

QUALIFICATIONS PACK - OCCUPATIONAL STANDARDS FOR TEXTILE SECTOR

What are Occupational Standards(OS)?

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

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Introduction

Qualifications Pack – Open End Spinning Tenter

SECTOR: TEXTILE

SUB-SECTOR: SPINNING

OCCUPATION: SPINNING

REFERENCE ID: TSC/ Q0203

ALIGNED TO: NCO-2004 / 8261.90

Brief Job Description:

An open end spinning tenter is responsible for carrying out tenting activities. This activity ensures minimum machine stoppage and maximum production in an open end spinning machine. An open end spinning tenter should be able to creel the sliver cans, piece the sliver on breakage, doff the cone /cheese package and carry out cleaning and preventive maintenance activities thus producing defect free yarn.

This job requires the individual to have thorough knowledge in process flow and material flow in a textile mill for yarn production and should be able to know the important functions and operations of an open end spinning machine.

Personal Attributes: A open end spinning tenter should have good eyesight, hand-eye-leg coordination, motor skills and vision. He/she should also have good interpersonal skills.

Job Details	Qualifications Pack Code	TSC/Q0203		
	Job Role	Open End SpinningTenter		
	Credits (NSQF)	TBD	Version number	1.0
	Sector	Textile	Drafted on	15/12/14
	Sub-sector	Spinning	Last reviewed on	25/02/15
	Occupation	Spinning	Next review date	01/03/16
	Job Role	Open End SpinningTenter		
	Role Description	An open end spinning tenter is responsible for carrying out tenting activities. This activity ensures minimum machine stoppage and maximum production in an open end spinning machine.		
	NSQF level	4		
	Minimum Educational Qualifications	5 th standard, preferably		
	Maximum Educational Qualifications	N/A		
	Training (Suggested but not mandatory)	Not Applicable		
	Experience	Preferably 1-2 years of work experience in a textile mill		
	National Occupational Standards (NOS)	Compulsory: <ol style="list-style-type: none"> TSC/ N0209 Taking charge of shift and handing over shift to Open-End Spinning Tenter TSC/ N0210 Carry out creeling and piecing activities in Open-End Spinning TSC/ N0211 Carryout doffing activities in Open-End Spinning TSC/ N0212 Carryout cleaning and maintenance activities in Open-End Spinning TSC/ N9001 Maintain work area,tools and machines TSC/ N9002 Working in a team TSC/ N9003 Maintain health, safety and security at workplace TSC/ N9004 Comply with industry and organizational requirement Optional: N/A		
	Performance Criteria	As described in the relevant OS units		

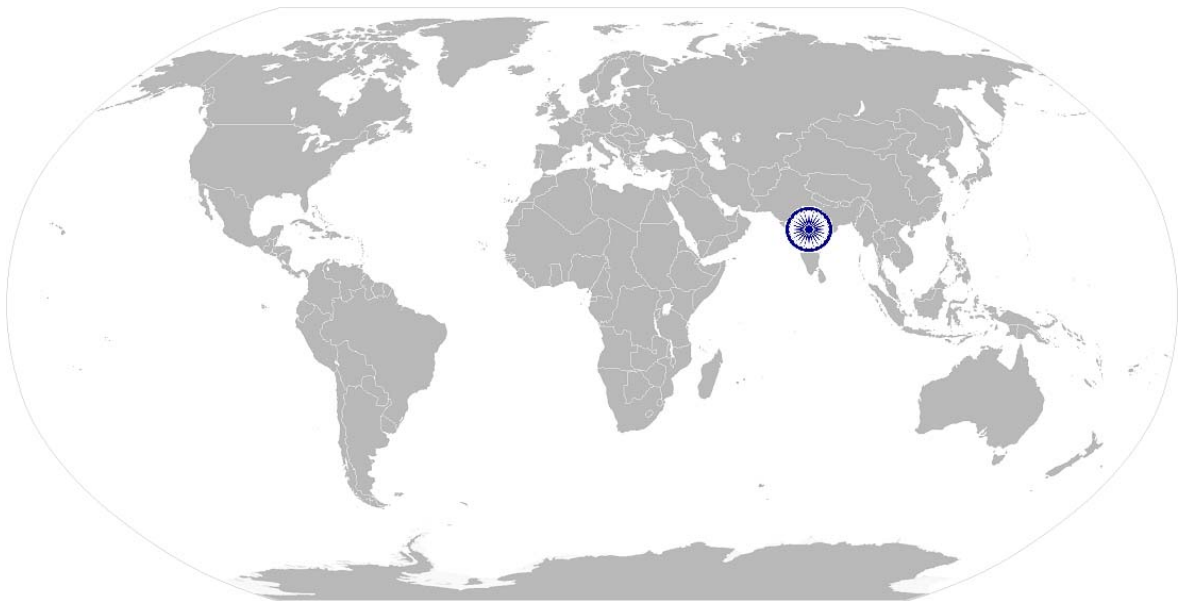
Table 1: Glossary of Key Terms

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

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

TSC/ N0209 Taking charge of shift and handing over shift to Open-End Spinning Tenter

National Occupational Standard



Overview

This unit is about taking charge of shift from previous shift Open-end spinning tenter and relieving the responsibilities to the next shift Open-end spinning tenter.

TSC/N 0209

Taking charge of shift and handing over shift to Open-End Spinning Tenter

Unit Code	TSC/ N0209
Unit Title (Task)	Taking charge of shift and handing over shift to Open-End Spinning Tenter
Description	This unit is about taking charge of shift from previous shift Open-end spinning tenter and relieving the responsibilities to the next shift Open-end spinning tenter
Scope	This unit/task covers the following: <ul style="list-style-type: none"> ▪ Taking charge of shift from Open-end spinning tenter ▪ Handing over shift to Open-end spinning tenter
Elements	performance criteria
Taking charge of shift from Open-end spinning tenter	<p>to be competent you must be able to:</p> <p>PC1. come at least 10 - 15 minutes earlier to the work spot</p> <p>PC2. bring the necessary operational tools to the department</p> <p>PC3. meet the previous shift operator and discuss with him/ her regarding the issues faced by them with respect to the quality, production, spare, safety or any other specific instruction etc.</p> <p>PC4. Understand the count produced, colour coding, followed in the open end spinning for his allocated number of spindles or machines</p> <p>PC5. ensure the technical details are mentioned in the display board in the open end spinning machine</p> <p>PC6. check for the availability of the carded or drawing sliver for creeling</p> <p>PC7. check the availability of sliver cans with technical details mentioned regarding the hank / count being produced</p> <p>PC8. check the yarn passage and OE yarn formation</p> <p>PC9. check for the run outs, availability of sliver cans, ensure that all the rotors and drums are working properly, if not should be enquired, for the reason of idling and report to the superiors regarding the same</p> <p>PC10. check the condition of all running rotors and winding drums</p> <p>PC11. ensure proper functioning of OE machine parts and machine</p> <p>PC12. ensure that all allocated drums / rotors are running with uniform length of yarn on cone, variations if any should be discussed with operator and reported to superiors</p> <p>PC13. check the condition of all winding drums, report to the superior if there is any damage</p> <p>PC14. check the cleanliness of the machines & other work areas</p> <p>PC15. check whether any spare/raw material/ tool / yarn / any other material are thrown under the machines or in the other work areas.</p> <p>PC16. ensure the wastes collection boxes are empty</p> <p>PC17. ensure the work spot is clean</p> <p>PC18. ensure the OHTC is working properly</p> <p>PC19. question the previous shift operator for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as well as that of the previous shift.</p> <p>PC20. take over the shift in a proper manner from the outgoing shift operator</p>
Handing over shift to Open-end spinning	PC21. ensure in providing the details regarding count produced, colour coding followed in the OE for his allocated number of spindles or machines

TSC/N 0209

Taking charge of shift and handing over shift to Open-End Spinning Tenter

tenter	<p>PC22. provide all relevant information regarding the count produced, idle drums, damaged machine parts if any</p> <p>PC23. get clearance from the incoming counterpart before leaving the work spot</p> <p>PC24. report to his/ her shift superiors as well as that of the incoming shift operator in case his/ her counterpart doesn't report for the incoming shift</p> <p>PC25. ensure the shift has to be properly handed over to the incoming shift operator</p> <p>PC26. report to his/ her shift superior about the quality / production / safety issues/ any other issue faced in his/ her shift and should leave the department only after getting concurrence for the same from his/ her superiors</p> <p>PC27. collect the wastes from waste collection bags, weigh them and transport to storage area</p> <p>PC28. ensure the work spot is clean</p>
Knowledge and Understanding (K)	
A. Organizational Context (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning / textile mill</p> <p>KA2. safe working practices to be adopted in spinning / textile mill</p> <p>KA3. quality systems and other processes practiced in the spinning / textile mill</p> <p>KA4. reporting to the supervisor or higher authority in case of emergency</p> <p>KA5. color coding adopted for different counts in the spinning / textile mill</p>
B. Technical Knowledge	<p>KB1. understanding the importance of :</p> <ul style="list-style-type: none"> • types of fibres • types of yarn • yarn count • types of yarn defects <p>KB2. process flow in a spinning / textile mill</p> <p>KB3. material flow in a spinning / textile mill</p> <p>KB4. importance of mixing, count change</p> <p>KB5. functions of different parts of OE machine</p> <p>KB6. guidelines for operating the OE machine</p> <p>KB7. functions of different signal lamps</p> <p>KB8. guidelines for taking charge of shift from previous shift Open-end spinning tenter</p> <p>KB9. knowledge of waste collection system & equipments used</p> <p>KB10. importance of cleanliness at workplace</p> <p>KB11. importance of material handling and types of material handling equipments used</p> <p>KB12. functions and methodology for operating different material handling equipments</p>
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	<p>You need to know and understand how to:</p> <p>SA1. Write clear and short sentences</p>
	Reading Skills
	<p>SA2. comprehend written instructions</p>

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Taking charge of shift and handing over shift to Open-End Spinning Tenter

B. Professional Skills	Oral Communication (Listening and Speaking skills)
	SA3. communicate with supervisor appropriately
	SA4. talk to others to convey information effectively
	Problem Solving
	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
	Attention to Detail
	SB1. apply good attention to detail
	SB2. check your work is complete and free from errors
	You need to know and understand :
	SB3. procedure to patrol around the OE machine
	SB4. procedure to identify sliver breakage, yarn breakage, sliver exhaust
	SB5. procedure for operating different material handling tools and equipments
	SB6. procedure for patrolling around the OE department and identifying worn out or damaged machine parts
	SB7. procedure to check the quality of sliver in sliver cans, OE yarn, proper functioning of machine parts in OE machine
	SB8. maintain neatness at work place

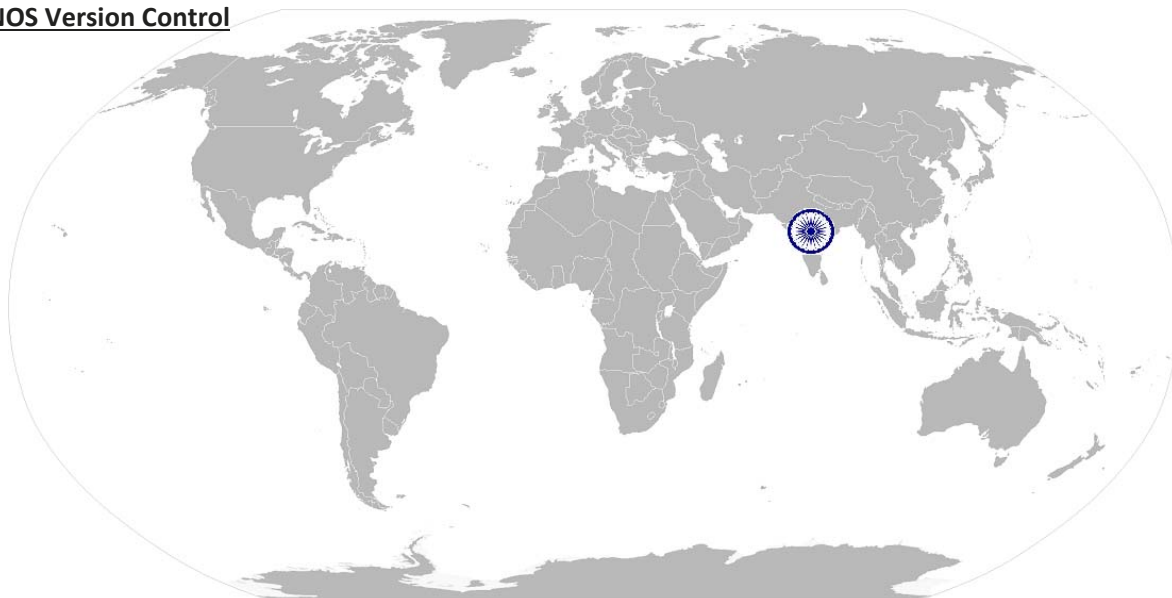


TSC/N 0209

Taking charge of shift and handing over shift to Open-End Spinning Tenter

NOS Code	TSC/ N0209		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16

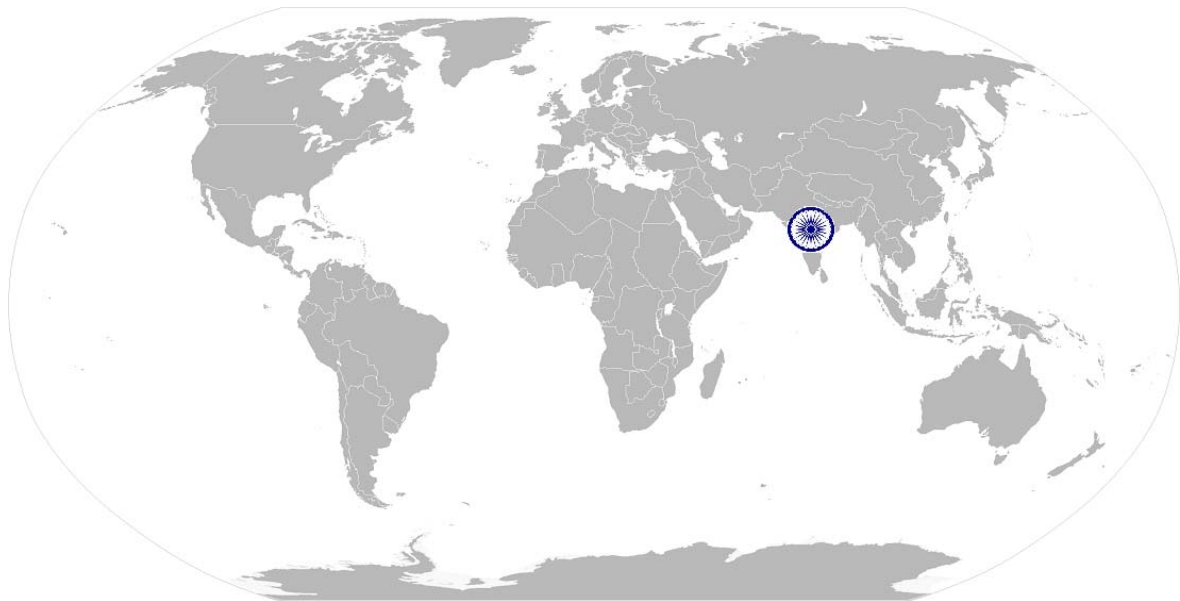
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TSC/N 0210

Carryout creeling and piecing activities in Open-End Spinning

National Occupational Standard



Overview

This unit is about carrying out procedure for creeling the sliver and piecing the sliver and yarn in the event of end breakage.

TSC/N 0210 Carryout creeling and piecing activities in Open-End Spinning

Unit Code	TSC/ N0210
Unit Title (Task)	Carryout creeling and piecing activities in Open-End Spinning
Description	This unit is about carrying out procedure for creeling the sliver and piecing the sliver and yarn in the event of end breakage
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> attending the machine for creeling creeling the sliver attending the machine on sliver breakage feeding / piecing the sliver to rotors attending the breaks and knotting the yarn
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Attending the machine for creeling	<p>To be competent, you must be able to:</p> <p>PC1. understand the mixings, hanks and the colour codification used</p> <p>PC2. bring the sliver cans from storage area</p> <p>PC3. ensure correct colour coded sliver cans are taken to OE section for creeling</p> <p>PC4. identify sliver exhausts and removing the empty sliver cans</p> <p>PC5. ensure minimum time is taken for attending the sliver exhaust or can change</p>
Creeling the sliver	<p>PC6. ensure the correct hank of slivers cans are taken for creeling to OE department</p> <p>PC7. follow proper color coding of sliver cans</p> <p>PC8. creel the required number of cans in an organized manner</p> <p>PC9. ensure proper feeding of sliver into the rotors</p> <p>PC10. feed the slivers to the rotors</p> <p>PC11. ensure the slivers are passed through rotors and yarns are taken out through guides and stop motions</p> <p>PC12. ensure proper material handling of slivers and sliver cans</p>
Attending the machine on sliver breakage	<p>PC13. patrol in the OE machine work area and identify the sliver breakage by viewing in the signal lamps provided at each rotors</p> <p>PC14. identify the reason for stoppage</p> <p>PC15. ensure minimum time is taken for attending the breakage</p>
Feeding / Piecing the sliver to rotors	<p>PC16. ensure the slivers cans are properly and uniformly placed in the creel zone and at proper distance to avoid mix up</p> <p>PC17. ensure that the sliver passes through the rotors without affecting the quality of sliver</p> <p>PC18. ensure proper length of sliver is available from sliver can to rotor tip</p> <p>PC19. feed the sliver end to the rotor</p> <p>PC20. piece the sliver between cans, in the event of sliver exhausting in the sliver can, replace with a full sliver can</p> <p>PC21. ensure standard procedure is adopted for feeding the sliver in rotors</p> <p>PC22. ensure minimum time is taken for piecing the sliver</p> <p>PC23. keep the sliver waste in the respective waste collection box</p>

TSC/N 0210 Carryout creeling and piecing activities in Open-End Spinning

	<p>PC24. segregate the reusable wastes and weigh and record them in a register</p> <p>PC25. ensure safety and cleanliness at work place</p>
Attending the breaks and knotting the yarn	<p>PC26. patrol around the machine to ensure proper production of OE yarn</p> <p>PC27. ensure minimum time is taken for attending the breaks</p> <p>PC28. feed the sliver in the rotors</p> <p>PC29. take the cheese package and identify defects if any</p> <p>PC30. remove defects in the cheese package if any</p> <p>PC31. lift the cheese package from the winding drum</p> <p>PC32. unwind the broken yarn end from the cheese to the rotor section and start new yarn formation</p> <p>PC33. ensure the yarn is formed with required twist</p> <p>PC34. ensure proper material handling of sliver, cheese and yarn</p> <p>PC35. follow proper procedure for piecing the yarn</p> <p>PC36. while processing knotless yarn, broken ends are to be overlapped on the cone/cheese as instructed</p> <p>PC37. ensure proper material handling of cheese and cone package</p> <p>PC38. ensure proper yarn passage & tension variator position post knotting</p> <p>PC39. follow standard procedure for operating material handling tools and knotting equipments</p> <p>PC40. follow safety procedures while carrying out creeling and piecing activities</p> <p>PC41. ensure cleanliness at work place</p>
knowledge and understanding (k)	
A. Organizational Context (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning / textile mill</p> <p>KA2. safe working practices to be adopted in spinning / textile mill</p> <p>KA3. quality systems and other processes practiced in the spinning / textile mill</p> <p>KA4. reporting to the supervisor or higher authority in case of emergency</p> <p>KA5. color coding adopted for different counts in the spinning / textile mill</p>
B. Technical Knowledge	<p>You need to know and understand:</p> <p>KB1. understanding the importance of types of fibres, types of yarn, yarn count, importance of yarn quality, types of yarn defects</p> <p>KB2. process flow in a spinning / textile mill</p> <p>KB3. material flow in a spinning / textile mill</p> <p>KB4. functions of different parts of OE machine</p> <p>KB5. importance of colour coding followed for different counts in spinning / textile mill</p> <p>KB6. importance of creeling</p> <p>KB7. importance of knotting</p> <p>KB8. types of yarn defects</p> <p>KB9. importance of attending breakages and knotting the yarn</p> <p>KB10. guidelines for creeling the sliver and sliver can</p> <p>KB11. guidelines for knotting / mending the yarn</p> <p>KB12. knowledge of waste collection system & equipments used</p> <p>KB13. importance of material handling</p> <p>KB14. types of material handling equipments used</p>

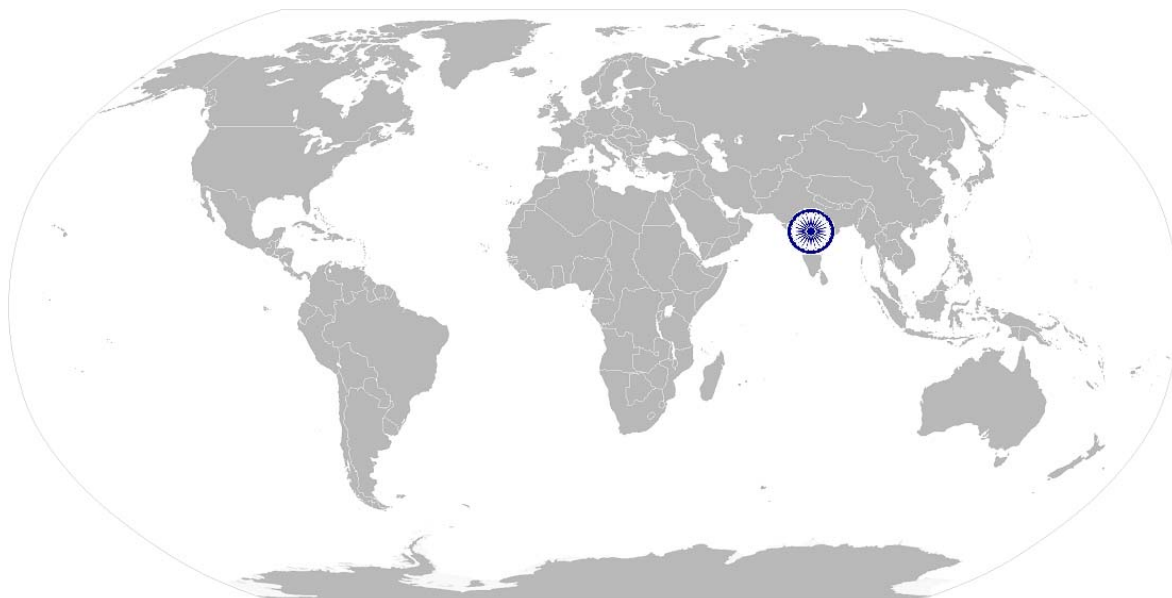
TSC/N 0210 Carryout creeling and piecing activities in Open-End Spinning

	<p>KB15. functions and methodology for operating different material handling equipments</p> <p>KB16. understanding the functions of different signal lamps</p> <p>KB17. importance of safety at workplace</p> <p>KB18. importance of cleanliness at workplace</p>
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to:
	SA1. write clear and short sentences
	Reading Skills
	SA2. comprehend written instructions
B. Professional Skills	Oral Communication (Listening and Speaking skills)
	SA3. communicate with supervisor appropriately
	SA4. talk to others to convey information effectively
	Problem Solving
	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
	Attention to Detail
	You need to know and understand how to:
	SB1. apply good attention to detail
	SB2. check your work is complete and free from errors
	You need to know and understand :
	SB3. procedure for patrolling in the OE work area
	SB4. patrol around the OE machine and identify sliver / yarn breakage and sliver exhaust
	SB5. procedure for material handling of sliver, sliver can& cheese package
	SB6. standard operating procedure for creeling the sliver
	SB7. standard operating procedure for knotting / mending for yarn formation
	SB8. procedure for removing the damages in cheese package
	SB9. procedure for operating different material handling tools and equipments
	SB10. maintain neatness at work place

TSC/N 0210 Carryout creeling and piecing activities in Open-End Spinning

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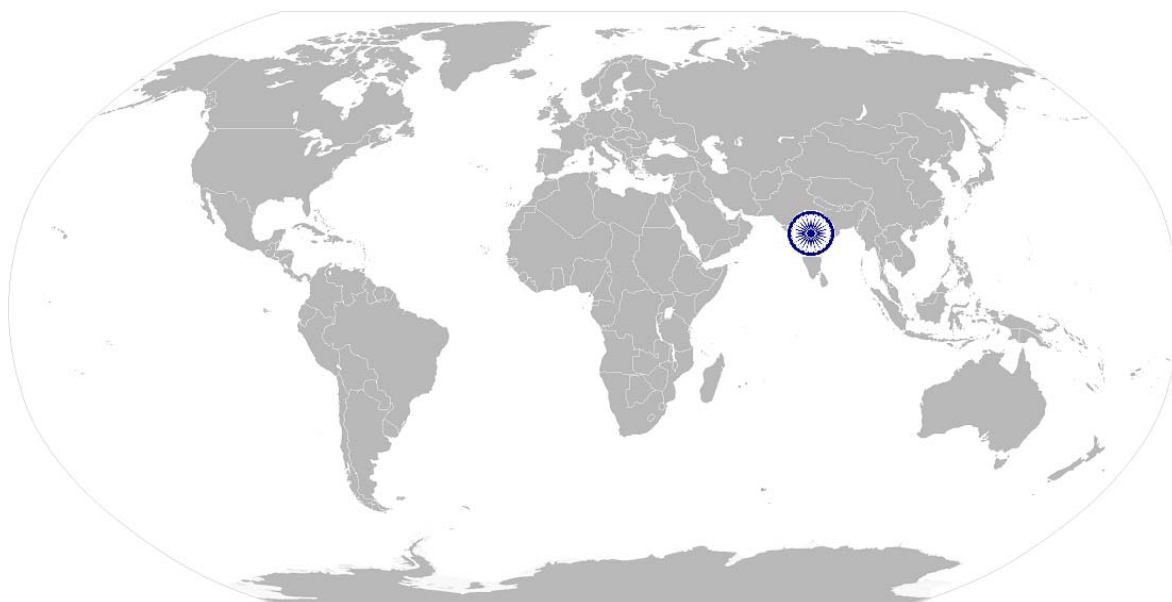
NOS Code	TSC/ N0210		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16



TSC/N 0211

Carry out doffing activities in Open-End Spinning

National Occupational Standard



Overview

This unit is about carrying out the doffing activities in an OE machine

TSC/N 0211

Carry out doffing activities in Open-End Spinning

Unit Code	TSC/N 0211
Unit Title (Task)	Carry out doffing activities in Open-End Spinning
Description	This unit is about carrying out the doffing activities in an OE machine
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> identify the machine for carrying out doffing activity doffing the cheese package weigh and store the cheese package restart the machine after doffing
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Identify the machine for carrying out doffing	<p>To be competent, you must be able to:</p> <p>PC1. follow the plan as instructed by superior for performing doffing activities at various machines in OE department</p> <p>PC2. identify which machine is ready for doffing</p> <p>PC3. ensure minimum time is taken for identifying the machine to carryout doffing activity</p> <p>PC4. ensure in confirming the machine with the superiors for carrying out doffing activity</p>
Doffing the cheese package	<p>PC5. check that the cheese package is fully wound to the predetermined length or weight and start doffing</p> <p>PC6. remove full cheese package from cone holder</p> <p>PC7. keep doffed cheese package in the peg trolley</p> <p>PC8. either stop the machine for doffing or doff the cone package while the machine is running as per the instructions of the supervisor</p> <p>PC9. ensure proper procedure is adopted for doffing the cheese package</p> <p>PC10. ensure proper material handling of cheese package</p> <p>PC11. ensure safety while carrying out doffing activity</p>
Weigh and store the cheese package	<p>PC12. weigh the cheese package and ensure the required weight have been achieved</p> <p>PC13. fix the cheese in the cheese holder and run it again till the cheese reaches the predetermined weight as instructed by superiors</p> <p>PC14. place the cheese in the cheese trolley and store in the storage area as instructed</p> <p>PC15. keep empty paper cheese ready in the reserve area for doffing</p>
Restart the machine after doffing	<p>PC16. insert the empty cheese into the cheese holder after doffing</p> <p>PC17. ensure that proper colour coded empty paper cone is mounted in holder</p> <p>PC18. follow the instructions of the superiors for count change</p> <p>PC19. ensure proper passage of yarn in OE machine</p> <p>PC20. ensure that all the rotors are running, and piece the ends once machine is restarted</p> <p>PC21. remove all the wastes and store it count wise in the waste collection box</p>
Knowledge and Understanding (K)	
A. Organizational	You need to know and understand:

TSC/N 0211

Carry out doffing activities in Open-End Spinning

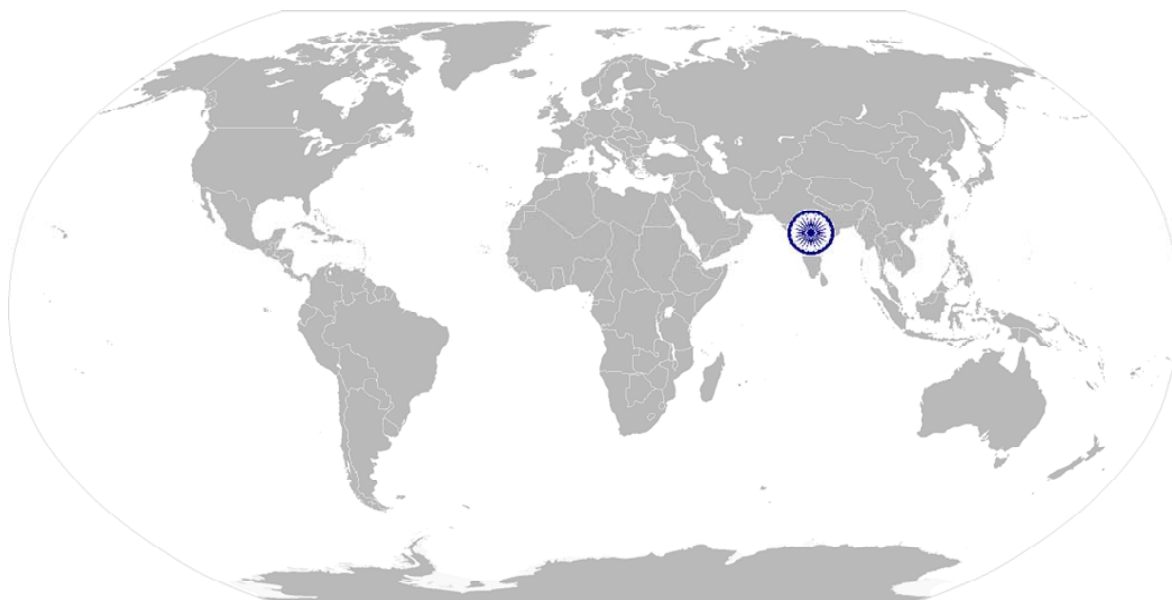
Context (Knowledge of the company/ organization and its processes)	<p>KA1. standard operating procedures (SOP) and regulations in a spinning/ textile mill</p> <p>KA2. safe working practices to be adopted in spinning / textile mill</p> <p>KA3. quality systems and other processes practiced in the spinning /textile mill</p> <p>KA4. reporting to the supervisor or higher authority in case of emergency</p> <p>KA5. color coding adopted for different counts in the spinning/ textile mill</p>
B. Technical Knowledge	<p>You need to know and understand:</p> <p>KB1. process flow and material flow in a spinning / textile mill</p> <p>KB2. understand the types of roving defects and reason for roving breakage</p> <p>KB3. functions of different parts of a OE machine</p> <p>KB4. functions of different signal lamps and control buttons</p> <p>KB5. knowledge about the schedule for carrying out doffing activity</p> <p>KB6. various type of yarn defects</p> <p>KB7. importance of doffing</p> <p>KB8. importance of material handling</p> <p>KB9. various tools and equipments used for doffing</p> <p>KB10. guidelines for carrying out doffing activity</p> <p>KB11. knowledge of waste collection system & material handling equipments used</p> <p>KB12. safety procedures to be followed in a OE machine</p> <p>KB13. importance of cleanliness and safety at work place</p>
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to:
	SA1. write clear and short sentences
	Reading Skills
	SA2. comprehend written instructions
	Oral Communication (Listening and Speaking skills)
	<p>SA3. communicate with supervisor appropriately</p> <p>SA4. talk to others to convey information effectively</p> <p>You need to know and understand :</p> <p>SA5. standard operating procedure for carrying out doffing activity</p> <p>SA6. procedure to inspect the cheese package and identify defects in cheese</p> <p>SA7. procedure to identify the cone defects</p> <p>SA8. procedure for handling of cone and cone trolley</p> <p>SA9. procedure for disposing the waste.</p> <p>SA10. maintain neatness at work place</p>

TSC/N 0211

Carry out doffing activities in Open-End Spinning

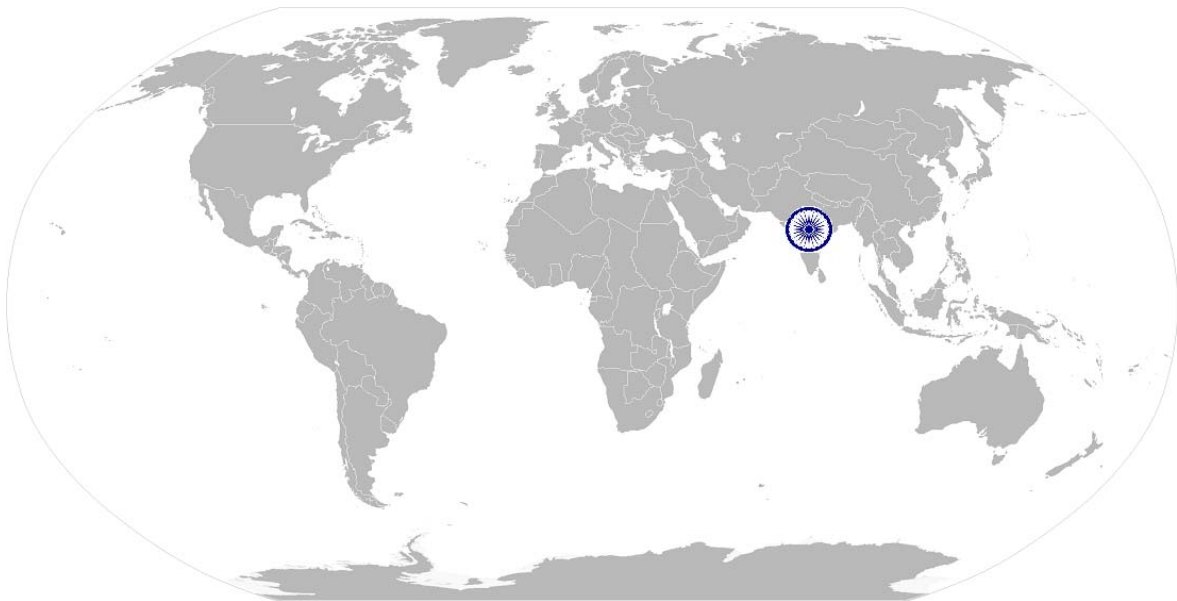
NOS Version Control

NOS Code	TSC/N 0211		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16



TSC/ N0212 Carryout cleaning and maintenance activities in Open-End Spinning

National Occupational Standard



Overview

This unit is about carrying out the cleaning and maintenance activities in an open end spinning machine.

TSC/ N0212 Carryout cleaning and maintenance activities in Open-End Spinning

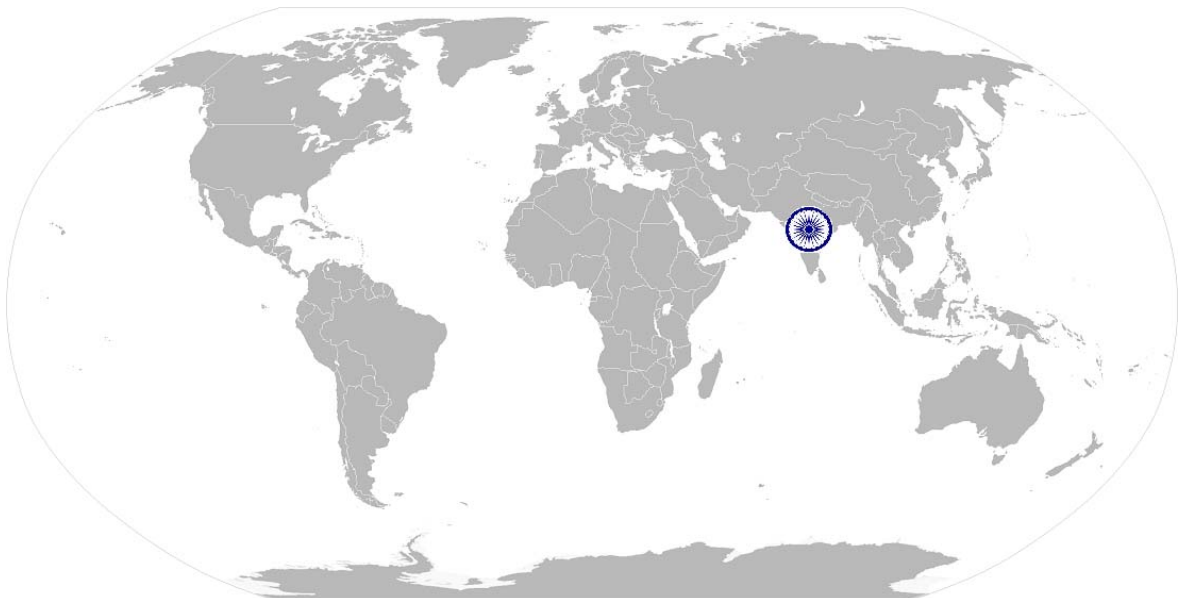
Unit Code	TSC/ N0212
Unit Title(Task)	Carryout cleaning and maintenance activities in Open-End Spinning
Description	This unit is about carrying out the cleaning and maintenance activities on an open end spinning machine
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> ▪ carryout cleaning & maintenance activities ▪ carryout preventive maintenance activities ▪ other tenting responsibilities
Performance Criteria (PC) w.r.t. the Scope	
Elements	PerformanceCriteria
Carry out cleaning & maintenance activities	<p>To be competent, you must be able to:</p> <p>PC1. schedule the cleaning and maintenance activities</p> <p>PC2. carry out cleaning and maintenance activities</p> <p>PC3. clean the creeling area</p> <p>PC4. ensure cleanliness in the yarn passage</p> <p>PC5. clean the rotor at regular intervals</p> <p>PC6. failure of stop motion, breakdown should be reported to superiors immediately</p> <p>PC7. ensure proper cleaning of different mechanisms in OE machine</p> <p>PC8. dispose the sliver wastes& yarn waste in the waste collection pocket provided to each tenter and finally disposing in the waste collection box</p> <p>PC9. remove the cleaned wastes and store in separate area</p> <p>PC10. clean the alley around the OE machine using proper cleaning equipments</p> <p>PC11. ensure the wastes collected from different parts of machine are deposited in the respective dustbins</p> <p>PC12. ensure the OE department is neat and clean</p>
Carry out preventive maintenance activities	<p>PC13. ensure proper functioning of machine</p> <p>PC14. check and verify the quality of different machine parts</p> <p>PC15. ensure taking care of yarn passage, rotors, guides, winding drums</p> <p>PC16. support fitter in removing the worn out parts and replace them with new parts in OE machine</p> <p>PC17. oil different parts of OE machine on need basis</p> <p>PC18. check OHTC air blowing</p> <p>PC19. check bottom apron, top apron, spacer etc</p> <p>PC20. check for damaged bobbins and discard them</p> <p>PC21. report to the supervisor and maintenance fitter if any problem is noticed in smooth functioning of machine</p> <p>PC22. ensure the OHTC is working.</p> <p>PC23. carry out preventive maintenance activities at the specified intervals</p>
Other tenting responsibilities	<p>PC24. during count change check the count board for cheese colour, cone tip colour and any other given instructions</p> <p>PC25. record the production details in the production report</p> <p>PC26. report to the supervisor in case of emergency stoppage of machine</p> <p>PC27. report to the supervisor and maintenance in charge if the operator was able</p>

TSC/ N0212 Carryout cleaning and maintenance activities in Open-End Spinning

	<p>to replace the worn out machine part with a new one.</p> <p>PC28. support the maintenance team while machine is under maintenance</p> <p>PC29. ensure all details related to production are provided to the next shift operator while relieving</p> <p>PC30. ensure count wise storage of damaged cheese in a separate area</p>
Knowledge and Understanding (K)	
A. Organizational Context (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. standard operating procedures (SOP) and regulations in a spinning / textile mill</p> <p>KA2. safe working practices to be adopted</p> <p>KA3. quality systems and other processes practiced in the spinning / textile mill</p> <p>KA4. report to the supervisor or higher authority in case of emergency</p>
B. Technical Knowledge	<p>You need to know and understand:</p> <p>KB1. process flow and material flow in a spinning / textile mill</p> <p>KB2. functions of various parts of an OE machine</p> <p>KB3. importance of yarn quality</p> <p>KB4. importance of machine cleaning</p> <p>KB5. schedule for machine cleaning</p> <p>KB6. types and functions of various cleaning tools and equipments</p> <p>KB7. guidelines for cleaning various part of OE machine</p> <p>KB8. operational schedule for cleaning different parts of an OE machine</p> <p>KB9. guidelines for carrying out routine preventive maintenance activities</p> <p>KB10. types of end breaks and reason for end breaks</p> <p>KB11. knowledge of the types of oil used for preventive maintenance</p> <p>KB12. knowledge of the safety precautions to be followed in a open end spinning department</p>
Skills (S)	
A. Core Skills/ Generic Skills	Writing Skills
	You need to know and understand how to:
	SA1. write clear and short sentences
	Reading Skills
	SA2. comprehend written instructions
	Oral Communication (Listening and Speaking skills)
	SA3. communicate with supervisor appropriately
	SA4. talk to others to convey information effectively
	You need to know and understand :
	SA5. procedure for operating various cleaning tools and equipments
	SA6. procedure for cleaning the creeling area
	SA7. procedure for cleaning different mechanisms in OE machine
	SA8. procedure for proper material handling of cleaning equipments and maintenance tools
	SA9. procedure to identify and remove worn out parts in OE machine
	SA10. procedure to replace the worn out part/parts with new machine part/parts

TSC/ N0212 Carryout cleaning and maintenance activities in Open-End Spinning

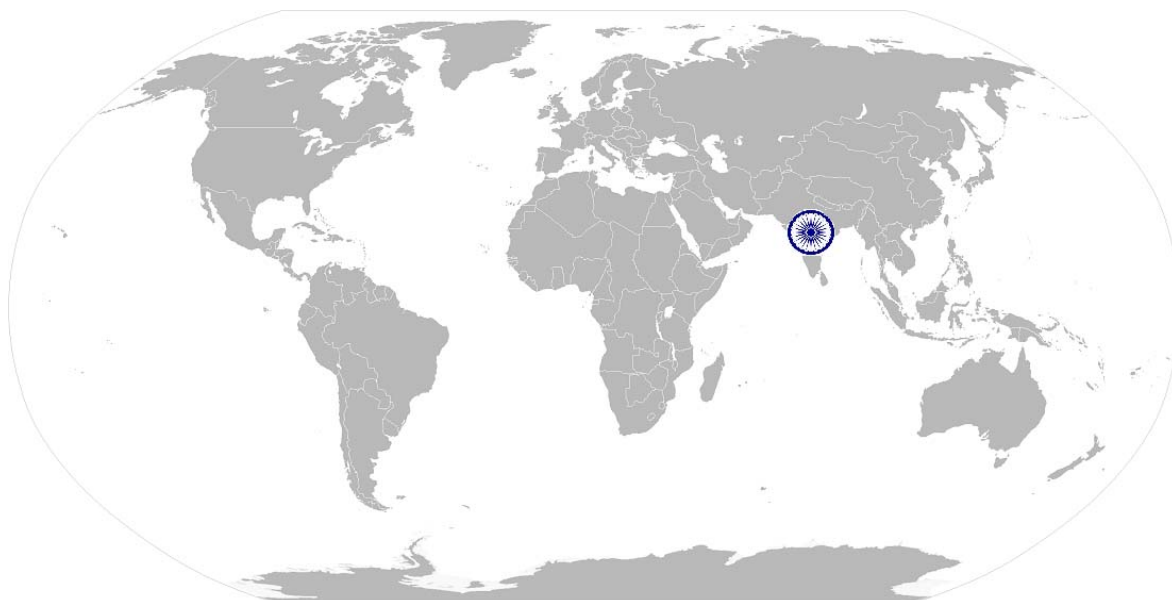
- | | |
|--|--|
| | <p>SA11. procedure for carrying out preventive maintenance activities</p> <p>SA12. procedure for oiling various parts of OE machine</p> <p>SA13. maintain neatness at work place</p> |
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TSC/ N0212 Carryout cleaning and maintenance activities in Open-End Spinning

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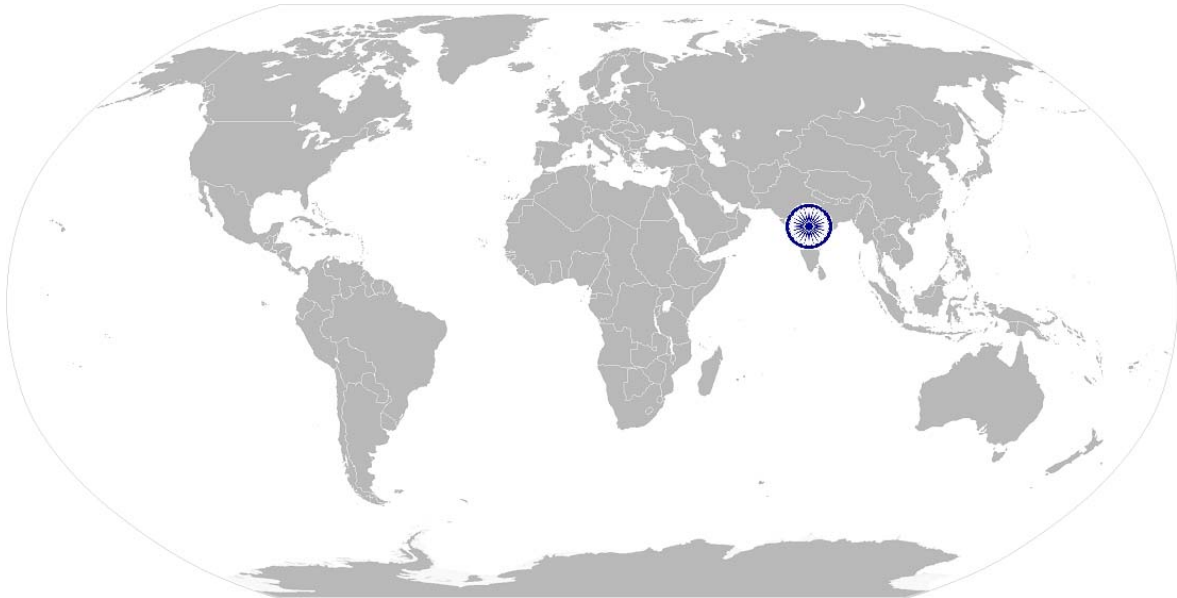
NOS Code	TSC/ N0212		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16



TSC/ N9001

Maintain work area, tools and machines

National Occupational Standard



Overview

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

TSC/ N9001

Maintain work area, tools and machines

National Occupational Standard

Unit Code	TSC/ N9001
Unit Title (Task)	Maintain work area, tools and machines
Description	This unit provides performance criteria, knowledge & understanding and skills & abilities required to organize/ maintain work areas and activities to ensure tools and machines are maintained as per norms
Scope	This unit/task covers the following: <ul style="list-style-type: none"> maintain the work area, tools and machines
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Maintain the work area, tools and machines	<p>To be competent, you must be able to:</p> <p>PC1. handle materials, machinery, equipment and tools with care and use them in the correct way</p> <p>PC2. use correct lifting and handling procedures</p> <p>PC3. use materials to minimize waste</p> <p>PC4. maintain a clean and hazard free working area</p> <p>PC5. maintain tools and equipment</p> <p>PC6. carry out running maintenance within agreed schedules</p> <p>PC7. carry out maintenance and/or cleaning within one's responsibility</p> <p>PC8. report unsafe equipment and other dangerous occurrences</p> <p>PC9. ensure that the correct machine guards are in place</p> <p>PC10. work in a comfortable position with the correct posture</p> <p>PC11. use cleaning equipment and methods appropriate for the work to be carried out</p> <p>PC12. dispose off waste safely in the designated location</p> <p>PC13. store cleaning equipment safely after use</p> <p>PC14. carry out cleaning according to schedules and limits of responsibility</p>
Knowledge and Understanding (K)	
A. Organizational Context (Knowledge of the company/ organization and its processes)	<p>You need to know and understand:</p> <p>KA1. personal hygiene and duty of care</p> <p>KA2. organization's standard operating procedures (SOP)</p> <p>KA3. limits of your own responsibility</p> <p>KA4. ways of resolving 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. Technical Knowledge	<p>You need to know and understand:</p> <p>KB1. work instructions and specifications and interpret them accurately</p> <p>KB2. relation between work role and the overall manufacturing process</p>

TSC/ N9001

Maintain work area, tools and machines

	<p>KB3. hazards likely to be encountered when conducting routine maintenance</p> <p>KB4. the importance of taking action when problems are identified</p> <p>KB5. different ways of minimizing waste</p> <p>KB6. the importance of running maintenance and regular cleaning</p> <p>KB7. effects of contamination on products i.e. machine oil, dirt, foreign materials</p> <p>KB8. common faults with equipment and the method to rectify</p> <p>KB9. maintenance procedures</p> <p>KB10. different types of cleaning equipment and substances and their use</p> <p>KB11. safe working practices for cleaning and the method of carrying them out</p>
Skills (S)	
A. Core Skills/ Generic Skills	Reading Skills
	You need to know and understand how to:
	SA1. comprehend written instructions
	SA2. read any application sent by other colleagues
	Oral Communication (Listening and Speaking skills)
	You need to know and understand how to:
	SA3. Communicate effectively in local language
	SA4. communicate with supervisor appropriately
B. Professional Skills	SA5. talk to others to convey information effectively
	Problem Solving
	You need to know and understand how to:
	SB1. identify the real reason of problem faced
	SB2. apply problem-solving approaches in different situations
	SB3. refer anomalies to the supervisor
	SB4. seek clarification on problems from others
	Attention to Detail
	You need to know and understand how to:
	SB5. apply good attention to detail
	SB6. check your work is complete and free from errors
	SB7. make sure every kind of communication is error free
	You need to know and understand :
	SB8. communicate effectively
	SB9. apply leadership skills wherever required
	SB10. take initiative at the right place
	SB11. understand the requirement to be creative

TSC/ N9001

Maintain work area, tools and machines

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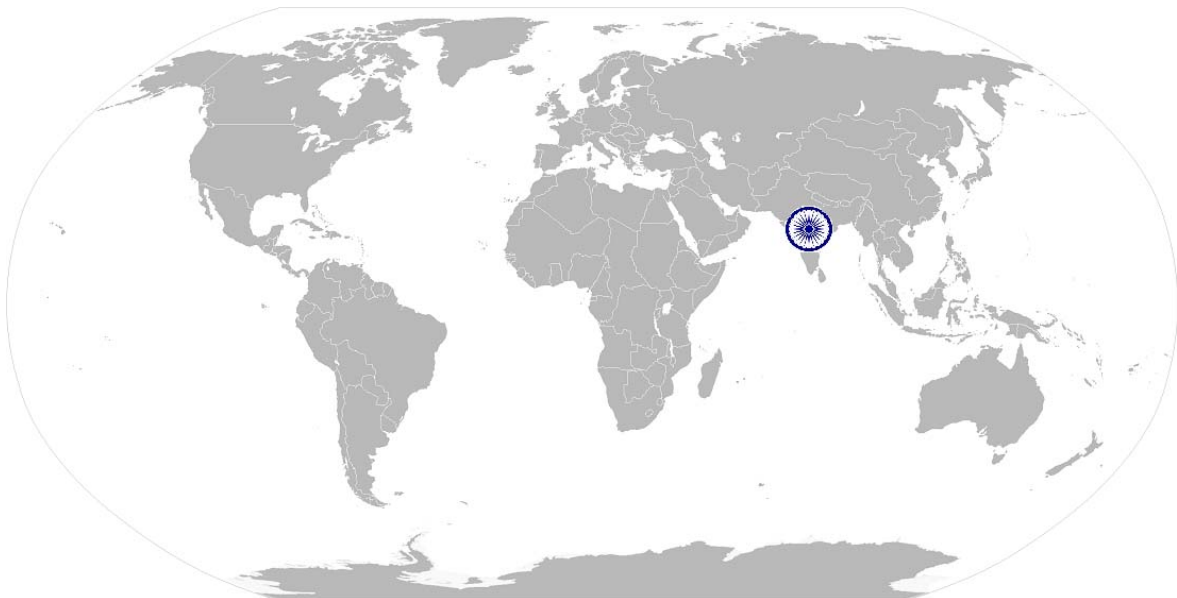
NOS Code	TSC/ N9001		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16



TSC/ N9002

Working in a team

National Occupational Standard



Overview

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

TSC/ N9002

Working in a team

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

TSC/ N9002

Working in a team

	SA3. write grievance complaint application
	Reading Skills
	SA4. comprehend written instructions SA5. read any application sent by other colleagues
	Oral Communication (Listening and Speaking skills)
	SA6. communicate with supervisor appropriately SA7. talk to co-workers to convey information effectively
B. Professional Skills	Problem Solving
	You need to know and understand how to: SB1. identify the real reason of problem faced SB2. be able to find the most effective solution to the problems faced
	Attention to Detail
	SB3. apply good attention to detail SB4. ensure every kind of communication is error free
	You need to know and understand how to: SB5. communicate effectively SB6. apply leadership skills wherever required SB7. take initiative at the right place SB8. understand the requirement to be creative

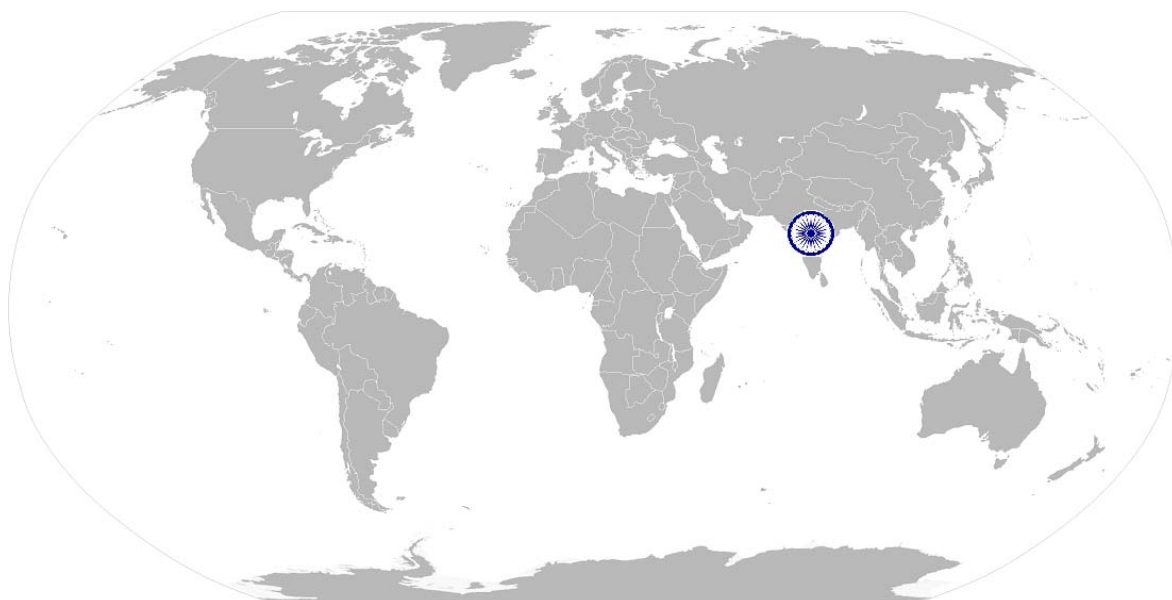


TSC/ N9002

Working in a team

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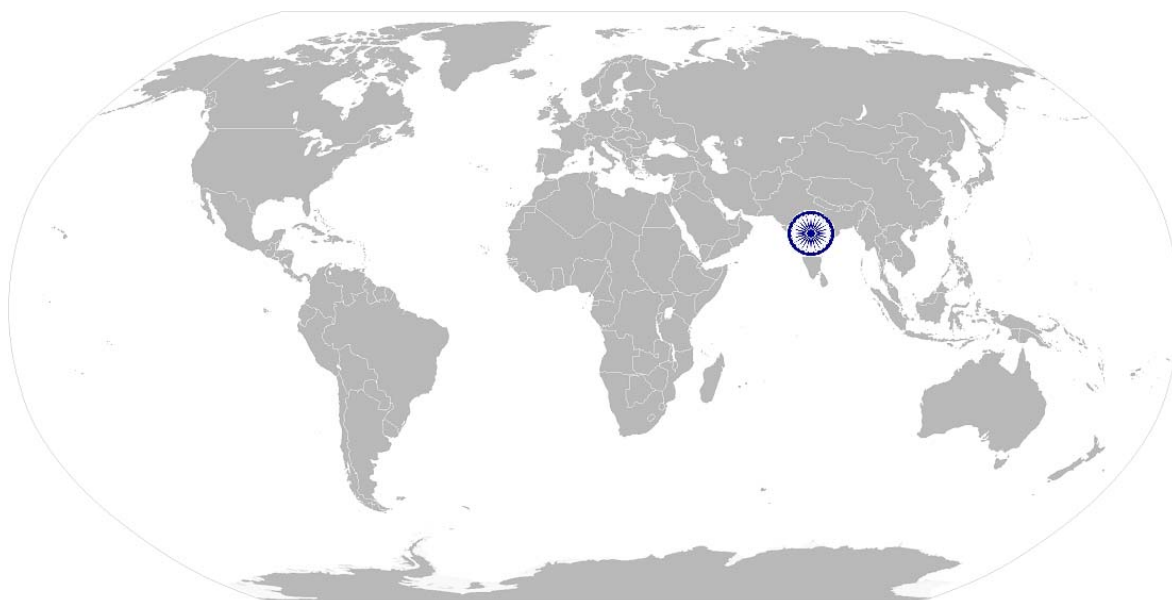
NOS Code	TSC/ N9002		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16



TSC/ N9003

Maintain health, safety and security at work place

National Occupational Standard



Overview

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

TSC/ N9003

Maintain health, safety and security at work place

National Occupational Standard

Unit Code	TSC/ N9003
Unit Title (Task)	Maintain health, safety and security at work place
Description	This unit provides performance criteria, knowledge & understanding and skills & abilities required to comply with health, safety and security requirements at the workplace and covers procedures to prevent, control and minimize risk to self and others.
Scope	<p>This unit/task covers the following:</p> <ul style="list-style-type: none"> Comply with health, safety and security requirements at work Recognizing the hazards Planning the safety techniques Implementing the programs
Performance Criteria (PC) w.r.t. the Scope	
Elements	Performance Criteria
Comply with health, Safety and security requirements at work	<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>PC19. identify different kinds of possible hazards (environmental, personal, ergonomic, chemical) of the industry</p> <p>PC20. recognise other possible security issues existing in the workplace</p>

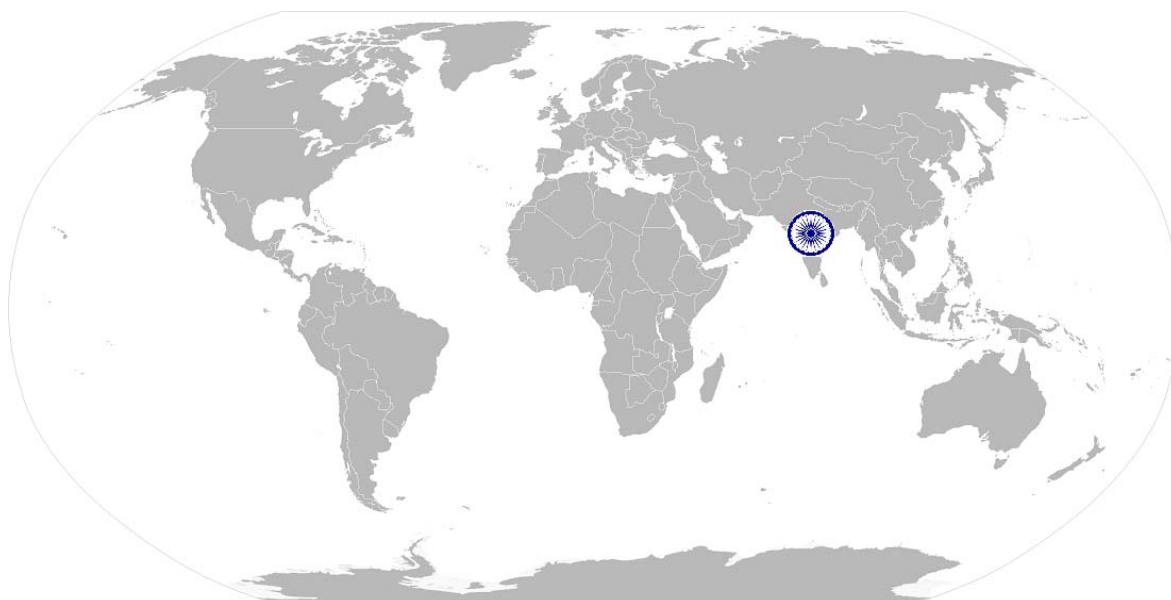
TSC/ N9003
Maintain health, safety and security at work place

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

TSC/ N9003

Maintain health, safety and security at work place

B. Professional Skills	Decision Making
	SB1. identify correct safety measure for particular hazard
	SB2. make required safety plans as and when required
	SB3. raise alarm in case of emergency
	Analytical Thinking
	SB4. know the use of correct safety measure whenever required
	Attention to Detail
	SB5. be attentive to details SB6. be careful to avoid occurrence of hazards You need to know and understand : SB7. maintenance of neatness at work place SB8. procedure for reporting unwanted behavior

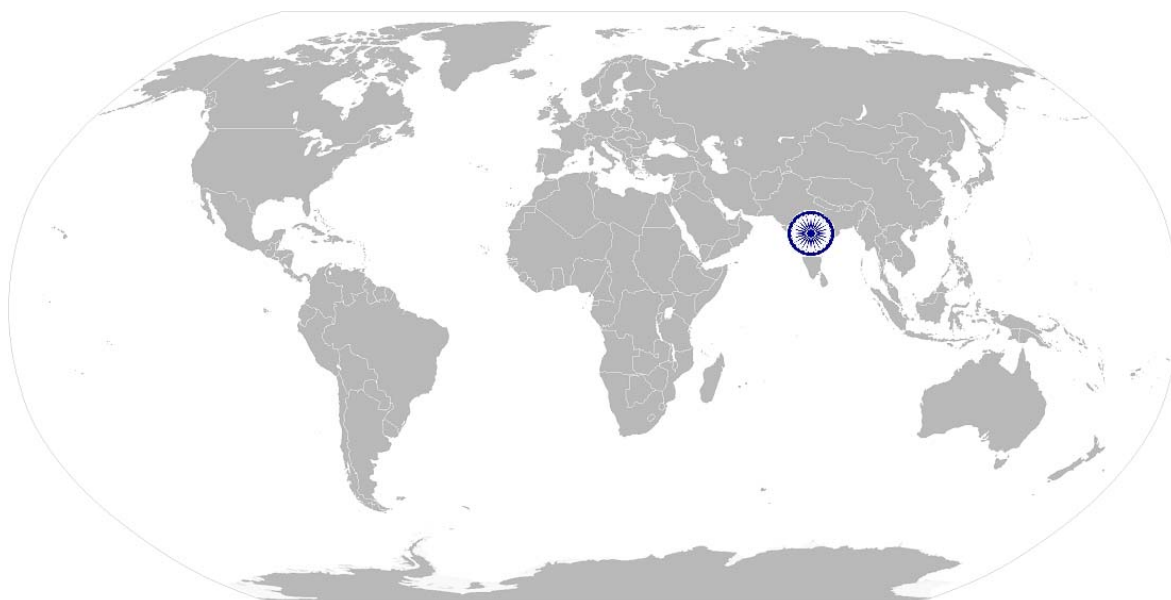


TSC/ N9003

Maintain health, safety and security at work place

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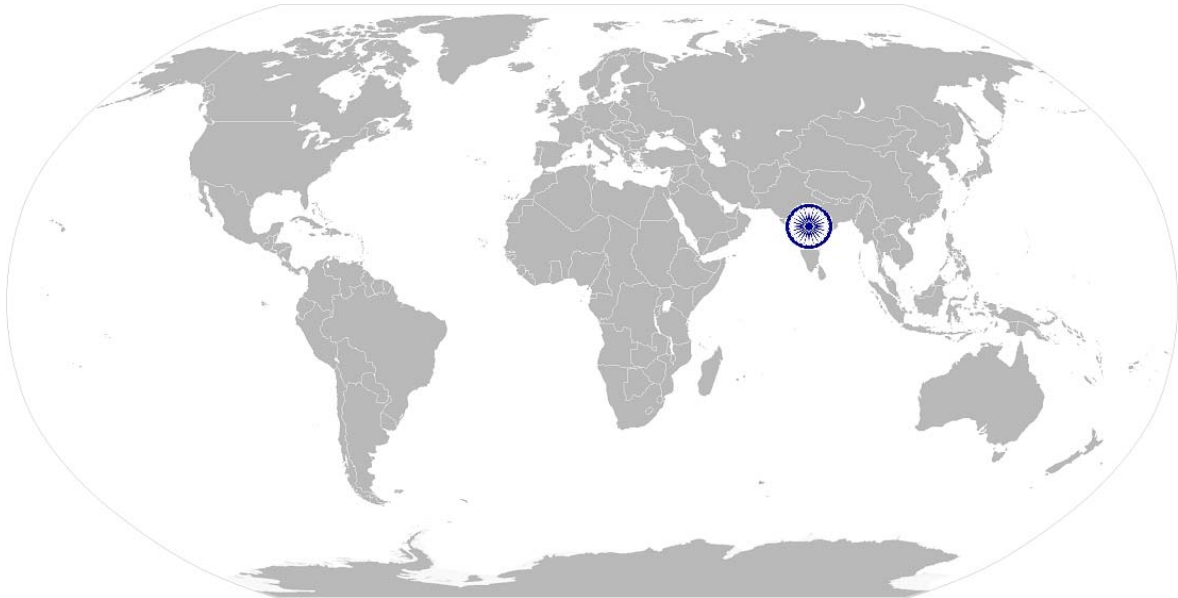
NOS Code	TSC/ N9003		
Credits (NSQF)	TBD	Version number	1.0
Industry	Textile	Drafted on	15/12/14
Industry Sub-sector	Spinning	Last reviewed on	25/02/15
Occupation	Spinning	Next review date	01/03/16



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

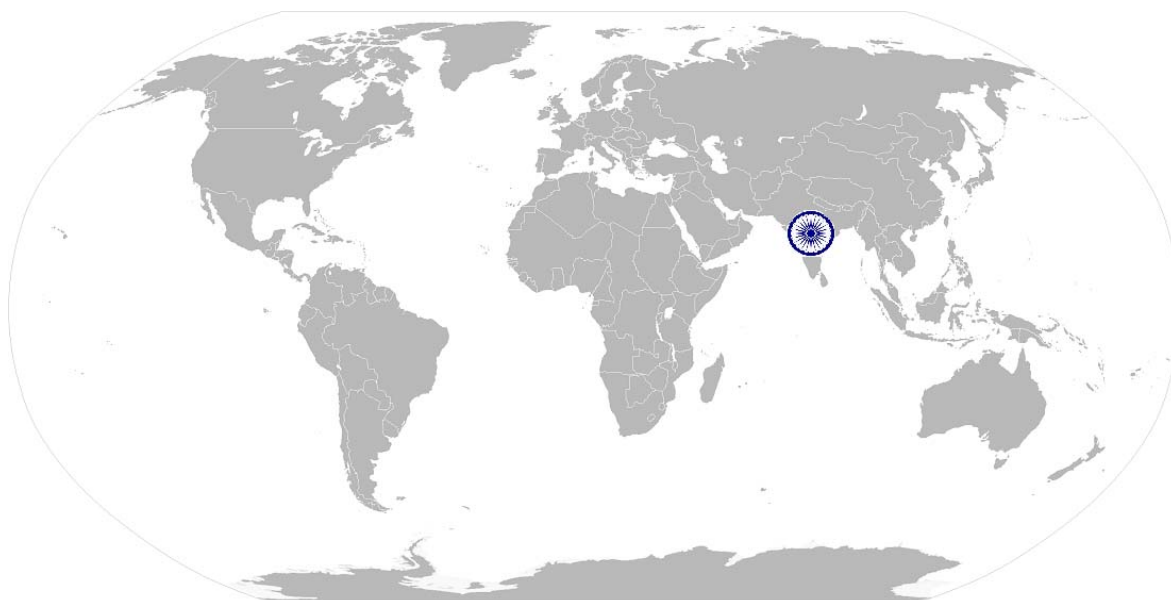
Comply with industry and organizational requirements

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

TSC/ N9004

Comply with industry and organizational requirements

	Reading Skills
	You need to know and understand how to:
	SA2. read the given instructions SA3. comprehend written instructions
	Oral Communication (Listening and Speaking skills)
	SA4. talk effectively with others SA5. put forward your point SA6. listen to others
	you need to know and understand :
	SA7. Organizational requirements
	SA8. your responsibilities at the workplace
	SA9. procedure to comply with the industry standards

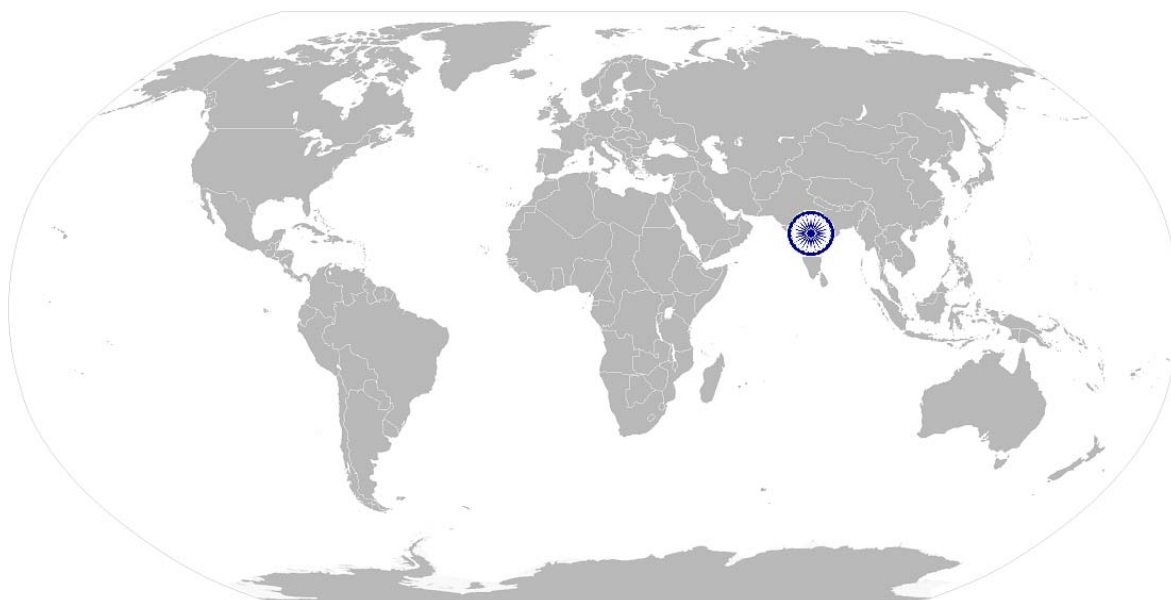


TSC/ N9004

Comply with industry and organizational requirements

NOS Version Control

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



Assessment Criteria

Job Role: Open End Spinning Tenter

Qualification Pack: Open End Spinning Tenter(TSC/ Q0203)

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		
				Theory	Skills Practical	Viva
1.TSC/N0209 (Taking charge of shift and handing over shift to Open-End Spinning Tenter)	PC1. come at least 10 - 15 minutes earlier to the work spot	100	3	1	1	1
	PC2. bring the necessary operational tools to the department		4	1	2	1
	PC3. meet the previous shift operator and discuss with him/ her regarding the issues faced by them with respect to the quality,production,spare, safety or any other specific instruction etc.		5	2	1	2
	PC4. Understand the count produced, colour coding, followed in the open end spinning for his allocated number of spindles or machines		5	2	1	2
	PC5. ensure the technical details are mentioned in the display board in the open end spinning machine		4	2	1	1

Assessment criteria

	PC6. check for the availability of the carded or drawing sliver for creeling		4	1	2	1
	PC7. check the availability of sliver cans with technical details mentioned regarding the hank / count being produced		3	1	1	1
	PC8. check the yarn passage and OE yarn formation		4	1	2	1
	PC9. check for the run outs , availability of sliver cans,ensurethat all the rotors and drums are working properly, if not should be enquired, for the reason of idling and report to the superiors regarding the same		3	1	1	1
	PC10. check the condition of all t running rotors and winding drums		4	1	2	1
	PC11. ensure proper functioning of OE machine parts and machine		3	1	1	1
	PC12. ensure that all allocated drums / rotors are running with uniform length of yarn on cone, variations if any should be discussed with operator and reported to superiors		4	1	2	1
	PC13. check the condition of all winding drums,report to the superior if there is any damage		4	1	2	1
	PC14. check the cleanliness of the machines & other work areas		3	1	1	1
	PC15. check whether any spare/raw material/ tool / yarn / any other material are thrown under the machines or in the other work areas.		3	1	1	1
	PC16. ensure the wastes collection boxes are empty		4	1	2	1

Assessment criteria

	PC17. ensure the work spot is clean		3	1	1	1
	PC18. ensure the OHTC is working properly		3	1	1	1
	PC19. question the previous shift operator for any deviation in the above and should bring the same to the knowledge of his/ her shift superior as well as that of the previous shift.		4	1	2	1
	PC20. take over the shift in a proper manner from the outgoing shift operator		4	1	1	2
	PC21. ensure in providing the details regarding count produced, colour coding followed in the OE for his allocated number of spindles or machines		3	1	1	1
	PC22. provide all relevant information regarding the count produced, idle drums, damaged machine parts if any		3	1	1	1
	PC23. get clearance from the incoming counterpart before leaving the work spot		3	1	1	1
	PC24. 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		5	2	1	2
	PC25. ensure the shift has to be properly handed over to the incoming shift operator		3	1	1	1
	PC26. 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	1	1	1

Assessment criteria

	PC27. collect the wastes from waste collection bags, weigh them and transport to storage area		3	1	1	1
	PC28.ensure the work spot is clean		3	1	1	1
	Total		100	32	36	32
	Weightage %			32%	36%	32%
2. TSC/N 0210 (Carryout Creeling and piecing activities in Open-End Spinning)	PC1. understand the mixings, hanks and the colour codification used	150	4	1	2	1
	PC2. bring the sliver cans from storage area		3	1	1	1
	PC3. ensure correct colour coded sliver cans are taken to OE section for creeling		3	1	1	1
	PC4. identify sliver exhausts and removing the empty sliver cans		4	1	2	1
	PC5. ensure minimum time is taken for attending the sliver exhaust or can change		4	1	2	1
	PC6. ensure the correct hank of slivers cans are taken for creeling to OE department		4	1	2	1
	PC7. follow proper color coding of sliver cans		3	1	1	1
	PC8. creel the required number of cans in an organized manner		4	1	2	1
	PC9. ensure proper feeding of sliver into the rotors		4	1	2	1
	PC10.feed the slivers to the rotors		5	2	2	1
	PC11.ensure the slivers are passed through rotors and yarns are taken out through guides and stop motions		4	1	2	1
	PC12.ensure proper material handling of slivers and sliver		3	1	1	1

Assessment criteria

	cans					
	PC13.patrol in the OE machine work area and identity the sliver breakage by viewing in the signal lamps provided at each rotors		4	1	2	1
	PC14.identify the reason for stoppage		3	1	1	1
	PC15.ensure minimum time is taken for attending the breakage		4	1	2	1
	PC16.ensure the slivers cans are properly and uniformly placed in the creel zone and at proper distance to avoid mix up		3	1	1	1
	PC17.ensure that the sliver passes through the rotors without affecting the quality of sliver		4	1	2	1
	PC18.ensure proper length of sliver is available from sliver can to rotor tip		4	1	2	1
	PC19.feed the sliver end to the rotor		4	1	2	1
	PC20.piecing the sliver between cans, in the event of sliver exhausting in the sliver can ,replace with a full sliver can		5	2	2	1
	PC21.ensure standard procedure is adopted for feeding the sliver in rotors		4	1	2	1
	PC22.ensure minimum time is taken for piecing the sliver		3	1	1	1
	PC23.keep the sliver waste in the respective waste collection box		3	1	1	1
	PC24.segregate the reusable wastes and weigh and record them in a register		4	1	2	1

Assessment criteria

	PC25.ensure safety and cleanliness at work place		4	1	2	1
	PC26.patrol around the machine to ensure proper production of OE yarn		3	1	1	1
	PC27.ensure minimum time is taken for attending the breaks		3	1	1	1
	PC28.feed the sliver in the rotors		4	1	2	1
	PC29.take the cheese package and identify defects if any		4	1	2	1
	PC30.remove defects in the cheese package if any		4	1	2	1
	PC31.lift the cheese package from the winding drum		3	1	1	1
	PC32.unwind the broken yarn end from the cheese to the rotor section and start new yarn formation		4	1	2	1
	PC33.ensure the yarn is formed with required twist		3	1	1	1
	PC34.ensure proper material handling of sliver, cheese and yarn		4	1	2	1
	PC35.follow proper procedure for piecing the yarn		4	1	2	1
	PC36.while processing knotless yarn, broken ends are to be overlapped on the cone/cheese as instructed		4	1	2	1
	PC37.ensure proper material handling of cheese and cone package		3	1	1	1
	PC38.ensure proper yarn passage & tension variator position post knotting		3	1	1	1
	PC39. follow standard procedure for operating material handing tools and knotting		3	1	1	1

Assessment criteria

Assessment criteria						
	equipments					
	PC40.follow safety procedures while carrying out creeling and piecing activities		4	1	2	1
	PC41.ensure cleanliness at work place		3	1	1	1
	Total		150	43	66	41
	Weightage %			29%	44%	27%
3. TSC/N 0211 Carryout doffing activities in Open-End Spinning)	PC1. follow the plan as instructed by superior for performing doffing activities at various machines in OE department	100	5	1	1	3
	PC2. identify which machine is ready for doffing		5	2	2	1
	PC3. ensure minimum time is taken for identifying the machine to carryout doffing activity		4	1	2	1
	PC4. ensure in confirming the machine with the superiors for carrying out doffing activity		4	1	2	1
	PC5. check that the cheese package is fully would to the predetermined length or weight and start doffing		4	1	2	1
	PC6. remove full cheese package from cone holder		6	2	3	1
	PC7. keep doffed cheese package in the peg trolley		5	1	3	1
	PC8. either stop the machine for doffing or doff the cone package while the machine is running as per the instructions of the supervisor		6	2	3	1
	PC9. ensure proper procedure is adopted for doffing the cheese package		5	2	2	1
	PC10.ensure proper material handling of cheese package		4	1	2	1
	PC11.ensure safety while carrying		5	2	2	1

Assessment criteria

	out doffing activity					
	PC12.weigh the cheese package and ensure the required weight have been achieved		4	1	2	1
	PC13.fix the cheese in the cheese holder and run it again till the cheese reaches the predetermined weight as instructed by superiors		5	2	2	1
	PC14.place the cheese in the cheese trolley and store in the storage area as instructed		4	1	2	1
	PC15. keep empty paper cheese ready in the reserve area for doffing		4	1	2	1
	PC16.insert the empty cheese into the cheese holder after doffing		5	1	3	1
	PC17.ensure that proper colour coded empty paper cone is mounted in holder		4	1	2	1
	PC18.follow the instructions of the superiors for count change		5	2	2	1
	PC19.ensure proper passage of yarn in OE machine		5	2	2	1
	PC20.ensure that all the rotors are running,and piece the ends once machine is restarted		6	2	3	1
	PC21.remove all the wastes and store it count wise in the waste collection box		5	2	2	1
	Total		100	31	46	23
	Weightage %			31%	46%	23%
4. TSC/N 0212 Carryout cleaning and maintenance activities in Open-End Spinning)	PC1. schedule the cleaning and maintenance activities	100	4	1	1	2
	PC2. carry out cleaning and maintenance activities		4	1	2	1
	PC3. clean the creeling area		3	1	1	1
	PC4. ensure cleanliness in the yarn passage		3	1	1	1

Assessment criteria

PC5. clean the rotor at regular intervals	3	1	1	1
PC6. failure of stop motion, breakdown should be reported to superiors immediately	3	1	1	1
PC7. ensure proper cleaning of different mechanisms in OE machine	3	1	1	1
PC8. dispose the sliver wastes& yarn waste in the waste collection pocket provided to each tenter and finally disposing in the waste collection box	3	1	1	1
PC9. remove the cleaned wastes and store in separate area	4	1	2	1
PC10. clean the alley around the OE machine using proper cleaning equipments	3	1	1	1
PC11. ensure the wastes collected from different parts of machine are deposited in the respective dustbins	4	1	2	1
PC12. ensure the OE department is neat and clean	3	1	1	1
PC13. ensure proper functioning of machine	4	1	2	1
PC14. check and verify the quality of different machine parts	3	1	1	1
PC15. ensure taking care of yarn passage, rotors, guides, winding drums	4	1	2	1
PC16. support fitter in removing the worn out parts and replace them with new parts in OE machine	4	1	2	1
PC17. oil different parts of OE machine on need basis	3	1	1	1
PC18. check OHTC air blowing	2	1	1	0
PC19. check bottom apron ,top apron, spacer etc	3	1	1	1

Assessment criteria

	PC20.check for damaged bobbins and discard them		3	1	1	1
	PC21.report to the supervisor and maintenance fitter if any problem is noticed in smooth functioning of machine		4	1	2	1
	PC22.ensure the OHTC is working.		2	1	1	0
	PC23.carry out preventive maintenance activities at the specified intervals		3	1	1	1
	PC24.during count change check the count boardfor cheese colour, cone tip colour and any other given instructions		4	1	2	1
	PC25.record the production details in the production report		3	1	1	1
	PC26.report to the supervisor in case of emergency stoppage of machine		4	1	1	2
	PC27.report to the supervisor and maintenance incharge if the operator was able to replace the worn out machine part with a new one.		4	1	1	2
	PC28.support the maintenance team while machine is under maintenance		3	1	1	1
	PC29.ensure all details related to production are provided to the next shift operator while relieving		4	1	2	1
	PC30. ensure count wise storage of damaged cheese in a separate area		3	1	1	1
	Total		100	30	39	31
	Weightage %			30%	39%	31%
5.TSC/N9001 (Maintaining work area, tools and	PC1. handle materials, machinery, equipment and tools with care and use them in the correct way	50	4	1	2	1

Assessment criteria

machines)	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 off 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
	Total		50	15	21	14
	Weightage %			30%	42%	28%
6.TSC/N9002 (Working in a team)	PC1. be accountable to the own role in whole process	50	4	2	1	1
	PC2. perform all roles with full responsibility		5	2	1	2
	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

Assessment criteria

	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	2	1
	PC10.avoid conflicting situations		4	1	1	2
	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
	Total		50	16	17	17
	Weightage %			32%	34%	34%
7.TSC/N9003 (Maintain health, safety and security at work place)	PC1. comply with health and safety related instructions applicable to the workplace	100	5	2	2	1
	PC2. use and maintain personal protective equipment 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		4	1	2	1

Assessment criteria

	waste					
	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

Assessment criteria

	PC22.communicate the safety plan to everyone		4	2	1	1
	PC23.attach disciplinary rules with the implementation		4	2	1	1
	Total		100	43	34	23
	Weightage %			43%	34%	23%
8.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
	Total		50	18	19	13
	Weihtage %			36%	38%	26%
Grand total			700			