

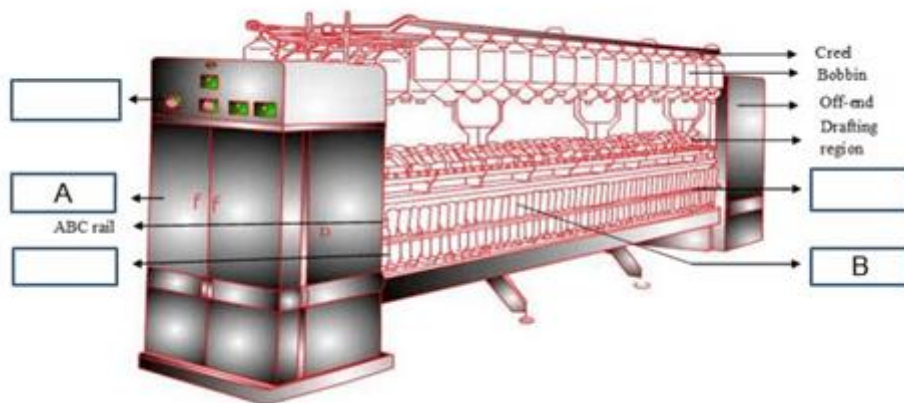
Ring Frame Doffer

Theory (Questions: 21)

Q1. Which of the following information should be provided to your fellow ring frame doffer while handing over the shift?

- A. Color coding for roving bobbins
- B. Details regarding empty ring bobbins for allocated spindles/machines
- C. Details regarding count produced
- D. All of the mentioned

Q2. Given is an image representing different parts of a ring frame machine. You are required to ensure that all the parts are functioning properly. Which of the following is the correct option representing the parts marked as A and B?



- A. A- Gear End
B- Separator
- B. A- Gear End
B- Ring Cops
- C. A- Separator
B- Ring Rail
- D. A- Ring Cop
B- Gear End

Q3. Who among the following people will give you the confirmation before carrying out the doffing activity on the machine?

- A. Your colleague
- B. Your supervisor
- C. The machine technician
- D. The Storekeeper

Q4. Which of the following things should **not** be done while collecting the empty cops from storage area and loading in cop trolley?

- A. The cops should be segregated according to the colour code
- B. The empty cops should be cleaned
- C. The yarn remains should be left as it is
- D. The damaged cops should be removed

Q5. In a ring frame machine, the roving is fed from roving bobbin held by creels. Which of the following image represents creeled roving bobbins?

A.



B.



C.



D. None of the mentioned

Q6. Which of the following represents an arrangement of empty cop trolleys?

A.



B.



C.



D. None of the mentioned

Q7. The full yarn cop on the spindle should be replaced with which of the following?

A.



B.



C.

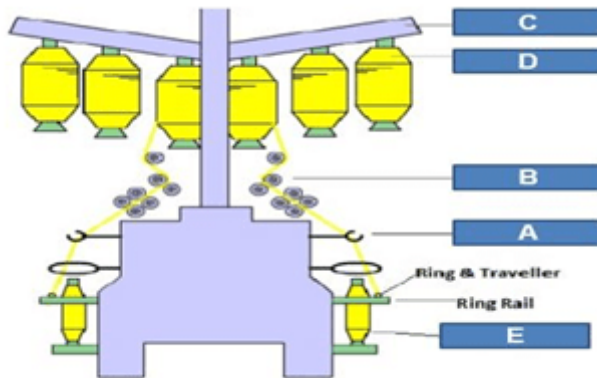


D. All of the mentioned

Q8. Which of the following is **not** true in the context of the checks that are needed to be carried out after the completion of doffing activities?

- A. All the full cops should be replaced with empty cops
- B. Gaiting should be done for all the spindle in a proper manner
- C. Place all the empty cops in the cop trolley
- D. None of these

Q9. Which of the following in the given diagram should be lowered to its position properly post doffing activities?



- A. B
- B. A
- C. C
- D. D

Q10. Which of the following trays should be used to keep the empty ring tubes before machine reaches the doff length?

- A. C-Channel Peg Tray
- B. D- Channel Peg Tray
- C. A-Channel Peg Tray
- D. B-Channel Peg Tray

Q11. Which of the following is the correct lubrication interval for the crank lever bracket of an auto doffer?

- A. 9-12 months
- B. 5-7 months
- C. 7-9 months
- D. 12-15 months

Q12. Which of the following equipment should be used for lifting and handling the empty cop trolleys?

A.



B.



C.



D.



Q13. Which hazard is represented by the given warning sign?



- A. Fire Hazard
- B. Biological hazard
- C. Electric hazard
- D. Chemical hazard

Q14. Which of the following is not true in context of cleaning of Ring frame and waste disposal?

- A. The cleaning activity should be carried out at periodic interval
- B. Creeling zone should be kept free from dust
- C. Clearer roller should be cleaned periodically
- D. It should be ensured that the pneumafil pipes' suction openings have appropriate fluff accumulation

Q15. What should you do in case you find excess heating of ring frame machine?

- A. Report the problem to the supervisor
- B. Leave the problem unattended
- C. Spray some chilled water on the machine
- D. Clean the interior of the machine

Q16. Fill in the blank from the given options.

A ring frame doffer is **not** responsible and accountable for _____.

- A. attending the ring frame machine for creeling of Roving bobbins
- B. assembling the broken rovings
- C. assembling the yarn in case of yarn breakage
- D. troubleshooting the planetary gearbox of ring frame machine

Q17. Which of the following protective equipment should be used while performing the doffing activities?

A.



B.



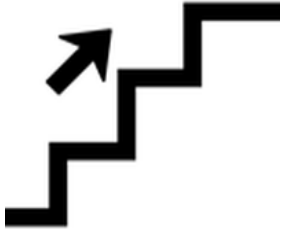
C.



D. All of the mentioned

Q18. Which of the following symbol depicts the correct representation of fire exit that should be used if the fire breaks out?

A.



B.



C.



D.



Q19. Which of the following symbol represents acute toxic chemical that can lead to a possible hazard?

A.



B.



C.



D.



Q20. Which of the following person should be reported in case of defects like soft bobbins, stained bobbins and unequal taperings?

- A. Supervisor
- B. Colleague
- C. Maintenance officer
- D. Machine Technician

Q21. Which of the following helps in avoiding conflicts and miscommunication at work?

- A. Avoid blaming others
- B. Communicate politely
- C. Pay attention to non-verbal cues
- D. All of the mentioned

Questions (Viva: 10)

Q1. What will you discuss with the previous shift doffer before taking charge of your shift?

Correct answer:

Will take count of the machines ready for doffing and will discuss regarding the issues faced by them with respect to the quality or production or spare or safety or any other specific instruction etc.

- A. Correct
- B. Partially correct
- C. Incorrect

Q2. What are the things that need to be ensured before taking charge of a shift?

Correct answer:

Ensure the proper functioning of cop trolley and the correctness of technical details mentioned in the display board of the ring frame machine. Check whether any spare/raw material/ tool / yarn / any other material are thrown under the machines. Check the cleanliness of the workplace and ensure the wastes collection boxes are empty.

- A. Correct
- B. Partially correct
- C. Incorrect

Q3. What criteria should be used for segregating the empty cops required for performing the next doffing activity?

Correct answer:

Empty cop should be segregated based on their size and color code.

- A. Correct
- B. Partially correct
- C. Incorrect

Q4. What are the things that need to be ensured while transporting the empty bobbin trolley to the ring frame machine?

Correct answer:

The cop trolleys are arranged in organized manner and the machine is stopped.

- A. Correct
- B. Partially correct
- C. Incorrect

Q5. What are things that need to be done while checking for the completion of doffing activity?

Correct answer:

The full cops should be replaced with the empty cops and gaiting should be done for all the spindles in a proper manner. Full cops should be properly transferred to the cop trolley.

- A. Correct
- B. Partially correct
- C. Incorrect

Q6. How will you ensure that the Ring frame department is neat and clean?

Correct answer:

Following steps should be followed to keep the department neat and clean-

1. Dispose of the waste at their respective places.
2. The work area should be cleaned at regular intervals.

- A. Correct
- B. Partially correct
- C. Incorrect

Q7. What are the things that are required to be done in order to maintain a clean and hazard free working area?

Correct answer:

The following things are required to be done in order to maintain a clean and hazard free working area:

- Maintenance and cleaning of tools and equipment at regular interval
- Reporting unsafe equipment and other dangerous occurrences
- Ensuring that the all machinery and equipment are in place
- Disposal of waste safely in the designated location
- Working in a comfortable position with the correct postures

- A. Correct
- B. Partially correct
- C. Incorrect

Q8. Who is the right person to report the problems faced while carrying out the doffing activities on the ring frame machine?

Correct answer:

Supervisor is the right person to be reported in case of difficulties faced with the machining operation

- A. Correct
- B. Partially correct
- C. Incorrect

Q9. Name four protective equipment that should be used while carrying out doffing activities.

Correct answer:

Protective equipment are:

- Nose Mask
- Ear plug
- Safety cap
- Safety shoes

- A. Correct
- B. Partially correct
- C. Incorrect

Q10. What are the tasks that can be undertaken for self-development?

Correct answer:

Following tasks should be done for self-development:

- Carry out task effectively
- Take responsibility and accountability for actions
- Emphasize on self-learning and improvement
- Try to initiate innovative methods for process improvement

- A. Correct
- B. Partially correct
- C. Incorrect

Questions (Practical: 17)

Passage: As a 'Ring Frame Doffer', you need to take charge of the shift from the previous operator, complete the designated tasks before starting the shift. Demonstrate what steps you will perform while taking charge of the shift.

Q1. Candidate performs basic tasks while taking charge of a shift such as understanding the count and colour coding followed in the ring frame, gathering the schedule of the doffing activities to be followed and also ensures that the appropriate technical details are mentioned on the display board.

- A. Excellent
- B. Good
- C. Satisfactory
- D. Poor

Q2. Candidate checks the availability of empty cops and follows appropriate procedure to ensure proper functioning of the ring frame machine.

- A. Excellent
- B. Good
- C. Satisfactory
- D. Poor

Passage: As a 'Ring Frame Doffer' you need to prepare yourself to carry out the doffing activity which involves identifying the machine to carry out the doffing activity, appropriately carrying and loading empty cops and providing support in creel zone during lot change. Demonstrate how will you perform this.

Q3. Candidate follows the proper plan to execute doffing activities and identifies if the machine is ready for doffing. Additionally, the candidate carries out doffing activity after confirming with the supervisor.

- A. Excellent
- B. Good

C. Satisfactory

D. Poor

Q4. Candidate identifies the empty cops and ensure they are clean. Additionally, the candidate performs the checks required on the cops before arranging them appropriately.

A. Excellent

B. Good

C. Satisfactory

D. Poor

Q5. Candidate supports tenter in moving new bobbins from speed frame department to the appropriate location ensuring that the correct roving bobbins are being moved.

A. Excellent

B. Good

C. Satisfactory

D. Poor

Passage: As a 'Ring Frame Doffer' you are required to carry out doffing activities in a Ring Frame machine and tasks like transportation of the empty bobbin trolley to the ring frame machine. Demonstrate how you will perform this.

Q6. Candidate transports the empty cop trolley to the ring frame machine in an organized manner

A. Excellent

B. Good

C. Satisfactory

D. Poor

- Q7. Candidate performs the necessary checks before removing a full yarn cop and replacing it
- A. Excellent
 - B. Good
 - C. Satisfactory
 - D. Poor
- Q8. Candidate performs the necessary checks to ensure that the doffing activity has been completed in an appropriate manner
- A. Excellent
 - B. Good
 - C. Satisfactory
 - D. Poor
- Q9. Candidate performs post doffing activities and assists the tender in performing the tasks required for a count change according to instructions given
- A. Excellent
 - B. Good
 - C. Satisfactory
 - D. Poor
- Q10. Candidate ensures the proper transportation of filled cop trolleys and the segregation of the empty and defective cop trolleys.
- A. Excellent
 - B. Good
 - C. Satisfactory

D. Poor

Passage: Suppose you are working on a 'Ring frame machine' and you need to perform some checks on it including readiness of empty ring tubes, prevention of machine from getting frozen etc. Demonstrate how will you perform such checks.

Q11. Candidate performs the checks which are necessary to ensure that the operational activities can be carried out appropriately by auto doffer ring frame machine.

- A. Excellent
- B. Good
- C. Satisfactory
- D. Poor

Q12. Candidate performs other checks which are required while handing over the shift to another doffer.

- A. Excellent
- B. Good
- C. Satisfactory
- D. Poor

Passage: As a 'Ring Frame Doffer' you need to be aware of the proper procedures to handle tools, materials etc. so that the work area, tools and machines maintained appropriately. Perform how will you handle the machine.

Q13. Candidate demonstrates the proper procedure to use the materials and equipment which are required to run the ring frame machine.

- A. Excellent
- B. Good
- C. Satisfactory

D. Poor

Passage: As a 'Ring Frame Doffer' you have been assigned to a new team at a different location of your company. Perform how you will act at that new place.

Q14. Candidate demonstrates the activities and behaviours necessary so that he can maintain accountability for the tasks performed by him and prove himself as responsible and efficient in his job.

A. Excellent

B. Good

C. Satisfactory

D. Poor

Passage: As a part of your job as 'Ring Frame Doffer' you need to be aware of the practices that are to be followed to comply with health, safety and security requirements at work and identify and mitigate any hazards that are perceived. Display how you will identify and resolve the hazards with the provided PPEs.

Q15. Candidate demonstrates the proper use of PPEs provided.

A. Excellent

B. Good

C. Satisfactory

D. Poor

Q16. Candidate inspects the work area and identifies any hazards and security issues.

A. Excellent

B. Good

C. Satisfactory

D. Poor

Passage: As a Ring Frame Doffer, you are supposed to demonstrate polite behaviour while coordinating with the team members and various colleagues. You come across some of your colleagues in the middle of an argument, then demonstrate the steps you will take to resolve the conflict.

Q17. Candidate intervenes and asks the colleagues to calm down and listens to their issues and resolves the problem or escalates it to the supervisor.

- A. Excellent
- B. Good
- C. Satisfactory
- D. Poor

ANSWERS:

Question	Answer
1	D
2	A
3	B
4	C
5	B
6	A
7	B
8	C
9	B
10	A
11	B
12	C
13	C
14	D
15	A
16	D
17	D
18	B
19	C
20	A
21	D