Tour Note of Sri C. L. Das, Executive Director, TFDPC Ltd during his visit to
Factory Division, Takmacherra on 29/12/2015

Reached office of the Divisional Manager, Factory Division, Takmacherra on 29/12/2015 at about 10.15 AM. Divisional Manager, In-Charge & Supervisor of the factory were found in the Factory premises. Visited various units of the factory. The observations are as under:

1. Latex Centrifuging Factory unit:
1.1 It was earlier learnt that efficiency of Centrifuging machine was not being received to the desired extent. In view of this, checked the fittings in respect of Skim screw and Feed tube. It was found that as per direction furnished earlier, feed tube of 10.5 mm and skim screw of 9.5 mm diameter was fitted in both the Centrifuging machines. As per my direction, sample of Cenex from both the machines was collected and sent to laboratory for DRC testing. It was directed that in case DRC of Cenex is found to be more than 61%, then skim screw of higher diameter should be fitted and further DRC of Cenex should be tested. It was also instructed that DRC of Cenex should be regularly tested and skim screw should be adjusted in such a way that DRC in Cenex remains around 61%.

1.2 Further, to ascertain efficiency of the machine it is necessary to go for checking of output by changing feed tube and skim screw at regular interval. After trial, proper set of feed tube and skim screw has to be installed. The process was demonstrated. It was told that while under taking such trial, volume of latex being put to machine is to be measured and at the end of machine operation, the volume of Cenex collected in the storage tank has to be measured to ascertain machine efficiency. As such machine efficiency should be around 90% i.e. 90% Dry rubber of the processed latex should be recovered in the Cenex while balance 10% may be recovered in Skim.

1.3 There are 3 different types of feed tubes having internal diameter of 9 mm, 10.5 mm and 11.5 mm. Trial to ascertain efficiency of machine, should be done using all the feed tubes to get best efficiency. This activity should be closely monitored for every changing of bowl and data should be properly maintained.
1.4 While checked the spare parts of the Centrifuging machine it was found that only one spare plug screw was available which is not sufficient to run both the machines smoothly as it is necessary to have one plug screw for each machine. DM is to arrange procurement of 2 nos. plug screw for both the machines. It was found that no spared bowl discs were available. Earlier there was good number of stock of bowl discs for use during emergency. DM was directed to arrange procurement of at least 10 disks for each machine so that it can be utilized as and when required. Such spared discs are used while button fixed on the outer surface of disc get detached.

1.5 The ammonia content in Cenex of storage tank was found to be around 0.5% which is not desired. The ammonia content in the Cenex tank should be maintained at 0.8% for which regular ammonization should be done.

1.6 One of the weighing scale available was found to be non functional. As such it is necessary to keep both Avery make weighing scales functional to ensure proper weight of Cenex in the barrel. DM should arrange rectification of the same.

1.7 All the spare parts of the centrifuging machine presently available in the office of O/C should be kept in the office of Supervisor of Centrifuging Factory. Check list of the spare parts available should be prepared and kept in readiness.

2. Workshop:

2.1 It was found that one of the Pressure machines which requires for testing of strength of MS barrel had been lying defunct for long time. The Pressure machine which is being used presently was learnt not to be strong enough to provide requisite pressure to the barrels. It was stated by the workers that new pressure machine has to be procured so that testing of barrel can be done effectively. DM was directed to arrange procurement of one such machine keeping conformity in respect of specification of the old one which was earlier in use.
2.2 Further, it was found that procurement of DA gas was not made properly resulting hampering of welding work. DM was directed to arrange procurement of required gases (DA, O₂) timely so that welding work does not suffer.

3. Storage tank of concentrated Sulphuric Acid

3.1 It was observed that in spite of passing instruction earlier Plug valve was not fitted to the storage tank. It was learnt that concentrated sulphuric acid tank had already reached at Agartala and expected to reach factory shortly. As per my direction available plug valve was fitted to the tank. As such for draining out of acid from the tank one more plug valve was supposed to be put at the acid collection point to avoid accident. DM was directed to arrange early fixing of plug valve with suitable bend pipe so that sulphuric acid is collected safely in a tank.

3.2 At present the PVC tank put for dilution of Sulphuric acid was found to have more height than required which may involve risk in dilution of Sulphuric Acid and its shifting. DM was directed to arrange procurement of one PVC tank having height around 2ft. so that dilution can be done properly.

3.3 DM was also directed to arrange painting on the outer side of the storage tank to check rusting of the tank.

4. Crepe Mill

4.1 It was found that some of the defunct crepers had been put to operation but one cutter creper and plain creper were found still defunct. DM was directed to arrange repairing of the same.

4.2 Lubrication system of the Crepers had not been resumed. DM was directed to ensure proper lubrication of different parts of Crepers.

5. ISNR Factory

5.1 ISNR factory was found non-functional due to non availability of power. However, as per my direction, I/C took initiative to start operation of the ISNR factory as power was resumed at around 4.15 PM.
5.2 DM was directed to arrange processing of the old scrap received from TFDPC IE first so that the quality does not get further worsen.

6. **Laboratory**

6.1 Checked if different tests of Cenex being done by the Laboratory In-charge was in order or not. It was found that tests were being done properly. Arranged preparation of normal solution of NaOH to check the strength of Sulphuric Acid being used for ammonia test.

6.2 Necessary directions were given to the Lab. In-charge in respect of testing of different samples being received from Centrifuging Factory, ISNR Factory. She was directed to maintain records of all the tests being conducted in the laboratory.

7. It was further found that timings for the various activities in the factory was not being maintained. Siren available in the factory to ensure timing was found non-functional resulting irregular movement of workers while shift was on. DM was directed to arrange procurement of siren and arrange proper functioning so that all workers may strictly follow time schedule. This should be not be compromised in any case.

8. At around 4.00 PM it was found that power house was under lock and key and Electrician had reportedly gone for taking bath. While enquired it come out that Electrician attend duty at their will which is highly dangerous. Electrician should maintain proper timings. One should work from 6 AM to 2 PM while the other should work from 2 PM to 10 PM without any compromise. This should be closely monitored by the In-charge.

9. **Ammonia Storage Tank**

9.1 The shed was found not maintained properly. Water shower which was available earlier to fight during emergency was found defunct. The water tank was found damaged. DM was directed to arrange immediate repairing so that the shed can be utilized properly.

9.2 It appeared from the wall writing that the Explosive License had already got expired on 30.09.2014. DM was directed to check the matter and take action for its revalidation if no action was taken.

9.3 DM has to further see validity of the following licenses:
   i. Factory License issued by Chief Inspector of Factories and Boilers
   ii. License issued from Pollution Control Board
iii. License issued by the Rubber Board of India
iv. License issued by the BIS
v. Explosive License.

9.4 DM was directed that in case these are not having validity, necessary action should be taken for renewal of the same. Compliance should be reported.

10. Earlier there was a canteen inside the factory premise which was catering the need of workers and staff. But at present there is no canteen in the complex. Workers are found moving outside the factory making disruption in factory operation. As it is mandatory to have canteen inside the factory complex, DM was directed to arrange construction if a canteen inside the factory complex in the same location which was earlier in existence. Necessary estimate etc. should be submitted early.

11. DM was directed to locate the register containing details of ammonia cylinders available in the factory to ascertain the total stock of ammonia cylinder. Compliance should be reported.

[C. L. Das]
Executive Director
TFDPC Ltd

No. F. 2-112/Estt/TFDPC-14/ 9206-08

Dated, 31/12/2015

Copy to:

1. The Managing Director, TFDPC Limited.
2. The Divisional Manager, Factory Division, Takmacherra
3. The In-Charge/Supervisor, Latex Centrifuging Factory and Crepe Mill, Takmacherra

[C. L. Das]
Executive Director