

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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**Sector: TEXTILE**

**SUB-SECTOR: WEAVING**

**OCCUPATION: Maintenance**

**REFERENCE ID: TSC/Q 2403**

**ALIGNED TO: NCO-2004 /  7233.46**

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

**Personal Attributes:** A Fitter - Shuttleless Weaving Machine: Rapier 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).

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**Qualifications Pack – Fitter - Shuttleless Weaving Machine: Rapier**

**Sector: Information technology- INFORMATION TECHNOLOGY enabled SERVICES (IT-ITeS)ces Helpdesk Attendant**

**Introduction**

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| Job Details | **Qualifications Pack Code** | **TSC/Q 2403** | | |
| **Job Role** | **Fitter - Shuttleless Weaving Machine: Rapier** | | |
| **Credits (NSQF)** | **TBD** | **Version number** | **1.0** |
| **Sector** | **Textile** | **Drafted on** | **15/12/14** |
| **Sub-sector** | **Weaving** | **Last reviewed on** | **21/01/15** |
| **Occupation** | **Maintenance** | **Next review date** |  |

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| **Job Role** | **Shuttle-less Weaving Machine Fitter (Rapier)** |
| **Role Description** | To maintain automatic shuttle-less loom (rapier loom) efficiently so as to get maximum output with minimum defects, with less cost of production |
| **NSQF level**  **Minimum Educational Qualifications**  **Maximum Educational Qualifications** | 5 |
| 10th standard, preferably  N/A |
| **Training**  (Suggested but not mandatory) | Training in weaving department |
| **Experience** | Preferably 1-2 years of work experience in a weaving unit |
| **National Occupational Standards (NOS)** | **Compulsory:**   1. [TSC/ N2404 Taking charge of shift and handing over shift to fitter](#_This_unit_is_1) 2. [TSC/ N2405 Maintain the shuttle-less loom: Rapier Looms](#_This_unit_provides) 3. [TSC/ N9001 Maintain work area, tools and machines](#_This_unit_is_2) 4. [TSC/ N9002 Working in a team](#_This_unit_is_3) 5. [TSC/ N9003 Maintain health, safety and security at workplace](#_This_unit_is_4) 6. [TSC/ N9004 Comply with industry and organizational requirement](#_This_unit_is_5)   **Optional:**  **N/A** |
| **Performance Criteria** | As described in the relevant OS units |

# Glossary of Key Terms

**Table 1: Glossary of Key Terms**

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| Definitions | **Keywords /Terms** | **Description** |
| Sector | Sector is a conglomeration of different business operations having similar businesses and interests. It may also be defined asa 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. |
| **Acronyms** | **Keywords /Terms** | **Description** |
| SSC | Sector Skill Council |
| OS | Occupational Standard(s) |
| NOS | National Occupational Standard(s) |
| QP | Qualifications Pack |
| NSQF | National Skill Qualifications Framework |
| NCO | National Classifications of Occupation |
| TBD | To Be Determined |
| TSC | Textile Sector Skill Council |
| NSDC | National Skill Development Corporation |

**National Occupational Standard**

**Overview**

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

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| **Unit Code**  National Occupational Standard | TSC/ N 2404 |
| **Unit Title**  **(Task)** | Taking charge of shift and handing over shift to fitter |
| **Description** | This unit is about taking charge of shift from previous shift fitter and relieving the responsibilities to the next shift fitter |
| Scope | **This unit/task covers the following:**   * To take charge of shift from previous shift fitter * To hand over the shift to next shift fitter |
| **Elements** | **Performance Criteria** |
| Taking charge of shift | To be competent, you must be able to:   1. come at least 15 - 20 minutes earlier to the work spot 2. ensure that the necessary tools, gauges etc, are in place 3. check for the availability of the weft & the condition of the same 4. check the working condition of the Weft Feeders 5. check for the fabric defects on the cloth 6. check for the correct functions of Centre Cutter , Side Cutter etc., wherever they are in use 7. check whether the leno ends are drawn properly 8. check whether catch cord ends are drawn properly 9. check whether the Leno motion works properly 10. check the condition of the running beams , for cross ends, ends pulling out particularly at the selvedges 11. check the condition of the Rapiers 12. check the condition of the Rapier Tapes 13. note down the break downs 14. check for the size of the Cloth Rolls & to see whether any indication is there in the cloth rolls 15. check the cleanliness of the machines & other work areas 16. check whether any spare/raw material/ tool / fabric/ any other material is thrown under the machines or in the other work areas 17. question the previous shift fitter for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as well as that of the previous shift |
| **Handing over shift** | 1. hand over the shift to the incoming fitter in a proper manner 2. get clearance from the incoming counterpart before leaving the work spot 3. 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. In that case, the shift has to be properly handed over to the incoming shift Superior & get clearance from Him before leaving the work spot 4. 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 |
| **Knowledge and Understanding (K)** | |
| 1. **Organizational Context** (Knowledge of the company/ organization and its processes) | You need to know and understand:   1. the organization's policies & procedures 2. should have an awareness, knowledge of customers 3. potential hazards associated with the machines and the safety precautions must be taken 4. protocol to obtain more information on work related tasks 5. contact person in case of queries on procedure or products and for resolving issues related to defective machines, tools, materials & equipments 6. details of the various job roles & responsibilities 7. documentation and reporting formats 8. work targets & review mechanism with superiors 9. protocol and format for reporting work related risks/ problems 10. method of obtaining /giving feed back with respect to performance 11. importance of harmonious working relationships 12. process for offering /obtaining work related assistance 13. responsibilities under health, safety and environmental legislation 14. guidelines for storage & disposal of waste materials |
| 1. **Technical/ Domain Knowledge** | The user/individual on the job needs to know and understand:   1. minimum quality requirements of the product with respect to permissible/non permissible defect 2. fabric quality particulars such as ends & picks per inch, width weave etc. |
| (About the Raw materials) | 1. yarns from natural fibres - cotton, silk, wool 2. yarns from man made fibres - polyester, nylon, viscos. 3. Blended yarns - Polyester Cotton, Polyester Viscose |
| (About different types of Looms) | 1. Hand Loom 2. Power Loom - Conventional Loom 3. Auto Loom - Shuttle Looms 4. Shuttleless Looms - Rapier , Projectile , Airjet, Waterjet 5. Tappet loom/ Cam Loom/ Crank Loom , Dobby Loom, Jacquard Loom |
| (About Type Of Weaves) | 1. Plain Weave, Twill , Drill, Plain Satin, Stripe Satin , Dobby designs , Jacquard Designs |
| (Causes for fabric defects) | 1. Wrong Drawing , Wrong Denting, End Out , Double End, Broken Pick, Double Pick, Missing Pick, Hand Stain , Hole, Wrong Weft, Bad Selvedge 2. End Out, Let-Off, Take- Up problem, Temple Mark, Temple Cut, Emery Hole/ Emery Cut/ Emery Mark, Broken Pick, Missing Pick, Double Pick, Short Pick, Snarls, Impression Mark, Oil Stain, Lashing In, Weft Catching, Selvedge Cut, Loops, Weft Stitches, Warp Stitches, Bumping Mark, Weft Crack, Cloth Torn , Bad Shedding, Warp Floats, Weft Floats, Reed Mark, Bad Selvedge, Starting Mark, Thin & Thick Place , Hair line crack 3. Spinning Faults - Thin Place, Thick Place, Neps, Kitties, Contamination, Colour Flies, Yarn variation, Shade Variation 4. Sizing Faults - Shade variation, Size Patches, Sizing Oil, Bead formation 5. Weaving Faults - Wrong Weft, Wrong Pattern, Less Width, Low EPI, Low PPI, Wrong Warp 6. Four Point American System  * Below 3" - 1 point * Between 3" to 6 " - 2 points * Between 6" to 9" - 3 points * Above 9" - 4 points |
| (British system of grading cuttable faults, warp way continuous faults, specification deviations) | 1. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No 3 Major Faults, 15 minor points 2. B Grade - Rejection. Deviation from A Grade 3. Cuttable Faults ; Hole, Let - Off, Take - Up, Selvedge Cut, Weft Crack, Cloth Torn, Wrong Pattern, Bad Shedding, Size Patches , Sizing Oil, Bead Formation, Wrong Weft 4. Major Faults : Wrong Drawing, Wrong Denting, End Out, Double End, Temple Mark, Temple Cut, Emery Hole, Emery Cut, Emery Mark, Impression Mark, Guide Tooth Mark, Under Tuck In, Tails, Warp Stitches , Warp Floats, Reed Mark, Bad Selvedge, Yarn Variation, Shade Variation 5. Cloth Width - No Minus is accepted & No excess above 0.5" is accepted 6. Ends Per Inch - Plus or Minus 2 is accepted. Picks Per Inch - Plus or Minus 1. |
| (American System) | 1. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No of grading Export Specification Deviation. Maximum 15 points for 100 Square meter Standard – Piece 2. B Grade - Rejection . Deviation from A Grade 3. Lengths - Between 40 mtrs to 79.75 mtrs - 20% (to variation from Buyer to Buyer) 4. Above 80 mtrs - 80% |
| (Safety Mechanism) | 1. safety mechanisms of the machines & should ensure that the same are in order 2. Should know about the stop motions & should ensure that the same are in order 3. Should know about the indication lamps & should ensure that the same are in order |
| (Machine operations) | 1. functional operations of the machines |
| **Skills (S)** | |
| 1. **Core Skills/ Generic Skills** | **Writing Skills** |
| You need to know and understand how to:   1. write in simple language |
| **Reading Skills** |
| You need to know and understand how to:   1. comprehend written instructions |
| **Oral Communication (Listening and Speaking skills)** |
| You need to know and understand how to:   1. communicate with supervisor appropriately 2. talk to others to convey information effectively |
| 1. **Professional Skills** | **Problem Solving** |
| You need to know and understand how to:   1. apply problem-solving approaches in different situations 2. refer anomalies to the supervisor 3. seek clarification on problems from others |
| **Attention to Detail** |
| You need to know and understand how to:  SB4. apply good attention to detail  SB5. check your work is complete and free from errors |
|  | **Participation** |
| 1. participate in the various programs/ meetings that will be conducted by the Superiors 2. put forth the suggestions in the interest of the Company 3. participate in the " Quality Circles" that will be formed by the Superiors 4. 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 |
| 1. **Technical Skills** | You need to know and understand how to:   1. ensure that Warp breaks/loom hour doesn’t exceed 2 2. ensure that weft breaks/loom hour doesn’t exceed 1 3. ensure that fabric rejection doesn’t exceed 1% 4. ensure that the efficiency is maintained in excess of 85% 5. ensure that the warp waste doesn’t exceed 0.5% 6. ensure that the weft waste doesn’t exceed 1 % |

**NOS Version Control**

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

**National Occupational Standard**

**Overview**

# This unit provides performance criteria, knowledge & understanding and skills & abilities required to maintain shuttle-less loom (Rapier Looms), by attending to repairs with respect to quality & production so as to get maximum output & minimum defects, and with less cost of production without entertaining any damage to the people, the machine etc. without wasting much of raw materials, spares, tools etc., & without spoiling the environmental aspects.

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| **Unit Code**  National Occupational Standard | TSC/ N 2405 |
| **Unit Title**  **(Task)** | Maintain the shuttle-less loom: Rapier Looms |
| **Description** | This unit provides performance criteria, knowledge & understanding and skills & abilities required to maintain shuttle-less loom (Rapier Looms), by attending to repairs with respect to quality & production so as to get maximum output & minimum defects, and with less cost of production without entertaining any damage to the people, the machine etc. without wasting much of raw materials, spares, tools etc., & without spoiling the environmental aspects. |
| Scope | **This unit/task covers the following:**   * Attending to quality Issues * Attending Production Issues/ Break downs * Ensuring Maintenance activities * Other Work Practices |
| **Elements** | **Performance Criteria** |
| **Attending to quality Issues** | To be competent, you must be able to:   1. ensure that the production is commenced only after the sample is approved 2. ensure that bulk production is started only after the first roll is approved 3. ensure that Warp Stop motion functions properly, so that no end out problem , warp float etc. doesn’t occur on the fabrics 4. ensure that Weft stop motion functions properly so that fabrics don’t get rejected due to weft crack 5. maintain Take – Up & Let-Off mechanisms properly so that fabrics don’t get rejected due to let-off faults, take-up faults etc 6. ensure proper functioning of stop motions, Back Rest, Shedding etc., so that fabrics are free from defects like starting mark, bad shedding etc. 7. maintain temple setting , reed setting so that fabrics don’t get rejected for reasons like “temple cut”, “temple mark”, “Reed mark” 8. attend the other fabric defects like “ Drop Pick” , “ Cloth Torn”, “ Weft Stitches” “ floats” “ etc. |
| **Attending Production Issues/ Break downs** | 1. attend excessive weft breaks 2. attend to Weft Transfer failures 3. attend excessive warp breaks 4. attend to loom stoppages due to “ Projectile getting Jammed “ 5. see that the condition of Heald wires, Heald Frames , reed etc. are in good condition 6. see that the loom runs with the actual required belts and should see that there is no slippage in the same, so as to ensure that the loom works in the recommended speed 7. see that replenishment of spares or attending to break downs is done in the prescribed time. 8. ensure required humidity in the loom shed 9. check the knotted looms & ensure that knotting is carried out without cross ends 10. check the sort change loom & ensure that drawing & reaching was carried out without any cross ends 11. ensure “ Loom Breakage Study” and check the quality of both warp & weft yarn. For any deviation the same has to be brought to the knowledge of the higher authority 12. check the Sizing quality and for any deviation , the same has to be brought to the notice of the higher authority 13. ensure proper dropper cleaning |
| **Ensuring Maintenance activities** | 1. ensure that the looms are cleaned properly as per the below schedule 2. Daily cleaning 3. Cleaning during Knottings 4. Cleaning during Sort Changes 5. carry out preventive maintenance as per the schedule 6. ensure the life of all the spares through effective maintenance |
|  | 1. To maintain “ Spare Changing Details ” note, for the following details. 2. Loom No. 3. Name Of The Spare 4. Side ( If any) 5. Part No. 6. Name Of the Supplier 7. Make 8. Date of Application 9. Date Of Removal 10. Reason For Removal 11. Life Of Item 12. To salvage the “ Broken Spare “ & to avail new spare, only after producing the “ Old Spare to the Stores 13. To maintain “ Sort Muster” as per the below details 14. Loom No. 15. Construction Details 16. Warp Material details 17. Warp Count 18. Warp Mill Name 19. Warp Yarn Test Report( Test Parameters) 20. Reed Used 21. Total Ends Used 22. Name Of The Sizing 23. Warping Breakage Rate 24. Average Warp Count 25. Size Pick Up 26. Warp break/ loom hour 27. Weft Material Details 28. Weft Count 29. Weft Mill Name 30. Weft Yarn Test Report( Test Parameters) 31. Reed Space 32. Weft breakage per loom hour] 33. Average Loom Efficiency 34. Loom Speed 35. Average Production in Kilo Picks/loom day 36. Production in mtrs/loom day 37. Date of knotting 38. Knotted mtrs 39. Date of exhaustion 40. Produced mtrs 41. Warp Crimp 42. Warp Consumption/mtr ( Excluding Size Add On) 43. Warp Wt in kgs/ mtr ( Including Size add on) 44. Weft Consumption/mtr 45. Total cloth wt in kgs/ mtr 46. GSM 47. Fabric doffed 48. Fabric inspected 49. Fabric Passed 50. Fabric Rejected 51. Rejection % 52. Reason For Rejection 53. Warp Waste % 54. Weft Waste % 55. maintain effective working of “Generator” 56. see that “ Air” is not misused Can use air for cleaning, only in the areas, where it is allowed 57. ensure proper maintenance of “Air Compressor” |
| **Other Work Practices** | 1. Should ensure that " Loom Cards " for all the required details are placed on all the looms 2. Loom No. 3. Construction details 4. Reed Count 5. Reed Space 6. Weft Count 7. Pick Wheel 8. Winding Spindle No. 9. Drawing Method 10. see that the weft yarn is completely used , without giving room for additional wastage of raw materials. For any quality issue or defective cone etc., the same has to be brought to the notice of the Superiors 11. To maintain “Knotting Entry Note” with the following details 12. Loom No. 13. Construction Details 14. Date Of Knotting 15. Time of Exhaustion 16. Cleaning Completed Time 17. Beam Loading Completed Time 18. Knotting Completed Time 19. Loom Run Time 20. Total Stopped Time For Knotting 21. Name Of the Sizing 22. Set No. 23. Beam Nos. 24. Beam Mtrs 25. Old Warp Waste kgs 26. New Warp Waste kgs 27. Cleaning Quality 28. Knotting Quality 29. ensure Relative Humidity in the Department is maintained 30. ensure correct quality of thrums are there & see that the same are properly tied 31. check the knotted loom for knotting quality etc. Double ends have to be removed. Report to Superiors for any deviation in the same & for any other quality issue 32. Check all the safety covers are placed 33. ensure that cloth rolls are doffed whenever/ wherever necessary 34. ensure that no raw material/ cloth/ spare/ tool / any other material is thrown under/ near the machines or in the other work areas. |
| **Knowledge and Understanding (K)** | |
| 1. **Organizational Context** (Knowledge of the company/ organization and its processes) | You need to know and understand:   1. The Organization's Policies & Procedures 2. Should have an awareness, knowledge of customers 3. Potential hazards associated with the machines and the safety precautions must be taken 4. Protocol to obtain more information on work related tasks 5. Contact Person in case of queries on procedure or products and for resolving issues related to defective machines, tools, materials & equipments 6. Details of the various job roles & responsibilities 7. Documentation and reporting formats 8. Work Targets & review mechanism with Superiors 9. Protocol and format for reporting work related risks/ problems 10. Method of obtaining /giving feed back with respect to performance 11. Importance of harmonious working relationships 12. Process for offering /obtaining work related assistance 13. Responsibilities under health, safety and environmental legislation 14. Guidelines for storage & disposal of waste materials |
| 1. **Technical/ Domain Knowledge** | The user/individual on the job needs to know and understand:   1. minimum quality requirements of the product with respect to permissible/non permissible defects 2. Fabric quality particulars such as ends & picks per inch, width weave etc. |
| (About the Raw materials) | 1. Yarns from natural fibres - Cotton, Silk, Wool 2. Yarns from Man made Fibres - Polyester, Nylon, Viscose 3. Blended yarns - Polyester Cotton, Polyester Viscose |
| (About different types of Looms) | 1. Hand Loom 2. Power Loom - Conventional Loom 3. Auto Loom - Shuttle Looms 4. Shuttleless Looms - Rapier , Projectile , Airjet, Waterjet 5. Tappet loom/ Cam Loom/ Crank Loom , Dobby Loom, Jacquard Loom |
| (About Type Of Weaves) | 1. Plain Weave, Twill , Drill, Plain Satin, Stripe Satin , Dobby designs , Jacquard Designs |
| (Causes for fabric defects) | 1. Wrong Drawing , Wrong Denting, End Out , Double End, Broken Pick, Double Pick, Missing Pick, Hand Stain , Hole, Wrong Weft, Bad Selvedge 2. End Out, Let-Off, Take- Up problem, Temple Mark, Temple Cut, Emery Hole/ Emery Cut/ Emery Mark, Broken Pick, Missing Pick, Double Pick, Short Pick, Snarls, Impression Mark, Oil Stain, Lashing In, Weft Catching, Selvedge Cut, Loops, Weft Stitches, Warp Stitches, Bumping Mark, Weft Crack, Cloth Torn , Bad Shedding, Warp Floats, Weft Floats, Reed Mark, Bad Selvedge, Starting Mark, Thin & Thick Place , Hair line crack 3. Spinning Faults - Thin Place, Thick Place, Neps, Kitties, Contamination, Colour Flies, Yarn variation, Shade Variation 4. Sizing Faults - Shade variation, Size Patches, Sizing Oil, Bead formation 5. Weaving Faults - Wrong Weft, Wrong Pattern, Less Width, Low EPI, Low PPI, Wrong Warp 6. Four Point American System 7. Below 3" - 1 point 8. Between 3" to 6 " - 2 points 9. Between 6" to 9" - 3 points 10. Above 9" - 4 points |
| (British system of grading cuttable faults, warp way continuous faults, specification deviations) | 1. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No 3 Major Faults, 15 minor points 2. B Grade - Rejection. Deviation from A Grade 3. Cuttable Faults ; Hole, Let - Off, Take - Up, Selvedge Cut, Weft Crack, Cloth Torn, Wrong Pattern, Bad Shedding, Size Patches , Sizing Oil, Bead Formation, Wrong Weft 4. Major Faults : Wrong Drawing, Wrong Denting, End Out, Double End, Temple Mark, Temple Cut, Emery Hole, Emery Cut, Emery Mark, Impression Mark, Guide Tooth Mark, Under Tuck In, Tails, Warp Stitches , Warp Floats, Reed Mark, Bad Selvedge, Yarn Variation, Shade Variation 5. Cloth Width - No Minus is accepted & No excess above 0.5" is accepted 6. Per Inch - Plus or Minus 2 is accepted. Picks Per Inch - Plus or Minus 1. |
| (American System) | 1. A Grade - No Cuttable Faults, No Warp Way Continuous Faults, No of grading Export Specification Deviation. Maximum 15 points for 100 Square meter Standard – Piece 2. B Grade - Rejection . Deviation from A Grade  * Lengths - Between 40 mtrs to 79.75 mtrs - 20% (to variation from Buyer to Buyer) * Above 80 mtrs - 80% |
| (Safety Mechanism) | 1. safety mechanisms of the machines & should ensure that the same are in order 2. the stop motions & should ensure that the same are in order 3. indication lamps & should ensure that the same are in order |
| (Machine operations) | 1. functional operations of the machines |
| **Skills (S)** | |
| 1. **Core Skills/ Generic Skills** | **Reading Skills** |
| You need to know and understand how to:   1. comprehend written instructions |
| **Oral Communication (Listening and Speaking skills)** |
| You need to know and understand how to:   1. Communicate with supervisor appropriately 2. talk to others to convey information effectively |
| 1. **Professional Skills** | **Problem Solving** |
| You need to know and understand how to:   1. apply problem-solving approaches in different situations 2. refer anomalies to the supervisor 3. seek clarification on problems from others |
| **Attention to Detail** |
| You need to know and understand how to:  SB4. apply good attention to detail  SB5. check your work is complete and free from errors |
| **Participation** |
| You need to know and understand how to:   1. participate in the various programs/ meetings that will be conducted by the Superiors 2. put forth the suggestions in the interest of the Company 3. participate in the " Quality Circles" that will be formed by the Superiors 4. 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 |
| 1. **Technical Skills** | You need to know and understand how to:   1. ensure that Warp breaks/loom hour doesn’t exceed 2 2. ensure that weft breaks/loom hour doesn’t exceed 1 3. ensure that fabric rejection doesn’t exceed 1% 4. ensure that the efficiency is maintained in excess of 85% 5. ensure that the warp waste doesn’t exceed 0.5% 6. ensure that the weft waste doesn’t exceed 1 % |

**NOS Version Control**

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| **NOS Code** | **TSC/ N2405** | | |
| **Credits (NSQF)**  **[*OPTIONAL*]** | **TBD** | **Version number** | **1.0** |
| **Industry** | **Textile** | **Drafted on** | **15/12/14** |
| **Industry Sub-sector** | **Weaving** | **Last reviewed on** | **21/01/15** |
| **Occupation** | **Maintenance** | **Next review date** |  |

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Current Industry Trends

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**National Occupational Standard**

**Overview**

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

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| **Unit Code**  National Occupational Standard | **TSC/ N9001** |
| **Unit Title**  **(Task)** | Maintaining work area, tools and machines |
| **Description** | 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 |
| Scope | **Proper maintaining of work area and activities** |
| **Performance Criteria (PC) w.r.t. the Scope** | |
| **Elements** | **Performance Criteria** |
| Maintain the work area, tools and machines | To be competent, you must be able to:   1. handle materials, machinery, equipment and tools with care and use them in the correct way 2. use correct lifting and handling procedures 3. use materials to minimize waste 4. maintain a clean and hazard free working area 5. maintain tools and equipment 6. carry out running maintenance within agreed schedules 7. carry out maintenance and/or cleaning within one’s responsibility 8. report unsafe equipment and other dangerous occurrences 9. ensure that the correct machine guards are in place 10. work in a comfortable position with the correct posture 11. use cleaning equipment and methods appropriate for the work to be carried out 12. dispose of waste safely in the designated location 13. store cleaning equipment safely after use 14. carry out cleaning according to schedules and limits of responsibility |
| **Knowledge and Understanding (K)** | |
| 1. **Organizational Context** (Knowledge of the company/ organization and its processes) | You need to know and understand:   1. personal hygiene and duty of care 2. safe working practices and organisational procedures 3. limits of your own responsibility 4. ways of resolving with problems within the work area 5. the production process and the specific work activities that relate to the whole process 6. the importance of effective communication with supervisors 7. the lines of communication, authority and reporting procedures 8. the organisation’s rules, codes and guidelines (including timekeeping) 9. the company’s quality standards 10. the importance of complying with written instructions 11. equipment operating procedures / supervisor’s instructions |
| 1. **Technical Knowledge** | You need to know and understand:   1. work instructions and specifications and interpret them accurately 2. relation between work role and the overall manufacturing process 3. hazards likely to be encountered when conducting routine maintenance 4. the importance of taking action when problems are identified 5. different ways of minimising waste 6. the importance of running maintenance and regular cleaning 7. effects of contamination on products i.e. machine oil, dirt, foreign materials 8. common faults with equipment and the method to rectify 9. maintenance procedures 10. different types of cleaning equipment and substances and their use 11. safe working practices for cleaning and the method of carrying them out |

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| **Skills (S)** | |
| 1. **Core Skills/ Generic Skills** | **Writing Skills** |
| 1. write in simple launguage |
| **Reading Skills** |
| You need to know and understand how to:   1. comprehend written instructions 2. read any application sent by other colleagues |
| **Oral Communication (Listening and Speaking skills)** |
| You need to know and understand how to:   1. Communicate effectively in local language 2. communicate with supervisor appropriately 3. talk to others to convey information effectively |
| 1. **Professional Skills** | **Problem Solving** |
| You need to know and understand how to:   1. identify the real reason of problem faced 2. apply problem-solving approaches in different situations 3. refer anomalies to the supervisor 4. seek clarification on problems from others |
| **Attention to Detail** |
| You need to know and understand how to:   1. apply good attention to detail 2. check your work is complete and free from errors 3. make sure every kind of communication is error free |
| 1. **Technical Skills** | You need to know and understand :   1. communicate effectively 2. apply leadership skills wherever required 3. take initiative at the right place 4. understand the requirement to be creative |

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| **NOS Code** | **TSC/ N9001** | | |
| **Credits (NSQF)**  **[*OPTIONAL*]** | **TBD** | **Version number** | **1.0** |
| **Industry** | **Textile** | **Drafted on** |  |
| **Industry Sub-sector** | **Weaving** | **Last reviewed on** |  |
| **Occupation** | **Maintenance** | **Next review date** |  |

**National Occupational Standard**

**Overview**

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

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| **Unit Code** | **TSC/ N9002** |
| **Unit Title**  National Occupational Standard  **(Task)** | Working in a team |
| **Description** | This unit is about working as a team member in the textile industry |
| Scope | **This unit/task covers the following:**   * commitment and trust * communication * adaptability * creative freedom |
| **Performance Criteria (PC) w.r.t. the Scope** | |
| **Elements** | **Performance Criteria** |
| Commitment and trust | To be competent, you must be able to:   1. be accountable to the own role in whole process 2. perform all roles with full responsibility 3. be effective and efficient at workplace |
| Communication | 1. properly communicate about company policies 2. report all problems faced during the process 3. talk politely with other team members and colleagues 4. submit daily report of own performance |
| Adaptability | 1. adjust in different work situations 2. give due importance to others’ point of view 3. avoid conflicting situations |
| Creative freedom | 1. develop new ideas for work procedures 2. improve upon the existing techniques to increase process efficiency |
| **Knowledge and Understanding (K)** | |
| 1. **Organizational Context** | You need to know and understand:   1. general rules and regulations in a textile mill 2. procedure followed to get the final output in the mill 3. safe working practices to be adopted in textile mill 4. reporting to the supervisor or higher authority about any grievances faced |
| 1. **Technical Knowledge** | 1. the importance of the previous and next step of the process 2. process flow in a textile mill and the concerned workers 3. material flow in a textile mill and the required person 4. functions of different parts of the machine 5. tools and equipments used 6. guidelines for operating the machine 7. safety procedures to be followed in the machine |
| **Skills (S)** | |
| 1. **Core Skills/ Generic Skills** | **Writing Skills** |
| You need to know and understand how to:   1. write in simple language 2. write daily work report 3. write grievance complaint application |
| **Reading Skills** |
| 1. comprehend written instructions 2. read any application sent by other colleagues |
| **Oral Communication (Listening and Speaking skills)** |
| 1. communicate with supervisor appropriately 2. talk to co-workers to convey information effectively |
| 1. **Professional Skills** | **Problem Solving** |
| You need to know and understand how to:   1. identify the real reason of problem faced 2. be able to find the most effective solution to the problems faced |
| **Attention to Detail** |
| 1. apply good attention to detail 2. ensure every kind of communication is error free |
| 1. **Technical Skills** | You need to know and understand how to:   1. communicate effectively 2. apply leadership skills wherever required 3. take initiative at the right place 4. understand the requirement to be creative |

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| **NOS Code** | **TSC/ N9002** | | |
| **Credits (NSQF)**  **[*OPTIONAL*]** | **TBD** | **Version number** | **1.0** |
| **Industry** | **Textile** | **Drafted on** |  |
| **Industry Sub-sector** | **Weaving** | **Last reviewed on** |  |
| **Occupation** | **Maintenance** | **Next review date** |  |

**National Occupational Standard**

**Overview**

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

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| **Unit Code**  National Occupational Standard | **TSC/ N9003** |
| **Unit Title**  **(Task)** | Maintain health, safety and security at work place |
| **Description** | This unit provides performance criteria, knowledge & understanding and skills & abilities required to comply with health, safety and security requirements at the workplace and covers procedures to prevent, control and minimize risk to self and others. |
| Scope | **This unit/task covers the following:**   * to recognize hazards * to plan safety techniques * to implement programs * to audit workplace |
| **Performance Criteria (PC) w.r.t. the Scope** | |
| **Elements** | **Performance Criteria** |
| Comply with health, Safety and security requirements at work | To be competent, operator must be able to:   1. comply with health and safety related instructions applicable to the workplace 2. use and maintain personal protective equipment such as “ear plug”, “ nose mask “, “ head cap” etc., as per protocol 3. carry out own activities in line with approved guidelines and procedures 4. maintain a healthy lifestyle and guard against dependency on intoxicants 5. follow environment management system related procedures 6. identify and correct (if possible) malfunctions in machinery and equipment 7. report any service malfunctions that cannot be rectified 8. store materials and equipment in line with organisational requirements 9. safely handle and remove waste 10. minimize health and safety risks to self and others due to own actions 11. seek clarifications, from supervisors or other authorized personnel in case of perceived risks 12. monitor the workplace and work processes for potential risks and threat 13. carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned 14. report hazards and potential risks/ threats to supervisors or other authorized personnel 15. participate in mock drills/ evacuation procedures organized at the workplace 16. undertake first aid, fire-fighting and emergency response training, if asked to do so 17. take action based on instructions in the event of fire, emergencies or accidents 18. follow organisation procedures for shutdown and evacuation when required |
| Recognizing the hazards | To be competent, you must be able to:   1. identify different kinds of possible hazards (environmental, personal, ergonomic, chemical) of the industry 2. recognise other possible security issues existing in the workplace |
| Planning the safety techniques | 1. recognise different measures to curb the hazards |
| Implementing the programs | 1. communicate the safety plan to everyone 2. attach disciplinary rules with the implementation |
| **Knowledge and Understanding (K)** | |
| 1. **Organizational Context** (Knowledge of the company/ organization and its processes) | You need to know and understand:   1. general rules and regulations in a textile mill 2. safe working practices to be adopted in textile mill 3. quality systems and other processes practiced in the textile mill 4. health and safety related practices applicable at the workplace 5. potential hazards, risks and threats based on nature of operations 6. organizational procedures for safe handling of equipment and machine operations 7. potential risks due to own actions and methods to minimize these 8. environmental management system related procedures at the workplace 9. layout of the plant and details of emergency exits, escape routes, emergency equipment and assembly points 10. potential accidents and emergencies and response to these scenarios 11. reporting protocol and documentation required 12. details of personnel trained in first aid, fire-fighting and emergency response 13. actions to take in the event of a mock drills/ evacuation procedures or actual accident, emergency or fire |
| 1. **Technical Knowledge** | You need to know and understand:   1. occupational health and safety risks and methods 2. personal protective equipment and method of use 3. identification, handling and storage of hazardous substances 4. proper disposal system for waste and by-products 5. signage related to health and safety and their meaning 6. importance of sound health, hygiene and good habits 7. ill-effects of alcohol, tobacco and drugs |
| **Skills (S)** | |
| 1. **Core Skills/ Generic Skills** | **Writing Skills** |
| You need to know and understand how to:   1. write in simple language |
| **Reading Skills** |
| 1. comphrende written instructions |
| **Oral Communication (Listening and Speaking skills)** |
| 1. listen to others attentively 2. respond to emergencies, accidents or fire at the workplace 3. evacuate the premises and help others in need while doing so 4. the value of physical fitness, personal hygiene and good habits 5. talk with others politely |
| 1. **Professional Skills** | **Decision Making** |
| 1. identify correct safety measure for particular hazard 2. make required safety plans as and when required 3. raise alarm in case of emergency |
| **Analytical Thinking** |
| 1. know the use of correct safety measure whenever required |
| **Attention to Detail** |
| 1. be attentive to details 2. be careful to avoid occurrence of hazards |
| 1. **Technical Skills** | You need to know and understand :   1. maintainance of neatness at work 2. procedure for reporting unwanted behavior |

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| **NOS Code** | **TSC/ N9003** | | |
| **Credits (NSQF)**  **[*OPTIONAL*]** | **TBD** | **Version number** | **1.0** |
| **Industry** | **Textile** | **Drafted on** |  |
| **Industry Sub-sector** | **Weaving** | **Last reviewed on** |  |
| **Occupation** | **Maintenance** | **Next review date** |  |

**NOS Version Control**

**National Occupational Standard**

**Overview**

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

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| **Unit Code**  National Occupational Standard | **TSC/ N9004** |
| **Unit Title**  **(Task)** | Comply with industry and organizational requirements |
| **Description** | This unit is about knowing, understanding, and complying with the requirements of the organization and the textle industry |
| Scope | **This unit/task covers the following:**   * focus on self development * focus on team work * know and understand organizational standards * know and understand industry standards |
| **Performance Criteria (PC) w.r.t. the Scope** | |
| **Elements** | **PerformanceCriteria** |
| Self- development | To be competent, you must be able to:   1. perform own duties effectively 2. take responsibility for own actions 3. be accountable towards the job role and assigned duties 4. take initiative and innovate the existing methods 5. focus on self-learning and improvement |
| Team work | 1. co-ordinate with all the team members and colleagues 2. communicate politely 3. avoid conflicts and miscommunication |
| Organisational standards | 1. know the organisational standards 2. implement them in your performance 3. motivate others to follow them |
| Industry standards | 1. know the industry standards 2. align them with organisation standards |
| **Knowledge and Understanding (K)** | |
| 1. **Organizational Context** (Knowledge of the company/ organization and its processes) | You need to know and understand:   1. general rules and regulations in a textile mill 2. reporting to the supervisor or higher authority 3. knowledge of organisationl standards 4. knowledge of industry standards |
| 1. **Technical Knowledge** | You need to know and understand:   1. process and material flow in a textile mill 2. importance of complying with the standards 3. guidelines for cleaning the various parts of machine |
| **Skills (S)** | |
| 1. **Core Skills/ Generic Skills** | **Writing Skills** |
| You need to know and understand how to:   1. write in simple language |
| **Reading Skills** |
| You need to know and understand how to:   1. comprehend written instructions |
| **Oral Communication (Listening and Speaking skills)** |
| 1. talk effectively with others 2. put forward your point 3. listen to others |
| 1. **Technical skills** | you need to know and understand :   1. Organizational requirements 2. your responsibilities at the workplace 3. procedure to comply with the industry standards |

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| **NOS Code** | **TSC/N 9004** | | |
| **Credits (NSQF)**  **[*OPTIONAL*]** | **TBD** | **Version number** | **1.0** |
| **Industry** | **Textile** | **Drafted on** |  |
| **Industry Sub-sector** | **Weaving** | **Last reviewed on** |  |
| **Occupation** | **Maintenance** | **Next review date** |  |

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| --- | --- | --- | --- | --- | --- | --- |
| **Job Role: Warper - Fitter - Shuttleless Weaving Machine: Rapier Qualification Pack: Fitter - Shuttleless Weaving Machine: Rapier Sector Skill Counci: Textile** | | | | | | |
|
| **Guidelines for assessment :-** 1. Criteria for assessment for each qualification pack will be created by the Sector Skill Council. Each performance criteria (PC) will be assigned marks proportional to its importance in NOS. SSC will also lay down proportion of marks for theory & skill practical for each PC. 2. The assessment for the theory part will be based on knowledge bank of question created by the SSC. 3. Individual assessment agencies will create unique evaluations for skill practical for every student each examination/training centre (as per assessment criteria below). 4. To pass the qualification pack, every trainee should achieve minimum grade 'C' (More Than 90% - "A+", 80%-89%-"A", 70%-79%-"B+", 60%-69%-"B", 50%-59%-"C", 49% or less is "F") | | | | | | |
|  |  |  |  |  |  |  |
| **National Occupational Standards (NOS)** | **Performance Criteria (PC)** | **Total Marks** | **Out Of** | **Marks Allocation** | | |
| **Practical** | **Theory** | **Viva** |
| **1. TSC/ N2404 Taking charge of shift and handing over shift to fitter** | PC1. come at least 15 - 20 minutes earlier to the work spot | **50** | 1 | 1 | 0 | 0 |
| PC2. ensure that the necessary tools, gauges etc, are in place | 3 | 1 | 1 | 1 |
| PC3. check for the availability of the weft & the condition of the same | 2 | 1 | 1 | 0 |
| PC4. check the working condition of the Weft Feeders | 2 | 2 | 0 | 0 |
| PC5. check for the fabric defects on the cloth | 4 | 2 | 1 | 1 |
| PC6. check for the correct functions of Centre Cutter , Side Cutter etc., wherever they are in use | 2 | 1 | 1 | 0 |
| PC7. check whether the leno ends are drawn properly | 4 | 2 | 1 | 1 |
| PC8. check whether catch cord ends are drawn properly | 2 | 1 | 1 |  |
| PC9. check whether the Leno motion works properly | 2 | 1 | 1 | 0 |
| PC10. check the condition of the running beams , for cross ends, ends pulling out particularly at the selvedges | 3 | 2 | 1 | 0 |
| PC11. check the condition of the Rapiers | 3 | 2 | 1 | 0 |
| PC12. check the condition of the Rapier Tapes | 4 | 2 | 1 | 1 |
| PC13. note down the break downs | 2 | 2 | 0 | 0 |
| PC14. check for the size of the Cloth Rolls & to see whether any indication is there in the cloth rolls | 2 | 1 | 1 | 0 |
| PC15. check the cleanliness of the machines & other work areas | 2 | 1 | 1 | 0 |
| PC16. check whether any spare/raw material/ tool / fabric/ any other material is thrown under the machines or in the other work areas | 2 | 1 | 1 | 0 |
| PC17. question the previous shift fitter for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as well as that of the previous shift | 1 | 1 | 0 | 0 |
| PC18. hand over the shift to the incoming fitter in a proper manner | 2 | 2 | 0 | 0 |
| PC19. get clearance from the incoming counterpart before leaving the work spot | 2 | 2 | 0 | 0 |
| PC20. 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. In that case, the shift has to be properly handed over to the incoming shift Superior & get clearance from Him before leaving the work spot | 2 | 1 | 1 | 0 |
| PC21. 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 |  | 3 | 2 | 1 | 0 |
|  |  | 50 | 31 | 15 | 4 |
| **Total** | **Weightage %** |  | 62.00% | 30.00% | 8.00% |
|  | | | | | | |
| **2. TSC/ N2405 Maintain the shuttle-less loom: Rapier Looms** | PC1. ensure that the production is commenced only after the sample is approved | **150** | 2 | 2 | 0 | 0 |
| PC2. ensure that bulk production is started only after the first roll is approved | 2 | 2 | 0 | 0 |
| PC3. ensure that Warp Stop motion functions properly, so that no end out problem , warp float etc. doesn’t occur on the fabrics | 4 | 3 | 1 | 0 |
| PC4. ensure that Weft stop motion functions properly so that fabrics don’t get rejected due to weft crack | 2 | 1 | 1 | 0 |
| PC5. maintain Take – Up & Let-Off mechanisms properly so that fabrics don’t get rejected due to let-off faults, take-up faults etc | 3 | 2 | 1 | 0 |
| PC6. ensure proper functioning of stop motions, Back Rest, Shedding etc., so that fabrics are free from defects like starting mark, bad shedding etc. | 4 | 2 | 2 | 0 |
| PC7. maintain temple setting , reed setting so that fabrics don’t get rejected for reasons like “temple cut”, “temple mark”, “Reed mark” | 5 | 3 | 2 | 0 |
| PC8. attend the other fabric defects like “ Drop Pick” , “ Cloth Torn”, “ Weft Stitches” “ floats” “ etc. | 5 | 3 | 2 | 0 |
| PC9. attend excessive weft breaks | 4 | 3 | 1 | 0 |
| PC10. attend to Weft Transfer failures | 3 | 2 | 1 | 0 |
| PC11. attend excessive warp breaks | 3 | 2 | 1 | 0 |
| PC12. attend to loom stoppages due to “ Projectile getting Jammed “ | 3 | 2 | 1 | 0 |
| PC13. see that the condition of Heald wires, Heald Frames , reed etc. are in good condition | 5 | 3 | 2 | 0 |
| PC14. see that the loom runs with the actual required belts and should see that there is no slippage in the same, so as to ensure that the loom works in the recommended speed | 3 | 2 | 1 | 0 |
| PC15. see that replenishment of spares or attending to break downs is done in the prescribed time. | 4 | 3 | 1 | 0 |
| PC16. ensure required humidity in the loom shed | 3 | 2 | 1 | 0 |
| PC17. check the knotted looms & ensure that knotting is carried out without cross ends | 4 | 3 | 1 | 0 |
| PC18. check the sort change loom & ensure that drawing & reaching was carried out without any cross ends | 4 | 3 | 1 | 0 |
| PC19. ensure “ Loom Breakage Study” and check the quality of both warp & weft yarn. For any deviation the same has to be brought to the knowledge of the higher authority | 3 | 2 | 1 | 0 |
| PC20. check the Sizing quality and for any deviation , the same has to be brought to the notice of the higher authority | 5 | 3 | 2 | 0 |
| PC21. ensure proper dropper cleaning | 4 | 3 | 1 | 0 |
| PC22. ensure that the looms are cleaned properly as per the below schedule  a) Daily cleaning b) Cleaning during Knottings c) Cleaning during Sort Changes | 6 | 3 | 2 | 1 |
| PC23. carry out preventive maintenance as per the schedule | 3 | 2 | 1 | 0 |
| PC24. ensure the life of all the spares through effective maintenance | 4 | 3 | 1 | 0 |
| PC25. To maintain “ Spare Changing Details ” note, for the following details. a) Loom No. b) Name Of The Spare c) Side ( If any) d) Part No. e) Name Of the Supplier f) Make g) Date of Application h) Date Of Removal i) Reason For Removal j) Life Of Item | 6 | 3 | 2 | 1 |
| PC26. To salvage the “ Broken Spare “ & to avail new spare, only after producing the “ Old Spare to the Stores | 4 | 3 | 1 | 0 |
| PC27. To maintain “ Sort Muster” as per the below details a) Loom No. b) Construction Details c) Warp Material details d) Warp Count e) Warp Mill Name f) Warp Yarn Test Report( Test Parameters) g) Reed Used h) Total Ends Used i) Name Of The Sizing j) Warping Breakage Rate k) Average Warp Count l) Size Pick Up m) Warp break/ loom hour  n) Weft Material Details o) Weft Count p) Weft Mill Name q) Weft Yarn Test Report( Test Parameters) r) Reed Space s) Weft breakage per loom hour] t) Average Loom Efficiency u) Loom Speed v) Average Production in Kilo Picks/loom day w) Production in mtrs/loom day x) Date of knotting y) Knotted mtrs z) Date of exhaustion aa) Produced mtrs bb) Warp Crimp cc) Warp Consumption/mtr ( Excluding Size Add On) dd) Warp Wt in kgs/ mtr ( Including Size add on) ee) Weft Consumption/mtr ff) Total cloth wt in kgs/ mtr gg) GSM hh) Fabric doffed ii) Fabric inspected jj) Fabric Passed kk) Fabric Rejected ll) Rejection % mm) Reason For Rejection nn) Warp Waste % oo) Weft Waste % | 7 | 3 | 2 | 2 |
| PC28. maintain effective working of “Generator” | 3 | 2 | 1 | 0 |
| PC29. see that “ Air” is not misused Can use air for cleaning, only in the areas, where it is allowed | 3 | 2 | 1 | 0 |
| PC30. ensure proper maintenance of “Air Compressor” | 4 | 3 | 1 | 0 |
| PC31. Should ensure that " Loom Cards " for all the required details are placed on all the looms a) Loom No. b) Construction details c) Reed Count d) Reed Space e) Weft Count f) Pick Wheel g) Winding Spindle No.  h) Drawing Method | 5 | 3 | 2 | 0 |
| PC32. see that the weft yarn is completely used , without giving room for additional wastage of raw materials. For any quality issue or defective cone etc., the same has to be brought to the notice of the Superiors | 4 | 3 | 1 | 0 |
| PC33. To maintain “Knotting Entry Note” with the following details a) Loom No. b) Construction Details c) Date Of Knotting d) Time of Exhaustion e) Cleaning Completed Time f) Beam Loading Completed Time g) Knotting Completed Time h) Loom Run Time i) Total Stopped Time For Knotting j) Name Of the Sizing k) Set No. l) Beam Nos. m) Beam Mtrs n) Old Warp Waste kgs o) New Warp Waste kgs p) Cleaning Quality q) Knotting Quality | 7 | 3 | 3 | 1 |
| PC34. ensure Relative Humidity in the Department is maintained | 3 | 2 | 1 | 0 |
| PC35. ensure correct quality of thrums are there & see that the same are properly tied | 3 | 2 | 1 | 0 |
| PC36. check the knotted loom for knotting quality etc. Double ends have to be removed. Report to Superiors for any deviation in the same & for any other quality issue | 5 | 3 | 2 | 0 |
| PC37. Check all the safety covers are placed | 2 | 1 | 1 | 0 |
| PC38. ensure that cloth rolls are doffed whenever/ wherever necessary | 2 | 1 | 1 | 0 |
| PC39. ensure that no raw material/ cloth/ spare/ tool / any other material is thrown under/ near the machines or in the other work areas. |  | 4 | 3 | 1 | 0 |
|  |  | 150 | 96 | 49 | 5 |
| **Total** | **Weightage %** |  | 64% | 33% | 3% |
|  | | | | | | |
| **3.TSC/N9001(Maintaining work area, tools and machines)** | PC1. handle materials, machinery, equipment and tools with care and use them in the correct way | **50** | 4 | 1 | 2 | 1 |
| PC2. use correct lifting and handling procedures | 4 | 1 | 2 | 1 |
| PC3. use materials to minimize waste | 3 | 1 | 1 | 1 |
| PC4. maintain a clean and hazard free working area | 3 | 1 | 1 | 1 |
| PC5. maintain tools and equipment | 4 | 2 | 1 | 1 |
| PC6. carry out running maintenance within agreed schedules | 4 | 1 | 2 | 1 |
| PC7. carry out maintenance and/or cleaning within one’s responsibility | 4 | 1 | 2 | 1 |
| PC8. report unsafe equipment and other dangerous occurrences | 4 | 1 | 2 | 1 |
| PC9. ensure that the correct machine guards are in place | 3 | 1 | 1 | 1 |
| PC10. work in a comfortable position with the correct posture | 3 | 1 | 1 | 1 |
| PC11. use cleaning equipment and methods appropriate for the work to be carried out | 3 | 1 | 1 | 1 |
| PC12. dispose of waste safely in the designated location | 4 | 1 | 2 | 1 |
| PC13. store cleaning equipment safely after use | 3 | 1 | 1 | 1 |
| PC14. carry out cleaning according to schedules and limits of responsibility | 4 | 1 | 2 | 1 |
|  | 50 | 15 | 21 | 14 |
| **Total** | **Weightage %** |  | 30% | 42% | 28% |
|  |  |  |  |  |  |  |
| **4.TSC/N9002 (Working in a team)** | PC1. be accountable to the own role in whole process | **50** | 5 | 3 | 1 | 1 |
| PC2. perform all roles with full responsibility | 4 | 2 | 1 | 1 |
| PC3. be effective and efficient at workplace | 4 | 1 | 2 | 1 |
| PC4. properly communicate about company policies | 4 | 1 | 1 | 2 |
| PC5. report all problems faced during the process | 4 | 1 | 1 | 2 |
| PC6. talk politely with other team members and colleagues | 4 | 1 | 1 | 2 |
| PC7. submit daily report of own performance | 5 | 2 | 2 | 1 |
| PC8. adjust in different work situations | 4 | 2 | 1 | 1 |
| PC9. give due importance to others’ point of view | 4 | 1 | 1 | 2 |
| PC10. avoid conflicting situations | 4 | 1 | 2 | 1 |
| PC11. develop new ideas for work procedures | 4 | 1 | 2 | 1 |
| PC12. improve upon the existing techniques to increase process efficiency | 4 | 1 | 2 | 1 |
|  | 50 | 17 | 17 | 16 |
| **Total** | **Weightage %** | 50 | 34.00% | 34.00% | 32.00% |
|  | | | | | | |
| **5.TSC/N9003 (Comply with health, safety and security at work place)** | PC1. comply with health and safety related instructions applicable to the workplace | **100** | 5 | 2 | 2 | 1 |
| PC2. use and maintain personal protective equipment such as “ ear plug” “ nose mask “ “ head cap” etc., as per protocol | 5 | 2 | 2 | 1 |
| PC3. carry out own activities in line with approved guidelines and procedures | 4 | 2 | 1 | 1 |
| PC4. maintain a healthy lifestyle and guard against dependency on intoxicants | 4 | 2 | 1 | 1 |
| PC5. follow environment management system related procedures | 4 | 2 | 1 | 1 |
| PC6. identify and correct (if possible) malfunctions in machinery and equipment | 5 | 2 | 2 | 1 |
| PC7. report any service malfunctions that cannot be rectified | 4 | 2 | 1 | 1 |
| PC8. store materials and equipment in line with 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 |
| 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 |
| **Total** | **Weightage %** | 100 | 43% | 34% | 23% |
|  | | | | | | |
| **7.TSC/N9004 (Comply with industry and organizational requirements)** | PC1. perform own duties effectively | **50** | 4 | 1 | 2 | 1 |
| PC2. take responsibility for own actions | 4 | 1 | 2 | 1 |
| PC3. be accountable towards the job role and assigned duties | 4 | 2 | 1 | 1 |
| PC4. take initiative and innovate the existing methods | 3 | 1 | 1 | 1 |
| PC5. focus on self-learning and improvement | 4 | 1 | 2 | 1 |
| PC6. co-ordinate with all the team members and colleagues | 4 | 1 | 2 | 1 |
| PC7. communicate politely | 4 | 1 | 1 | 2 |
| PC8. avoid conflicts and 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 |
|  | 50 | 18 | 19 | 13 |
| **Total** | **Weightage %** | 50 | 36% | 38% | 26% |
|  | **Total** |  | **450** | **220** | **155** | **75** |
| **Grand Total-1 (Subject Domain)** |  | **450** | | | | |