team work .harmonious working relationships</p> <p>KA12. process for offering /obtaining work related assistance</p> <p>KA13. responsibilities under health, safety and environmental legislation</p> <p>KA14. guidelines for storage &amp; disposal of waste materials</p>
<p><b>B. Technical Knowledge</b></p>	<p>The user/individual on the job needs to know and understand:</p> <p>KB1. Minimum quality requirements of the product with respect to permissible/non-permissible defects</p> <p>KB2. Beam quality particulars such as Count, Ends etc.</p> <p>KB3. Yarns from natural fibers - Cotton, Silk, Wool</p> <p>KB4. Importance of mixing, count change</p> <p>KB5. Yarns from Manmade Fibers - Polyester, Nylon, Viscose</p> <p>KB6. Blended yarns - Polyester Cotton, Polyester Viscose</p> <p>KB7. Hand Warp Reel</p> <p>KB8. Conventional Warping Machine</p> <p>KB9. Modern Direct Warping Machines</p> <p>KB10. Sectional Warping Machines</p> <p>KB11. Tappet loom/ Cam Loom/ Crank Loom , Dobby Loom, Jacquard Loom</p> <p>KB12. Shade Variation</p> <p>KB13. Count Mix- Up</p> <p>KB14. Color contamination</p> <p>KB15. Material Contamination</p> <p>KB16. Uneven Winding</p> <p>KB17. Ends Migration</p> <p>KB18. Improper Mending Of Broken Ends</p> <p>KB19. Improper Beam Ends</p> <p>KB20. Tension variation in warping Beams</p> <p>KB21. Oil Warp</p> <p>KB22. Stain Warp</p> <p>KB23. the safety mechanisms of the machines &amp; should ensure that the same are in order.</p> <p>KB24. the stop motions &amp; should ensure that the same are in order.</p> <p>KB25. the indication lamps &amp; should ensure that the same are in order.</p> <p>KB26. the functional operations of the machines, where He/ She is working.</p>
<p><b>Skills (S)</b></p>	
<p><b>A. Core Skills/ Generic Skills</b></p>	<p><b>Writing Skills</b></p> <p>You need to know and understand how to:</p> <p>SA1. write clear and short sentences</p>

**TSC/ N2101**

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

	<p>SA2. plan and manage work routine based on instructions from supervisor</p> <p><b>Reading Skills</b></p> <p>You need to know and understand how to:</p> <p>SA3. comprehend written instructions</p> <p><b>Oral Communication (Listening and Speaking skills)</b></p> <p>You need to know and understand how to:</p> <p>SA4. communicate with supervisor appropriately</p> <p>SA5. talk to others to convey information effectively</p>
<b>B. Professional Skills</b>	<p><b>Problem Solving</b></p> <p>You need to know and understand how to:</p> <p>SB1. apply problem-solving approaches in different situations</p> <p>SB2. refer anomalies to the supervisor</p> <p>SB3. seek clarification on problems from others</p> <p>SB4. participate in the various programs/ meetings that will be conducted by the Superiors</p> <p>SB5. put forth the suggestions in the interest of the Company</p> <p>SB6. participate in the " Quality Circles" that will be formed by the Superiors</p> <p>SB7. extend voluntary supports and adapt to the various procedures that will be adopted by the Company with respect to compliances for the different certifications like " ISO 9001", " ISO 14001", SA 8001" GOTS Certification " Fair Trade " etc.</p> <p><b>Attention to Detail</b></p> <p>You need to know and understand how to:</p> <p>SB1. apply good attention to detail</p> <p>SB2. check your work is complete and free from errors</p>
<b>C. Technical Skills</b>	<p>You need to know and understand how to:</p> <p>SC1. find " Warping Creel Capacity</p> <p>SC2. produce warping beams free from " Shade variation" " Count Mix-Up".</p>

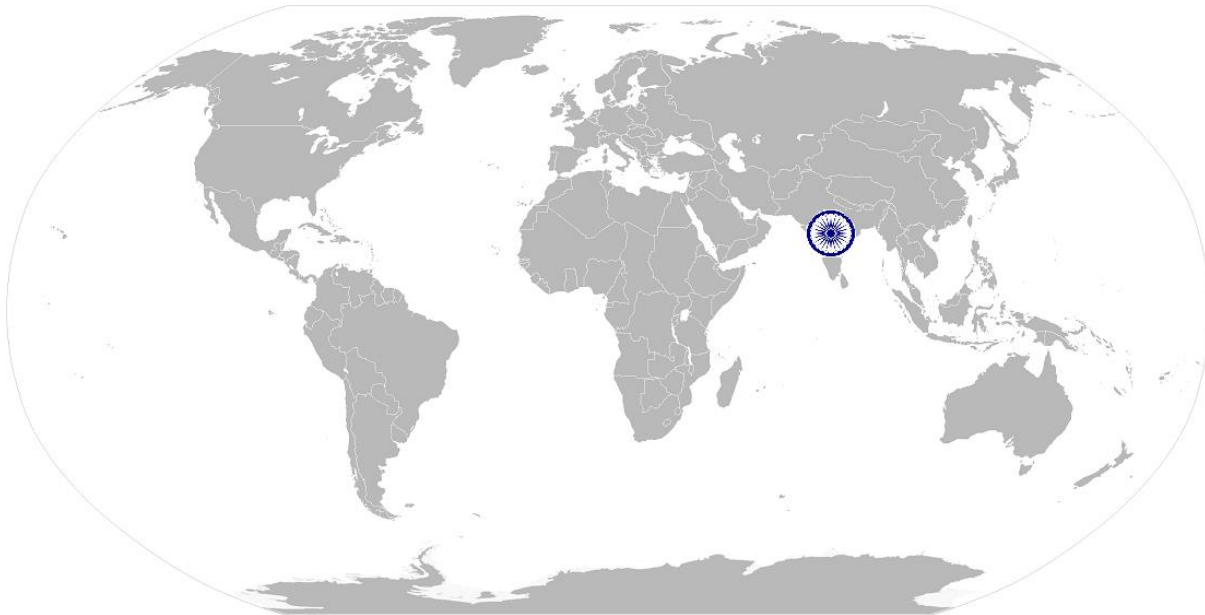


**TSC/ N2101**

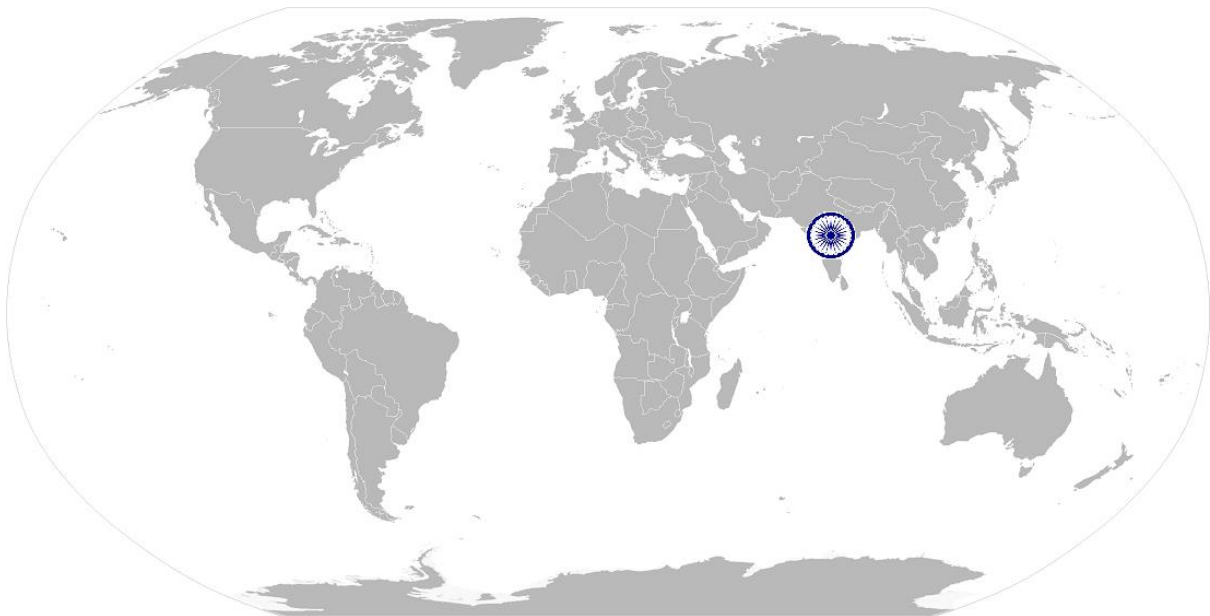
**Taking charge of shift and handing over shift to operator**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/ N 2101</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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Weaving Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



# National Occupational Standard



## Overview

This unit provides performance criteria ,knowledge & understanding and skills & abilities required to run a warping machine, by attending to warp breakages, so as to get maximum output & minimum defects, without entertaining any damage to the people , the machine etc., , without wasting much of raw materials, spares, tools etc., & without spoiling the environmental aspects.

TSC/ N2102

Operating a Warping Machine

<b>Unit Code</b>	TSC/ N2102
<b>Unit Title (Task)</b>	<b>Operating a Warping Machine</b>
<b>Description</b>	This unit provides performance criteria ,knowledge & understanding and skills & abilities required to run a warping machine , by attending to warp breakages, so as to get maximum output & minimum defects, without entertaining any damage to the people , the machine etc., , without wasting much of raw materials, spares, tools etc., & without spoiling the environmental aspects.
<b>Scope</b>	<p><b>This unit/task covers the following:</b></p> <ul style="list-style-type: none"> <li>▪ Warper’s Knot</li> <li>▪ Attending to Warp Break</li> <li>▪ Creeling of cones/cheeses in the warping creel</li> <li>▪ Running of warping machine</li> <li>▪ Doffing of warped beams</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
Warper's Knot	To be competent, you must be able to: PC1. make tiny & firm warper's knots
Attending to Warp Break	PC2. take straight the broken end in the warping beam . PC3. knot the broken end in the warping beam with the broken end in the creel, using tiny & firm warper knot by hand or by the knotting machine provided. PC4. leave straight the mended warp yarn in the beam and the machine has to be allowed to be run in slow speed for some time, before the machine is allowed to run in the speed prescribed. PC5. record the warping breakages details in the “yarn performance book” kept.
Creeling Of Cones/ Cheeses in the Warping Creel	PC6. remove the run out cones/ cheeses of the previous program. PC7. collect the removed cones/cheeses in trolleys/ bags provided. PC8. pack the said collected cones/ cheeses as per the instructions given PC9. write the following details on the packed bags <ul style="list-style-type: none"> <li>a) Count details</li> <li>b) Mill Name</li> <li>c) Warping Set No.</li> <li>d) No. Of Cones</li> <li>e) Gross wt. in kgs</li> <li>f) Net Wt. in Kgs</li> </ul> PC10. clean the warping creel area & the warping machine thoroughly PC11. bring the yarn bags required for the next program and keep the same at the centre of the warping creel PC12. bring the empty trolleys provided to store empty polythene cone covers. cone inserts and keep the same at the centre of the warping creel PC13. remove the polythene cone bags, cone inserts etc., & to store the same in the respective trolleys provided PC14. creel the cones/ cheeses in the creel stand PC15. remove the trolleys wherein the empty polythene covers & cone inserts are collected, from the warping area.

**TSC/ N2102**

**Operating a Warping Machine**

<p><b>Running Of Warping Machine</b></p>	<p>PC16. check the stop motions &amp; to ensure they are in “on” position, before the machine is allowed to run.</p> <p>PC17. check the counter meter</p> <p>PC18. mount the empty warping beam in the machine</p> <p>PC19. set the beam meters in the counter meter</p> <p>PC20. note down the “ beam no”, “ beam ends” “ beam set meters” etc. in the job card , immediately after the loading of the empty warping beam in the machine</p> <p>PC21. switch on the “ warping drum” so as to ensure no deviation between the “ beam set meters” &amp; “ the actual beam meters”</p> <p>PC22. while starting the machine, ensure that the ends in both the edges are coming properly without any overlapping. it has to be corrected using warping comb.</p> <p>PC23. there should not be any “up” &amp; “down” portion in the warping beam, particularly in the edges.</p>
<p><b>Doffing Of Warped Beams</b></p>	<p>PC24. after the completion of the warping beam, as per the set meters, the warped beams have to be doffed.</p> <p>PC25. immediately after the doffing of the warped beams , the following details have to be written on the warped beams using chalk</p> <ol style="list-style-type: none"> <li>Count</li> <li>Warp Set No.</li> <li>Warp Beam No.</li> <li>No. Of Ends</li> <li>Beam Meters</li> </ol>
<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. SOP (Standard Operating Procedures) and regulations in a weaving unit</p> <p>KA2. safe working practices to be adopted in weaving unit</p> <p>KA3. quality systems and other processes practiced in the weaving unit</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 weaving unit</p>
<p><b>B. Technical Knowledge</b></p>	<p>KA6. 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 roving</li> <li>• Roving hank</li> <li>• Importance of roving quality</li> <li>• Types of roving defects</li> <li>• Reasons for roving breakage</li> </ul> <p>KA7. process flow in a weaving unit</p> <p>KA8. material flow in a weaving unit</p> <p>KA9. functions of different parts of ring frame machine</p> <p>KA10. importance of creeling</p>

**TSC/ N2102**

**Operating a Warping Machine**

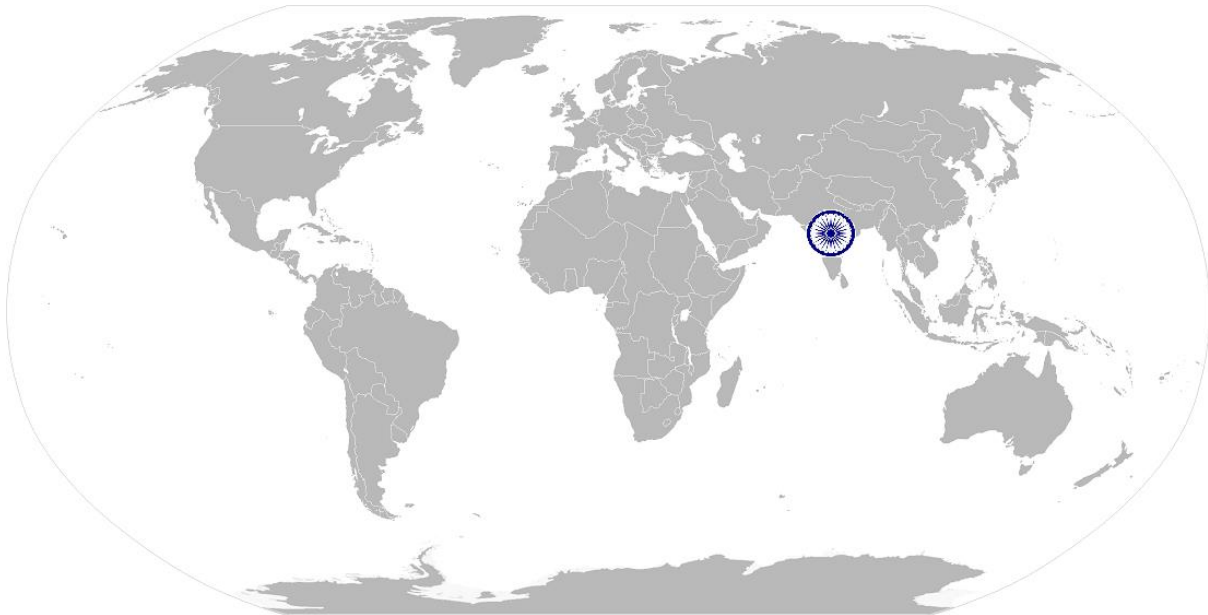
	<p>KA11. importance of colour coding followed for different counts in weaving unit          KA12. tools and equipments used          KA13. knowledge of waste collection system &amp; equipments used          KA14. importance of material handling and types of material handling equipments used          KA15. functions and methodology for operating different material handling equipments          KA16. understanding the functions of different signal lamps          KA17. guidelines for operating the ring frame machine          KA18. safety procedures to be followed in a ring frame machine</p>
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<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>          You need to know and understand how to:          SA2. comprehend written instructions</p> <p><b>Oral Communication (Listening and Speaking skills)</b>          You need to know and understand how to:          SA3. communicate with supervisor appropriately          SA4. talk to others to convey information effectively</p>
<b>B. Professional Skills</b>	<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>          You need to know and understand how to:          SB4. apply good attention to detail          SB5. check your work is complete and free from errors</p>
<b>C. Technical Skills</b>	<p>You need to know and understand how to:          SC1. standard operating procedures to be followed for creeling the roving          SC2. patrol around the ring frame machine and identify roving breakage or bobbin exhaust          SC3. transport the bobbin trolley          SC4. any damaged bobbin noticed should be cleaned and reused          SC5. standard piecing technique adopted for piecing the broken warp          SC6. check the quality of piecing          SC7. procedure for operating different material handling tools and equipments          SC8. maintain neatness at work</p>

**TSC/ N2102**

**Operating a Warping Machine**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/ N2102</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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
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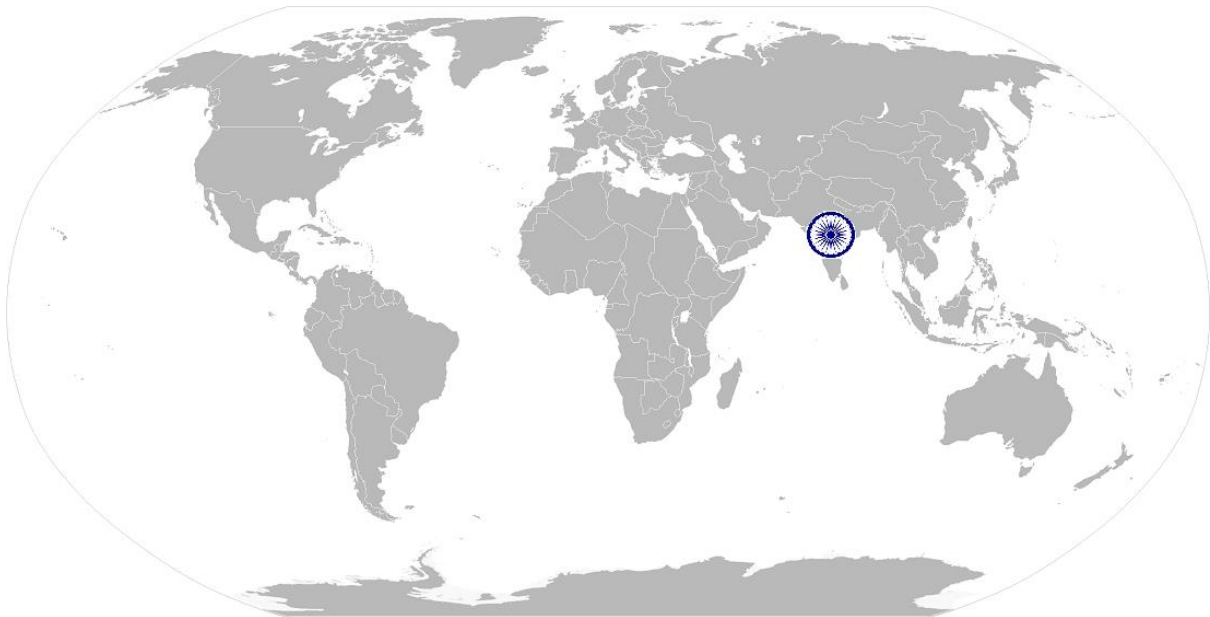




**TSC/ N2103**

**Piecing the broken yarn**

# National Occupational Standard



## Overview

**This unit is about carrying out procedure for piecing the yarn in the event of a yarn breakage**

**TSC/ N2103**

**Piecing the broken yarn**

<b>Unit Code</b>	<b>TSC/N 2103</b>
<b>Unit Title (Task)</b>	<b>Piecing the broken yarn</b>
<b>Description</b>	This unit is about carrying out procedure for piecing the yarn in the event of a yarn breakage
<b>Scope</b>	<p><b>This unit/task covers the following:</b></p> <ul style="list-style-type: none"> <li>▪ identifying yarn breakage</li> <li>▪ Piecing the broken yarn</li> <li>▪ material handling</li> <li>▪ check the quality of pieced yarn</li> </ul>
<b>Performance Criteria (PC) w.r.t. the Scope</b>	
<b>Elements</b>	<b>Performance Criteria</b>
<b>Identifying yarn breakage</b>	<p>To be competent, you must be able to:</p> <p>PC1. patrol around the Warping machine &amp; identify the yarn breakage.</p> <p>PC2. ensure minimum time is taken for attending the yarn breakages</p> <p>PC3. check creel break, traveller fly/ loading, undraft &amp; roller lapping</p> <p>PC4. apply the knee break to stop the spindle</p> <p>PC5. check the quality</p> <p>PC6. ensure proper seating of empties in the spindle after yarn piecing</p> <p>PC7. verify the quality of piecing done in the yarn</p> <p>PC8. attend to the end breakage as and when they occur.</p>
<b>Piecing the broken yarn</b>	<p>PC9. take yarn from cop to feed to start piecing</p> <p>PC10. ensure proper material handling</p> <p>PC11. piece the yarn between false twister and drafting zone by following standard piecing techniques</p> <p>PC12. ensure proper seating of empties in the spindle after yarn piecing</p> <p>PC13. ensure proper traveller running</p> <p>PC14. ensure minimum time is taken for piecing the yarn</p> <p>PC15. ensure the yarn should be pieced with minimum overlapping</p>
<b>Material handling</b>	<p>PC16. put the roving ends and waste in the bags or pockets of coat / apron while attending the end breakages.</p> <p>PC17. ensure proper material handling of yarn and cops</p>
<b>Check the quality of pieced yarn</b>	<p>PC18. ensure the quality of piecing is as per standard</p> <p>PC19. ensure the tension of the pieced yarn is proper</p> <p>PC20. ensure the piecing is perfectly done</p> <p>PC21. verify proper material passage from drafting zone till the yarn wound</p> <p>PC22. remove the yarn waste and deposit in the respective waste collection bags</p> <p>PC23. ensure proper functioning of the machine</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. SOP (Standard Operating Procedures) and regulations in a weaving unit</p> <p>KA2. safe working practices to be adopted in weaving unit</p> <p>KA3. quality systems and other processes practiced in the weaving unit</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 weaving unit</p>

**TSC/ N2103**

**Piecing the broken yarn**

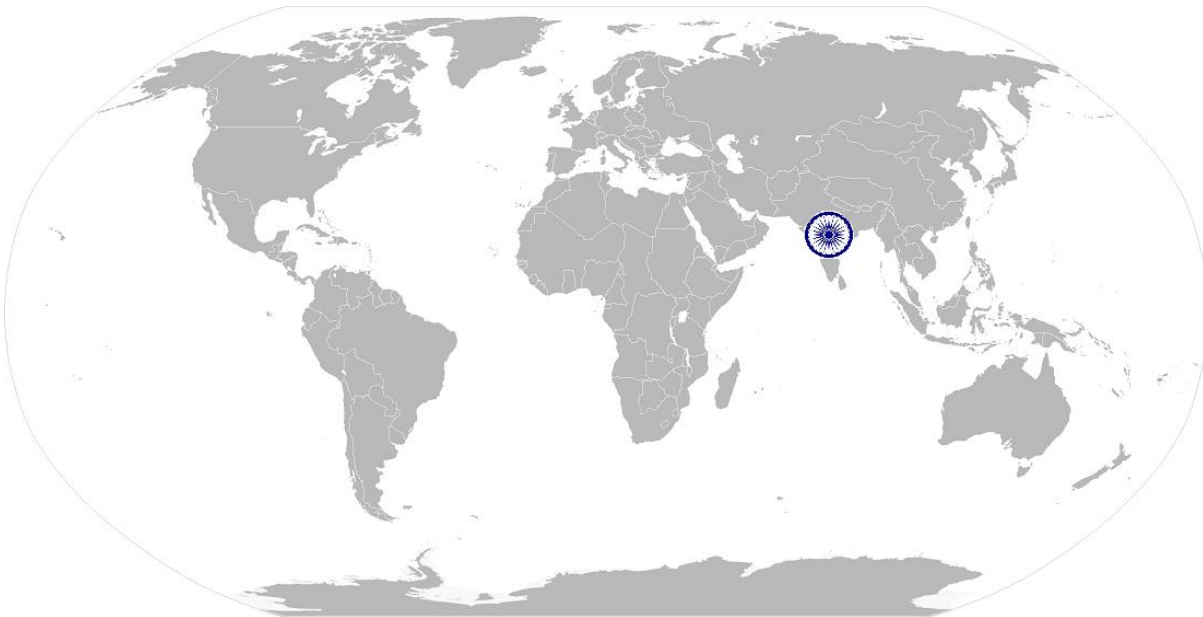
<p><b>B. Technical Knowledge</b></p>	<p>You need to know and understand:</p> <p>KA1. understanding the importance of different types of fibers, roving, roving, yarn, hank and count.</p> <p>KA2. understand the types of roving defects and reason for roving breakage</p> <p>KA3. process and material flow in a weaving unit</p> <p>KA4. functions of different parts of a ring frame machine</p> <p>KA5. importance of piecing</p> <p>KA6. tools and equipments used for piecing</p> <p>KA7. knowledge of waste collection system &amp; material handling equipments used</p> <p>KA8. functions of different signal lamps and control buttons</p> <p>KA9. guidelines for operating the ring frame machine</p> <p>KA10. safety procedures to be followed in a Ring frame machine</p>
<p><b>Skills (S)</b></p>	
<p><b>A. Core Skills/ Generic Skills</b></p>	<p><b>Writing Skills</b></p> <p>You need to know and understand how to:</p> <p>SA1. Write clear &amp; short sentences</p> <p><b>Reading Skills</b></p> <p>You need to know and understand how to:</p> <p>SA2. comprehend written instructions.</p> <p><b>Oral Communication (Listening and Speaking skills)</b></p> <p>You need to know and understand how to:</p> <p>SA3. communicate with supervisor appropriately</p> <p>SA4. talk to others to convey information effectively</p>
<p><b>B. Technical Skills</b></p>	<p>You need to know and understand :</p> <p>SC1. patrolling procedure to attend the end breaks without delay</p> <p>SC2. procedure for finding the broken yarn</p> <p>SC3. standard piecing technique for piecing the broken yarn</p> <p>SC4. check the quality of piecing</p> <p>SC5. maintain neatness at work</p> <p>SC6. procedure to deposit the waste.</p>

**TSC/ N2103**

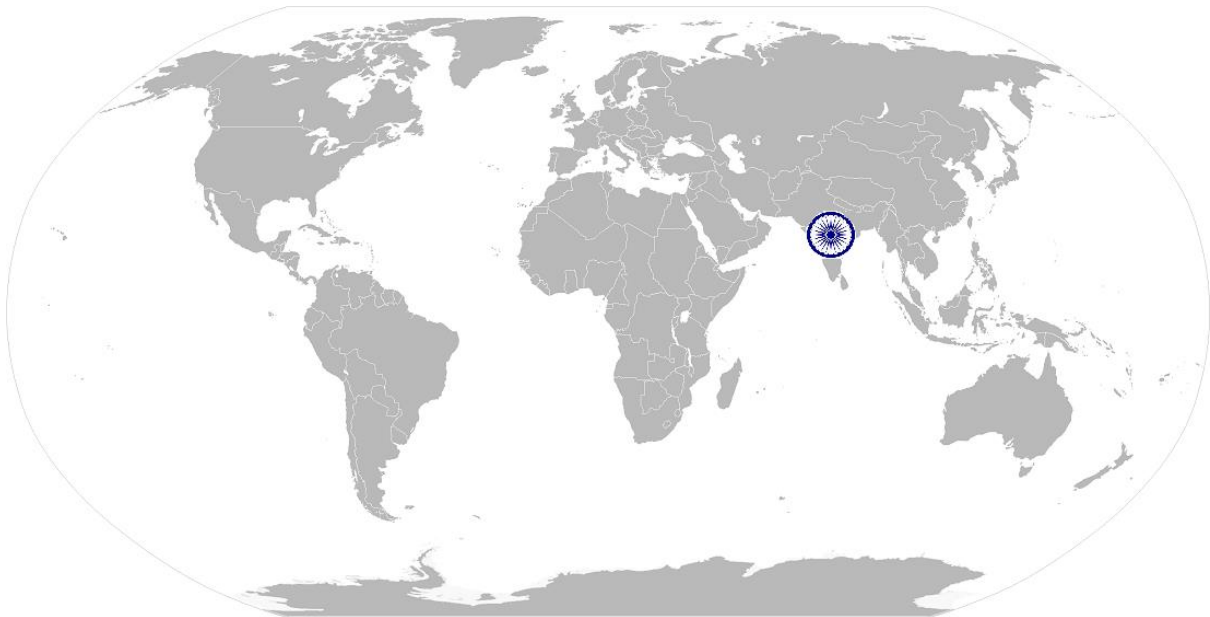
**Piecing the broken yarn**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/N 2103</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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Weaving Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



# National Occupational Standard



## Overview

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

**TSC/ N9001**

**Maintaining work area, tools and machine**

<b>Unit Code</b>	<b>TSC/ N9001</b>
<b>Unit Title (Task)</b>	<b>Maintaining work area, tools and machines</b>
<b>Description</b>	This unit provides performance criteria, knowledge & understanding and skills & abilities required to organize/ maintain work areas and activities to ensure tools and machines are maintained as per norms
<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. safe working practices and organizational procedures</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 organization'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</b>	<p>You need to know and understand:</p> <p>KB1. work instructions and specifications and interpret them accurately</p>



**TSC/ N9001**

**Maintaining work area, tools and machine**

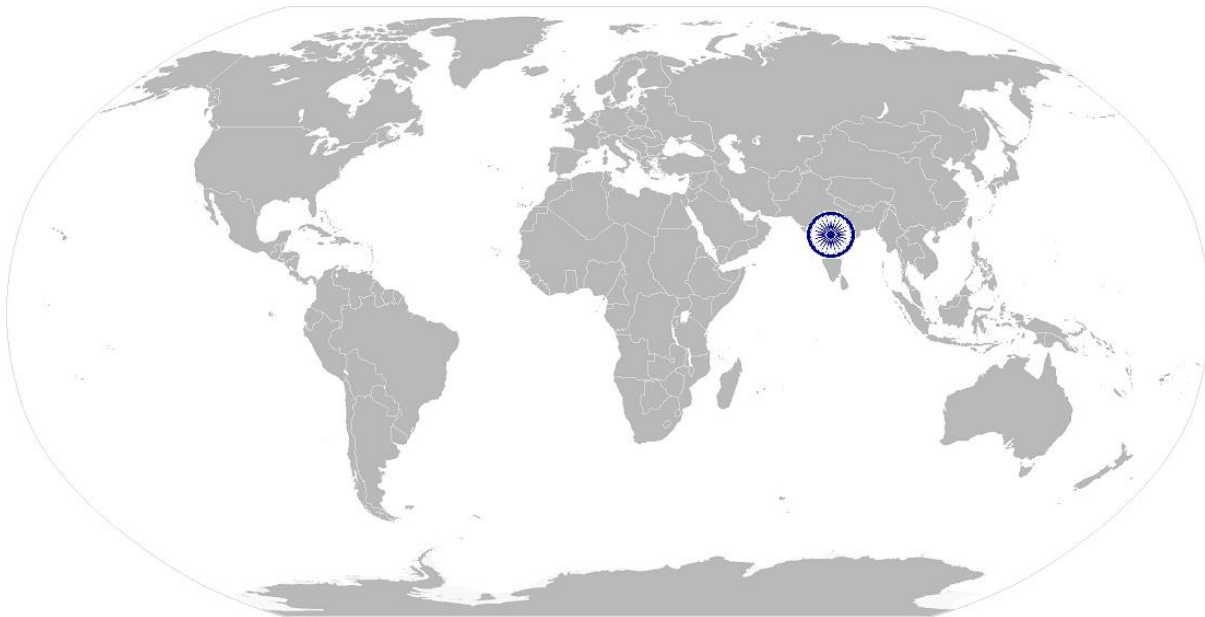
<b>Knowledge</b>	KB2. relation between work role and the overall manufacturing process KB3. hazards likely to be encountered when conducting routine maintenance KB4. the importance of taking action when problems are identified KB5. different ways of minimizing waste KB6. the importance of running maintenance and regular cleaning KB7. effects of contamination on products i.e. machine oil, dirt, foreign materials KB8. common faults with equipment and the method to rectify KB9. maintenance procedures KB10. different types of cleaning equipment and substances and their use KB11. safe working practices for cleaning and the method of carrying them out
<b>Skills (S)</b>	
<b>A. Core Skills/ Generic Skills</b>	<b>Writing Skills</b>
	SA1. write clear and short sentences
	<b>Reading Skills</b>
	You need to know and understand how to: SA2. comprehend written instructions SA3. read any application sent by other colleagues
	<b>Oral Communication (Listening and Speaking skills)</b>
<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. apply problem-solving approaches in different situations SB3. refer anomalies to the supervisor SB4. seek clarification on problems from others
	<b>Attention to Detail</b>
	You need to know and understand how to: SB5. apply good attention to detail SB6. check your work is complete and free from errors SB7. make sure every kind of communication is error free
	<b>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**

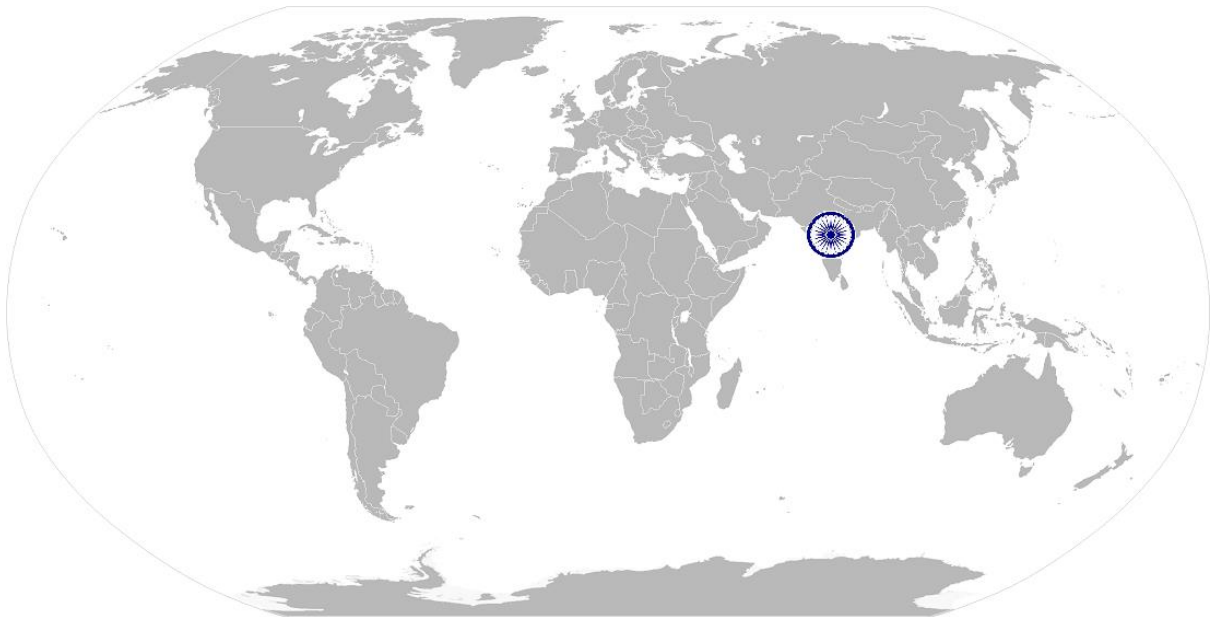
**Maintaining work area, tools and machine**

**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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Weaving 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. SOP (Standard Operating Procedures) 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: SC1. communicate effectively SC2. apply leadership skills wherever required SC3. take initiative at the right place SC4. understand the requirement to be creative

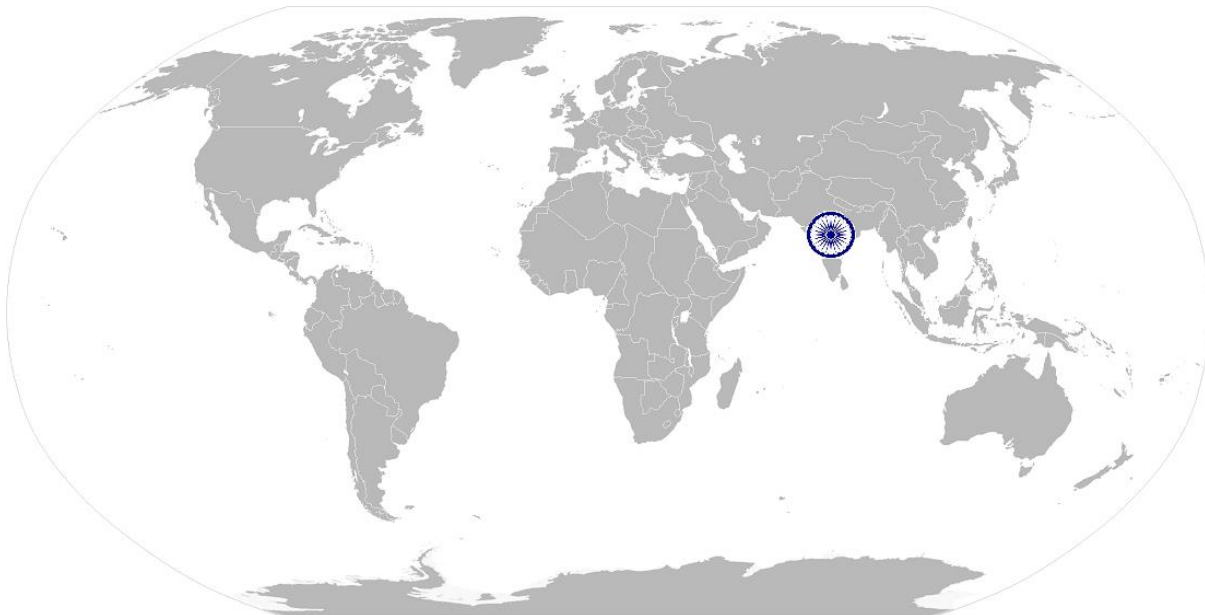


**TSC/ N9002**

**Working in a team**

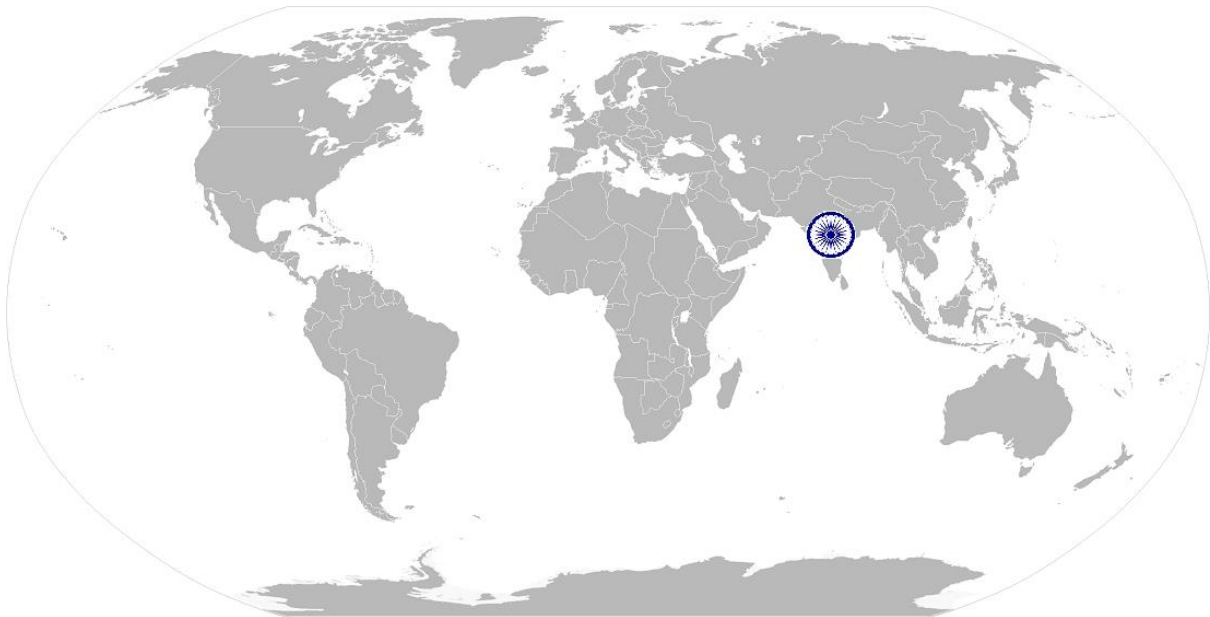
**NOS Version Control**

<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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Weaving 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**

<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>	This unit/task covers the following: <ul style="list-style-type: none"> <li>▪ to recognize hazards</li> <li>▪ to plan safety techniques</li> <li>▪ to implement programs</li> <li>▪ to audit workplace</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

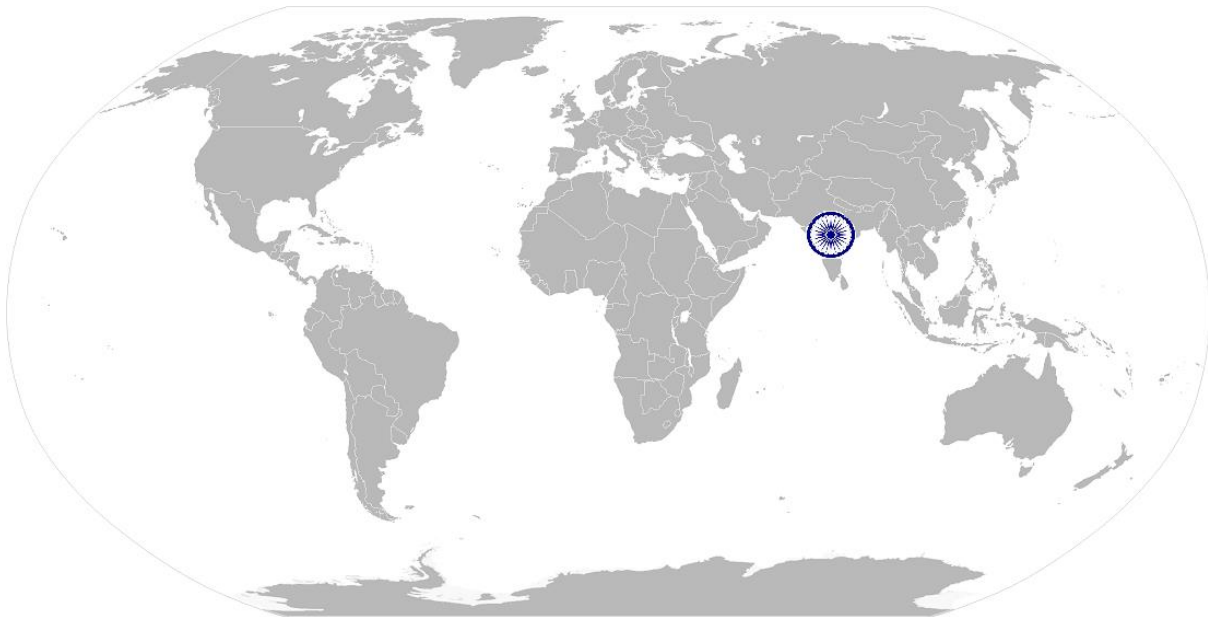
**TSC/ N9003 Maintain health, safety and security at work place**

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. SOP (Standard Operating Procedures) and regulations in a textile mill KA2. safe working practices to be adopted in textile mill KA3. quality systems and other processes practiced in the textile mill KA4. health and safety related practices applicable at the workplace KA5. potential hazards, risks and threats based on nature of operations KA6. organizational procedures for safe handling of equipment and machine operations KA7. potential risks due to own actions and methods to minimize these KA8. environmental management system related procedures at the workplace KA9. layout of the plant and details of emergency exits, escape routes, emergency equipment and assembly points KA10. potential accidents and emergencies and response to these scenarios KA11. reporting protocol and documentation required KA12. details of personnel trained in first aid, fire-fighting and emergency response KA13. actions to take in the event of a mock drills/ evacuation procedures or actual accident, emergency or fire
<b>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>
	SA2. comprehend written instructions
	<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>
	SB1. identify correct safety measure for particular hazard SB2. make required safety plans as and when required SB3. raise alarm in case of emergency

**TSC/ N9003**

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

	<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 : SC1. maintenance of neatness at work SC2. procedure for reporting unwanted behavior

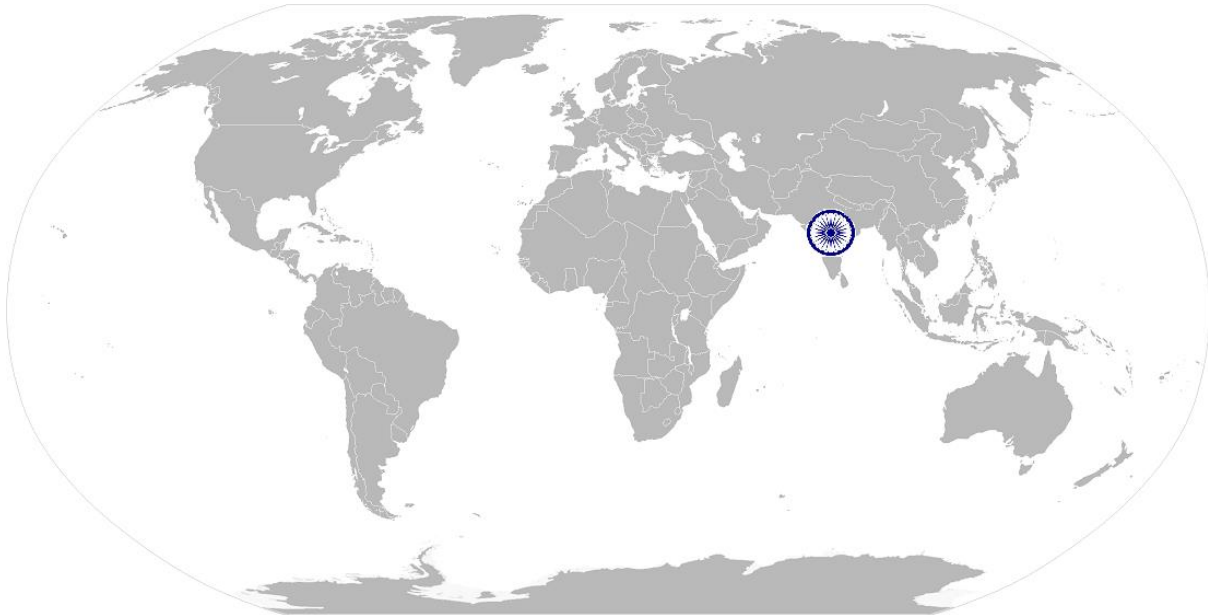


**TSC/ N9003**

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

**NOS Version Control**

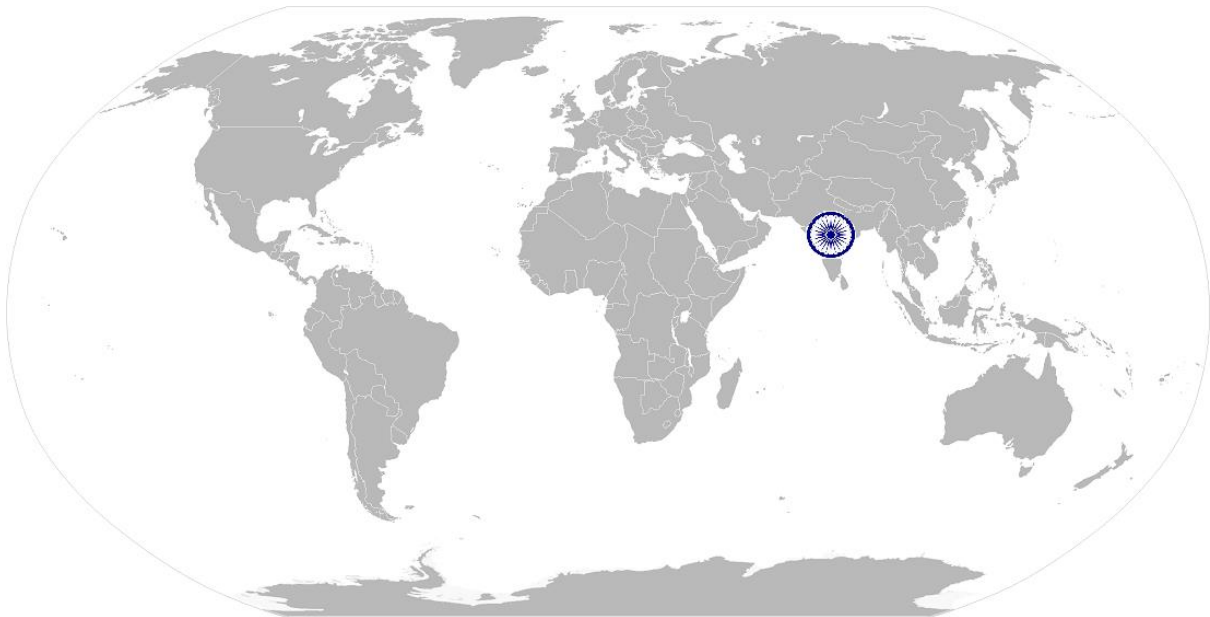
<b>NOS Code</b>	<b>TSC/ N9003</b>		
<b>Credits (NSQF)</b>	<b>TBD</b>	<b>Version number</b>	<b>1.0</b>
<b>Industry</b>	<b>Textile</b>	<b>Drafted on</b>	<b>15/12/14</b>
<b>Industry Sub-sector</b>	<b>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Weaving Preparatory</b>	<b>Next 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**

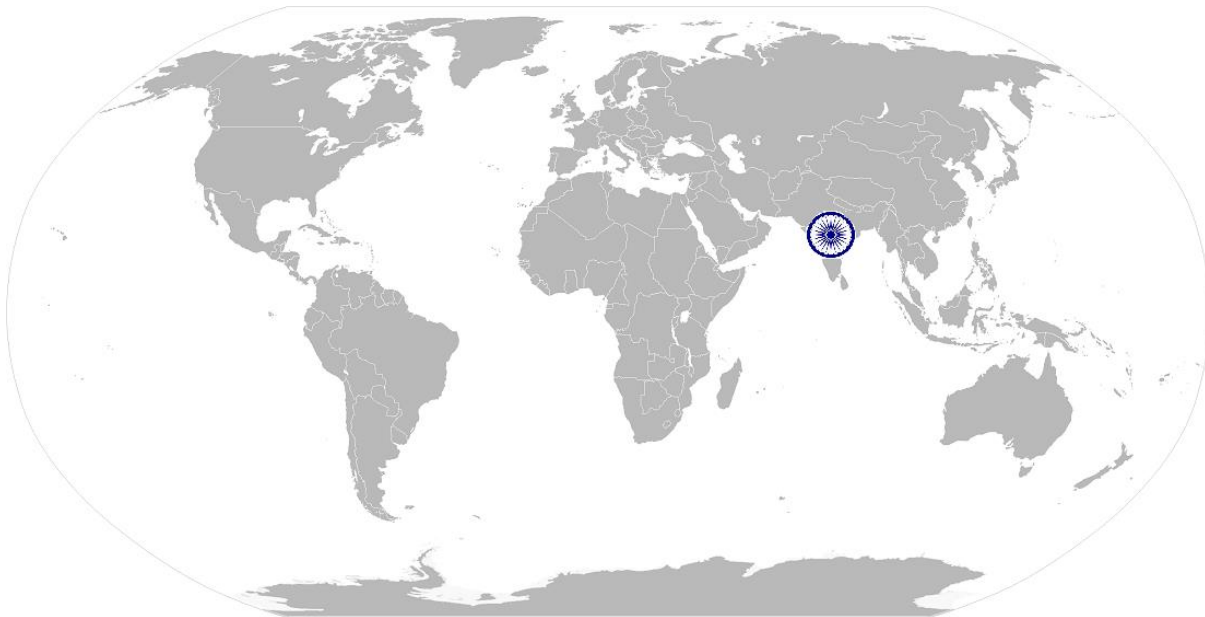
**Comply with industry and organizational requirements**

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>▪ focus on self development</li> <li>▪ focus on team work</li> <li>▪ know and understand organizational standards</li> <li>▪ know and understand industry standards</li> </ul>
	<b>Performance Criteria (PC) w.r.t. the Scope</b>	
	<b>Elements</b>	<b>Performance Criteria</b>
	Self- development	<p>To be competent, you must be able to:</p> <p>PC1. perform own duties effectively</p> <p>PC2. take responsibility for own actions</p> <p>PC3. be accountable towards the job role and assigned duties</p> <p>PC4. take initiative and innovate the existing methods</p> <p>PC5. focus on self-learning and improvement</p>
	Team work	<p>PC6. co-ordinate with all the team members and colleagues</p> <p>PC7. communicate politely</p> <p>PC8. avoid conflicts and miscommunication</p>
	Organizational standards	<p>PC9. know the organisational standards</p> <p>PC10. implement them in your performance</p> <p>PC11. motivate others to follow them</p>
	Industry standards	<p>PC12. know the industry standards</p> <p>PC13. align them with organisation standards</p>
	<b>Knowledge and Understanding (K)</b>	
	<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. SOP (Standard Operating Procedures) and regulations in a textile mill</p> <p>KA2. reporting to the supervisor or higher authority</p> <p>KA3. knowledge of organization standards</p> <p>KA4. knowledge of industry standards</p>
	<p><b>B. Technical Knowledge</b></p>	<p>You need to know and understand:</p> <p>KB1. process and material flow in a textile mill</p> <p>KB2. importance of complying with the standards</p> <p>KB3. guidelines for cleaning the various parts of machine</p>
<b>Skills (S)</b>		
<p><b>A. Core Skills/ Generic Skills</b></p>	<p><b>Writing Skills</b></p> <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. comprehend written instructions
	<b>Oral Communication (Listening and Speaking skills)</b>
	SA3. talk effectively with others SA4. put forward your point SA5. listen to others
<b>B. Technical skills</b>	you need to know and understand : SC1. Organizational requirements SC2. your responsibilities at the workplace SC3. procedure to comply with the industry standards

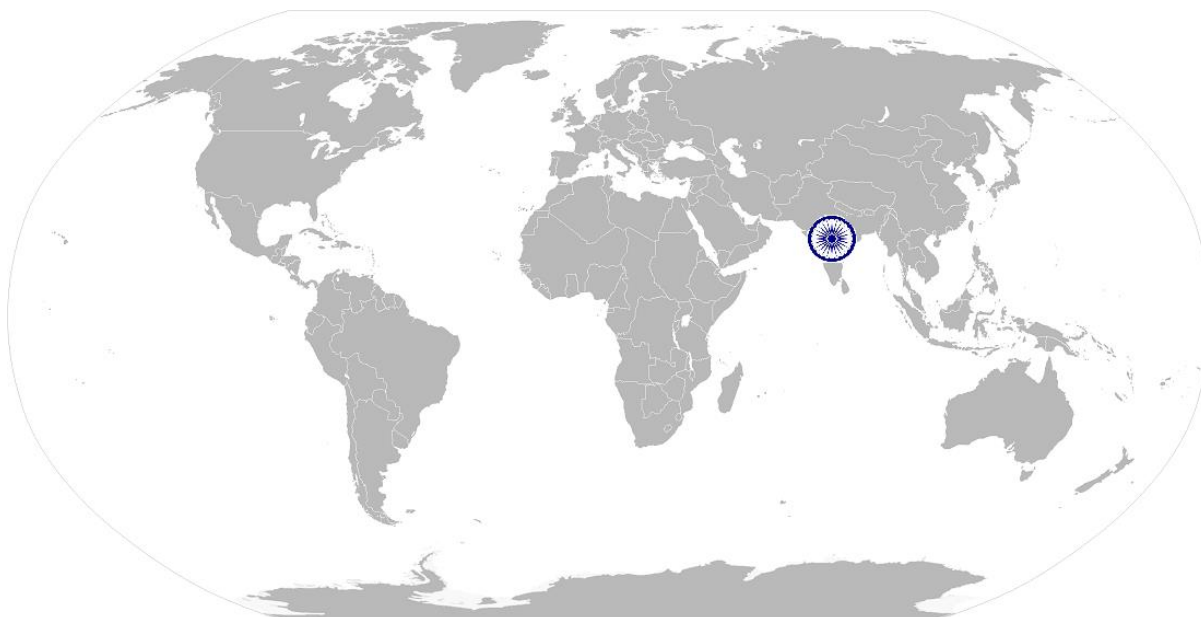


**TSC/ N9004**

**Comply with industry and organizational requirements**

**NOS Version Control**

<b>NOS Code</b>	<b>TSC/N 9004</b>		
<b>Credits (NSQF) [OPTIONAL]</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>Weaving</b>	<b>Last reviewed on</b>	<b>21/01/15</b>
<b>Occupation</b>	<b>Weaving Preparatory</b>	<b>Next review date</b>	<b>01/03/16</b>



### Assessment Criteria

**Job Role: Warper - Direct Warping Machine**  
**Qualification Pack: Warper -TSC/Q 2101**  
**Sector Skill Council: Textile Sector Skill Council**

**Guidelines for assessment :-**

1. Criteria for assessment for each qualification pack will be created by the Sector Skill Council. Each performance criteria (PC) will be assigned marks proportional to its importance in NOS. SSC will also lay down proportion of marks for theory & skill practical for each PC.
2. The assessment for the theory part will be based on knowledge bank of question created by the SSC.
3. Individual assessment agencies will create unique evaluations for skill practical for every student at each examination/training centre (as per assessment criteria below).
4. To pass the qualification pack, every trainee should score a minimum of 80%.

National Occupational Standards (NOS)	Performance Criteria (PC)	Total Marks	Out Of	Marks Allocation		
				Skills Practical	Theory	Viva
<b>1. TSC/ N2101 Taking charge of shift and handing over shift to operator</b>	PC1. Come atleast 10 - 15 minutes earlier to the work spot	<b>110</b>	10	6	2	2
	PC2. Check for the necessary items like " chalk", " pen", " knife" etc		9	5	2	2
	PC3. . Meet the previous shift warper , 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.		9	3	3	3
	PC4. Check the condition of the running beams , machine, performance of the yarn running for the running program		9	5	2	2
	PC5. Check whether all the stop motions work in good condition		9	3	3	3
	PC6. Take " job cards" for the next programs, from the higher authority.		8	4	3	1
	PC7. Check availability of the cones/ cheeses & empty warping beams required for the next programs .		8	3	3	2

### Assessment Criteria

	PC8. Check the cleanliness of the machines & other work areas .		8	4	3	1
	PC9. Check whether any spare/raw material/ tool /any other material is thrown under the machines or in the other work areas.		8	5	3	0
	PC10. Ask question to the previous shift warper 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.		8	6	2	0
	PC11. Hand over the Shift to the incoming Warper in a proper manner & get clearance from the incoming counterpart before leaving the work spot.		8	6	2	0
	PC12. Report to His/ Her shift Superiors as well as that of the incoming shift, in case His/ Her Counterpart doesn't come for work for the incoming shift. In that case, the shift has to be properly handed over to the incoming shift Superior & get clearance from Him/ Her, before leaving the work spot.		8	5	0	3
	PC13. 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		8	5	2	1
			110	60	30	20
	<b>Total</b>	<b>Weightage %</b>		<b>55%</b>	<b>27%</b>	<b>18%</b>
<b>2. TSC/ N2102 Operating a Warping</b>	PC1. Make tiny & firm warper's knots	<b>220</b>	<b>9</b>	<b>5</b>	<b>4</b>	<b>0</b>
	PC2. take straight the broken end in the warping beam .		<b>9</b>	<b>5</b>	<b>4</b>	<b>0</b>

### Assessment Criteria

<b>Machine</b>	PC3. knot the broken end in the warping beam with the broken end in the creel , using tiny & firm warper knot by hand or by the knotting machine provided.		9	5	3	1
	PC4. leave straight the mended warp yarn in the beam and the machine has to be allowed to be run in slow speed for some time, before the machine is allowed to run in the speed prescribed.		9	5	3	1
	PC5. record the warping breakages details in the “ yarn performance book” kept.		8	2	4	2
	PC6. remove the run out cones/ cheeses of the previous program .		8	1	5	2
	PC7. collect the removed cones/cheeses in trolleys/ bags provided.		8	1	5	2
	PC8. pack the said collected cones/ cheeses as per the instructions given		8	1	5	2
	PC9. write the following details on the packed bags a) Count details b) Mill Name c) Warping Set No. d) No. Of Cones e) Gross wt. in kgs f) Net Wt. in Kgs		9	6	3	0
	PC10. clean the warping creel area & the warping machine thoroughly		8	6	2	0
	PC11. bring the yarn bags required for the next program and keep the same at the centre of the warping creel		9	9	0	0
	PC12. bring the empty trolleys provided to store empty polythene cone covers . cone inserts and keep the same at the centre of the warping creel		9	9	0	0
	PC13. remove the polythene cone bags, cone inserts etc., & to store the same in the respective trolleys		9	9	0	0



### Assessment Criteria

	provided					
	PC14. creel the cones/ cheeses in the creel stand	9	6	3	0	
	PC15. remove the trolleys wherein the empty polythene covers & cone inserts are collected, from the warping area.	9	9	0	0	
	PC16. check the stop motions & to ensure they are in “ on” position, before the machine is allowed to run.	9	5	2	2	
	PC17. check the counter meter	9	5	2	2	
	PC18. mount the empty warping beam in the machine	9	5	2	2	
	PC19. set the beam mtrs in the counter meter	9	5	2	2	
	PC20. note down the “ beam no”, “ beam ends” “ beam set mtrs” etc. in the job card , immediately after the loading of the empty warping beam in the machine	9	4	3	2	
	PC21. switch on the “ warping drum” so as to ensure no deviation between the “ beam set mtrs” & “ the actual beam mtrs”	9	4	3	2	
	PC22. while starting the machine, ensure that the ends in both the edges are coming properly without any overlapping . it has to be corrected using warping comb.	9	4	3	2	
	PC23. there should not be any “ up” & “ down” portion in the warping beam, particularly in the edges.	9	3	4	2	
	PC24. after the completion of the warping beam, as per the set mtrs, the warped beams have to be doffed.	9	3	4	2	

### Assessment Criteria

	PC25. immediately after the doffing of the warped beams , the following details have to be written on the warped beams using chalk a. Count b. Warp Set No. c. Warp Beam No. d. No. Of Ends e. Beam Mtrs		9	3	4	2
			220	120	70	30
	<b>Total</b>	<b>Weightage %</b>		55%	32%	13%
<b>3. TSC/N 2103 Piecing the broken yarn</b>	PC1. patrol around the Warping machine & identify the yarn breakage.	<b>170</b>	8	4	4	0
	PC2. ensure minimum time is taken for attending the yarn breakages		8	5	3	0
	PC3. check creel break, traveller fly/ loading, undraft & roller lapping		7	3	2	2
	PC4. apply the knee break to stop the spindle		7	3	2	2
	PC5. check the quality		8	5	3	0
	PC6. ensure proper seating of empties in the spindle after yarn piecing		7	3	2	2
	PC7. verify the quality of piecing done in the yarn		8	5	3	0
	PC8. attend to the end breakage as and when they occur.		8	6	2	0
	PC9. take yarn from cop to feed to start piecing		7	5	2	0
	PC10. ensure proper material handling		7	5	2	0
	PC11. piece the yarn between false twister and drafting zone by following standard piecing techniques		7	3	2	2
	PC12. ensure proper seating of empties in the spindle after yarn piecing		7	3	2	2

### Assessment Criteria

	PC13. ensure proper traveller running		7	3	2	2
	PC14. ensure minimum time is taken for piecing the yarn		8	8	0	0
	PC15. ensure the yarn should be pieced with minimum overlapping		7	7	0	0
	PC16. put the roving ends and waste in the bags or pockets of coat / apron while attending the end breakages.		7	5	2	0
	PC17. ensure proper material handling of yarn and cops		7	4	3	0
	PC18. ensure the quality of piecing is as per standard		8	4	4	0
	PC19. ensure the tension of the pieced yarn is proper		7	4	3	0
	PC20. ensure the piecing is perfectly done		7	4	3	0
	PC21. verify proper material passage from drafting zone till the yarn wound		8	4	3	1
	PC22. remove the yarn waste and deposit in the respective waste collection bags		7	4	3	0
	PC23. ensure proper functioning of the machine		8	3	4	1
			<b>170</b>	<b>100</b>	<b>56</b>	<b>14</b>
	<b>Total</b>	<b>Weightage %</b>		<b>59%</b>	<b>33%</b>	<b>8%</b>
<b>4. TSC/ N9001 Maintain work area, tools and machines</b>	PC1. Handle materials, machinery, equipment and tools safely and correctly	<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

### Assessment Criteria

	PC7. Carry out maintenance and/or cleaning within one's responsibility		4	1	2	1
	PC8. Report unsafe equipment and other dangerous occurrences		4	1	2	1
	PC9. Ensure that the correct machine guards are in place		3	1	1	1
	PC10. Work in a comfortable position with the correct posture		3	1	1	1
	PC11. Use cleaning equipment and methods appropriate for the work to be carried out		3	1	1	1
	PC12. Dispose of waste safely in the designated location		4	1	2	1
	PC13. Store cleaning equipment safely after use		3	1	1	1
	PC14. Carry out cleaning according to schedules and limits of responsibility		4	1	2	1
			50	15	21	14
	<b>Total</b>	<b>Weightage %</b>		30%	42%	28%
<b>5.TSC/ N9002 Working in a team</b>						
	PC1. Be accountable to the own role in whole process	<b>50</b>	5	3	1	1
	PC2. Perform all roles with full responsibility		4	2	1	1
	PC3. Be effective and efficient at workplace		4	1	2	1
	PC4. Properly communicate about company policies		4	1	1	2
	PC5. Report all problems faced during the process		4	1	1	2
	PC6. Talk politely with other team members and colleagues		4	1	1	2
	PC7. Submit daily report of own performance		5	2	2	1
	PC8. Adjust in different work situations		4	2	1	1
	PC9. Give due importance to others' point of view		4	1	1	2
	PC10. Avoid conflicting situations		4	1	2	1
	PC11. Develop new ideas for work procedures		4	1	2	1

### Assessment Criteria

	PC12. Improve upon the existing techniques to increase process efficiency		4	1	2	1
			50	17	17	16
	<b>Total</b>	<b>Weightage %</b>		34%	34%	32%
<b>6. TSC/ N9003 Maintain health, safety and security at workplace</b>						
	PC1. Comply with health and safety related instructions applicable to the workplace	<b>100</b>	5	2	2	1
	PC2. Use and maintain personal protective equipment as per protocol		5	2	2	1
	PC3. Carry out own activities in line with approved guidelines and procedures		4	2	1	1
	PC4. Maintain a healthy lifestyle and guard against dependency on intoxicants		4	2	1	1
	PC5. Follow environment management system related procedures		4	2	1	1
	PC6. Identify and correct (if possible) malfunctions in machinery and equipment		5	2	2	1
	PC7. Report any service malfunctions that cannot be rectified		4	2	1	1
	PC8. Store materials and equipment in line with manufacturer's and organisational requirements		4	1	2	1
	PC9. Safely handle and move waste and debris		4	1	2	1
	PC10. Minimize health and safety risks to self and others due to own actions		5	2	2	1
	PC11. Seek clarifications, from supervisors or other authorized personnel in case of perceived risks		4	2	0	2
	PC12. Monitor the workplace and work processes for potential risks and threats		5	2	2	1

### 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
			100	43	34	23
	<b>Total</b>	<b>Weightage %</b>		43%	34%	23%
<b>7. TSC/ N9004 Comply with industry and organisational 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		3	1	1	1



**Assessment Criteria**

	the existing methods					
	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>50</b>	<b>18</b>	<b>19</b>	<b>13</b>
	<b>Total</b>	<b>Weihtage %</b>		36%	38%	26%
	<b>Total</b>		750	373	247	130
	<b>Grand Total</b>		<b>750</b>			