

Enhancement in the Working Process of Packaging Industries by Grouping of Lean Manufacturing & Six Sigma

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Abstract— This work is focused on the Packaging of things. In this work, the devices and structures used are all related to Lean Manufacturing and Six Sigma, in a manner of speaking Lean Six Sigma (LSS), systems. The goal of this work is to show how these gadgets can be used as a part of a progression wander that is focused on diminishing the Packaging expense of a mechanical plant and to give a course of action of answers for the goal business. The goals for this examination can be compacted in the going with way: Exhibit how Lean Six Sigma can be used as a part of a work focused on Packaging. Make a game plan of working courses of action through which the target business can reduce its Packaging cost. Show how to build the game plan improvement as for data examination rather than nature alone. As one of the targets of this work is to develop a plan of working responses for the target business to upgrade its Packaging, the courses of action and choose of the execution with these game plans are not theoretical points of confinement. Or maybe, the appraisals of overhaul potential are with the true objective that they allow some measure of assortment in the Packaging system. Likewise, the courses of action are to such a degree, to the point that they can be realized in the business with slightest ventures and give a more prominent number of focal points than unfavorable effects.

Key words: Six Sigma; Lean; Lean Six Sigma; Packaging Industry; muda; Manufacturing; Production

I. LEAN MANUFACTURING

Lean Manufacturing, Lean undertaking or Lean generation is fundamentally a creation practice that considers the consumption of assets for any objective other than the formation of significant worth for the end client to be inefficient and in this way an objective for disposal. Lean Manufacturing concentrates on cost diminishment by wiping out non-esteem included exercises so that few preferences can be acquired, for example, minimization/disposal of waste, expanded business openings and more focused associations. Lean Manufacturing can be embraced where there is a steady request and to guarantee a level calendar. The term 'Lean Manufacturing', which initially showed up in 1990, when it was utilized to allude to the end of waste in the creation procedure, has been declared as the generation arrangement of the 21st century. Verifiably, the idea of Lean Manufacturing was begun with Toyota Production Systems (TPS). Lean Manufacturing is called Lean as it uses less or the base, of everything required to create an item or play out an administration. Lean operations wipe out seven repetitive squanders (muda), in particular overproduction, over handling, holding up, movement, imperfections, stock, and transportation.

A. The Original Seven Muda Are

- Transport (moving items that are not really required to play out the handling)
- Inventory (all parts, work in process, and completed item not being handled)
- Motion (individuals or gear moving or strolling more than is required to play out the handling)
- Waiting (sitting tight for the following generation step, intrusions of creation amid move change)
- Overproduction (creation in front of interest)
- Over Processing (coming about because of poor device or item outline making action)
- Defects (the exertion required in reviewing for and settling abandons)

Lean is about accomplishing more esteem by using less assets all the more successfully and effectively through the constant end of non-esteemed included exercises or waste.

The procedure regularly diminishes the time between a client request and shipment, and it is intended to fundamentally enhance benefit, consumer loyalty, throughput time, and representative resolve. The advantages by and large are lower costs, higher quality, and shorter lead times.

B. The Characteristics of Lean Processes Are

- Single-piece creation
- Repetitive request qualities
- Just-In-Time materials/pull booking
- Short process durations
- Quick changeover
- Continuous stream work cells
- Collocated machines, hardware/apparatuses and individuals
- Compressed space
- Multi-talented and engaged workers
- Flexible workforce
- High first-pass yields with real decreases in imperfections

To put it plainly, the key logic behind Lean Manufacturing is to give better quality items than more clients at a fundamentally bring down cost and to add to a more prosperous society.

It is essential to fabricate an organization generation framework in view of this logic.

C. Lean Manufacturing Has Endeavoured To Rationalize Production By

- Completely disposing of waste in the generation procedure
- To incorporate quality with the procedure
- To lessen costs - efficiency enhancements

- To build up its own novel approach toward corporate administration
- To make and create incorporated strategies that will add to corporate operation.

II. FIVE FUNDAMENTAL CONCEPTS OF LEAN MANUFACTURING

There are five fundamental ideas that characterize Lean thinking and empower Lean Manufacturing: specify value, identify the value stream, flow, pull, and perfection (Womack and Jones, 1996).

A. Specify

In Lean Manufacturing, the end-utilize client exclusively characterizes the estimation of an item. The item should address the client's issues at both a particular time and value (Kandebo 1999). The conventional meaning of significant worth is the final result that the client buys. In the Lean model, esteem is the final result, as well as the chain of procedures that occur all together for a final result/end administration to be conveyed to the client. The a great many everyday and refined things that makers do to convey an item are for the most part of little enthusiasm to clients. Emiliani (1998) says, to view esteem through the eyes of the client requires most organizations to experience troublesome and extensive redesign of individuals, their mentality and practices, and business forms.

B. Identify

Distinguishing the esteem in Lean Manufacturing intends to see every one of the exercises required to create a particular item, and afterward to streamline the entire procedure from the perspective of the end-utilize client (Velocci 2001). Esteem is recognized through esteem stream mapping. This stream is contained every progression that has a place all the while and —touches the finished result. Procedures can be basic or complex. Procedures are driven in light of client desires and intended to be effective and to take out waste. Parts, capacities, and duties are intended to make the conveyance component more effective with less assets. The perspective of the client is fundamentally imperative since it recognizes exercises that plainly include esteem, exercises that include no esteem however can't be maintained a strategic distance from, and exercises that include no esteem and can be kept away from.

C. Flow

After esteem has been indicated and esteem streams have been distinguished, the following stride is to get the exercises that increase the value of stream without intrusion (Edwards 1996). Stream in Lean Manufacturing intends to process parts constantly, from crude materials to completed merchandise, one operation, or one piece at once. Maintain a strategic distance from group and line, or if nothing else persistently diminish them and the hindrances in their way. Stream is the effectiveness of the procedure that changes crude material into a finished result. This includes breaking down each progression in the process that touches and does not touch the finished result. The objective is to give a consistent stream muda (the Japanese word for —waste) minimized. Fruitful change endeavors will scrap a current procedure and overhaul it without any preparation.

In making stream Bicheno (2004) advocates never postponing an esteem including venture by a non esteem including step—attempt to do such strides in parallel. Bunch and line remains the prevailing strategy for creation in light of the fact that the numerous advantages of stream are irrational. Stream generation techniques can be exceptionally hard to actualize in develop Manufacturing organizations since they challenge all parts of traditional Manufacturing intelligence and practice. Recognize that clump and line Manufacturing is performed exclusively for the advantage of the maker, while stream generation reacts to the esteem in items as determined by end-utilize clients (Emiliani 1998).

D. Pull

The idea of draw in Lean Manufacturing intends to react to the force, or request, of the client. Lean producers plan their operations to react to the always showing signs of change prerequisites of end-utilize clients, while the operations of bunch and line makers are intended to meet their own particular nearby needs (Sohal 1996). Those ready to create to the draw of end-utilize clients don't have to make merchandise as per inefficient and erroneous figures that group and line makers must depend upon. The making arrangements for conveyance of item to end-utilize clients is less troublesome, and request turns out to be more steady if clients have trust in realizing that they can get what they need when they need it.

E. Perfection

On the off chance that an undertaking can do the initial four stages well, then all exercises get to be straightforward. This empowers individuals to all the more effectively distinguish and dispense with waste, and concentrate on enhancing exercises that make esteem (Rinehart 1997). The initial four stages associate in an "idealistic circle" that empowers the quest for flawlessness. The idea of flawlessness in Lean creation implies that there are unlimited open doors for enhancing the use of a wide range of advantages (Emiliani 1998). The deliberate disposal of waste will diminish the expenses of working the broadened endeavor and satisfy the end-utilize client's craving for most extreme esteem at the least cost. While flawlessness will never be accomplished, its interest is an objective worth taking a stab at on the grounds that it keeps up steady watchfulness against inefficient practices (Emiliani 1998). The changes in the recognizable proof of significant worth, the examination and stream of the esteem stream, and the pulled item/administration can be felt and seen at all levels of the association. It is in this impeccable express that the genuine advantages are perceived and figured it out. Operational, regulatory and key upgrades are plainly observed and the advantages to the association are acknowledged with fulfilled clients.

III. LEAN MANUFACTURING THEORY

The Lean Manufacturing strategy starts from Taiichi Ohno's Toyota Production System (TPS) which is firmly identified with the Just-In-Time (JIT) standards (Shah and Ward, 2007). Lean is basically gone for the lessening of waste and wasteful aspects inside procedures over the whole inventory network, and is cantered around those exercises that

expansion the quality and estimation of the item for the client. The strategy inventory network to achieve expanded process execution rates (De Treville and Antonakis, 2006). In the Lean procedure of persistently recognizing and dispensing with waste (Chen, Li and Shady, 2010), overhaul projects are started to boost the client saw estimation of an item or administration (Gautam and Singh, 2008). In this procedure it is vital to recognize what parts of the item or administration the client qualities to organize change activities all through the store network.

A. Definition

The adaption of Lean Manufacturing by U.S. supervisors and the clarification and investigation of the strategy by scholastics has turned out to be a test, due to this the writing contains to some degree repudiating definitions (Shah and Ward, 2007), which can bring about unsafe circumstances for firms needing to execute the technique (Pettersen, 2009). A study with respect to these repudiating meanings of Lean by Shah and Ward has given the accompanying clarification: "Lean creation is an incorporated socio-specialized framework whose principle goal is to dispense with waste by simultaneously diminishing or minimizing supplier, client, and interior changeability." (Shah and Ward, 2007: 791). This definition shows the wide scope of Lean inside a firm or even its production network. The accentuation is on the lessening of waste inside procedures which prompts institutionalization, decreased process durations, and an effective procedure stream (De Treville and Antonakis, 2006), basically, Lean is about accomplishing more with less (Christopher, 2000). Lean is an approach to persistently enhance quality and execution of items and procedures, and additionally decreasing expenses and streamline the improvement of developments (Gautam and Singh, 2008). On an inventory network level, long haul associations with suppliers and clients in regards to reconciliation of data and physical streams are likewise fused into the Lean rationality (Cagliano, Caniato and Spina, 2004).

B. Human Resources

Cooperation and aggregate representative contribution are key necessities for effective Lean applications (Shah and Ward, 2007; Fullerton and Wempe, 2009). The waste-decreasing and institutionalization attributes of Lean have been recommended to prompt undesirable working conditions for labourers (Conti et al., 2006). This has been negated by De Treville and Antonakis (2006), they infer that Lean makes work additionally rousing and middle of the road on account of expanded preparing, cross-utilitarian situation and a more prominent commitment to the general procedure. They additionally recommend that business pioneers need to independently persuade specialists to add to the Lean method for operations. Conti et al. (2006) say that the waste dispensing with normal for Lean does in reality enhances the execution of procedures; however it therefore expands the force of work. The procured accessibility of time is changed over into higher labourer limit. The same creators have reasoned that Lean practices have no immediate impact on the push levels of specialists. From an administrative perspective, chiefs ought to know about the way that Lean change activities can take quite a while before huge results can be measured which brings

about the supervisor to lose locate on which tasks are most essential to expel the association's key limitations (Spector and West, 2006). As to matter, Shah and Ward (2007) specify that representative contribution frames a critical component inside the Lean theory. Administrators ought to permit the base up approach of Lean to be compelling inside the association.

C. Criticism

Critics of Lean have contended the creativity and adequacy of the Lean theory. Näslund (2008) recommends that Lean is just a negligible swap for prior quality change techniques like the JIT standards. Encourage, the creator infers that tantamount procedure administration techniques take after a comparable item life cycle. A writing study by Cox and Chicksand (2005) demonstrates that commentators propose that the strategy is just effectively appropriate in high volume generation circumstances and that it can be hard to accomplish a win-win circumstance if there should arise an occurrence of purchaser predominance inside the inventory network. Since Lean requires inclusion and duty from nearly everybody inside a firm, it can be an exorbitant decision for firms to actualize the Lean theory (Fullerton and Wempe, 2009). Be that as it may, a contextual analysis by Chen et al. (2010), demonstrates that littler firms are similarly ready to effectively execute a Lean situation into their operations and increase impressive execution comes about. This to some degree negates the discoveries of Cox and Chicksand's writing study (2005) said prior.

D. Deviations of Lean

Lean is persistently developing in regards to both definition and reason (Pettersen, 2009), one of these deviations of the Lean idea is called Agile Manufacturing. Dexterity empowers firms to be more adaptable towards their client's novel request yet this at the same time puts weight on the association's cost and conveyed quality (Jiang and Chen, 2007), which is opposing to the Lean theory. The key contrasts amongst Lean and Agile are that Lean is for the most part suited in a circumstance where the market is steady and the item is standard, while Agile is more fitting on account of a creative item with high assortment and a flimsy, very unstable request (Stratton and Warburton, 2003; Cox and Chicksand, 2005). Coordinated can be more adaptable than Lean by its attention on accomplishing a high responsiveness towards the market request by dealing with a dynamic supplier organize, and through operational administration lacking expansive speculations which empowers fast modification of physical streams (Cagliano et al., 2004).

IV. SIX SIGMA THEORY

Other than Lean, there are different courses for firms to persistently enhance handle productivity to at last increment consumer loyalty and benefits. Another well known system is called Six Sigma. Six Sigma can be seen as a sorted out and organized technique for persistent process upgrades and quality administration which utilizes change experts and insights to build consumer loyalty, diminish handle variety and accomplish vital targets (Schroeder et al., 2008). McAdam and Lafferty (2004) address the genuine ramifications for associations while actualizing or applying

Six Sigma programs. The creators propose that Six Sigma is frequently used to really lessen handle variety and measurable basic leadership, yet the technique as a vital instrument is regularly downplayed.

A. Definition

A procedure works at a Six Sigma execution level when the quantity of imperfections (broken items) per million open doors (DPMO) is at 3.4 (Linderman et al., 2003). The strict concentrate on the client prerequisite is one of the principle qualities for the approach. This technique was initially presented by Motorola in the 1980's and further determined and promoted by, among others, General Electric under the authority of Jack Welch. These days the system is as yet picking up acknowledgment in view of expanding measures of reports of very effective Six Sigma ventures at driving firms (Arnheiter and Maleyeff, 2005; Chakravorty, 2009). Despite the fact that Six Sigma was at first put to rehearse in a Manufacturing situation, the procedure is these days being connected all through a wide assortment of businesses (Kumar et al., 2008). Six Sigma can be separated into two organized techniques: DMAIC and DFSS (Linderman et al., 2003), which will without further ado be talked about beneath.

B. Methods and Tools

The shortened form DMAIC remains for Define-Measure-Analyze-Improve-Control which are the five organized strides every one of the Six Sigma activities are to finished with a specific end goal to effectively enhance handle execution and, all the more critically, hold its enhanced execution. Every stage gives an assortment of apparatuses and strategies to control the change group to the main driver of the procedure variety (Kumar et al., 2008). The technique must be connected to existing procedures on the grounds that the strategy is gone for development. DFSS remains for Design For Six Sigma and is used to make new procedures without any preparation, however can likewise be connected to make new items or administrations (Schroeder et al., 2008). A strict client centre is a trademark for the plan procedure, which is like the DMAIC technique.

The Six Sigma technique applies measurements and institutionalized venture procedures to in the long run consent to client prerequisites with respect to process abscond rates (Schroeder et al., 2008). Its measurable establishment brought about the philosophy utilizing different execution, fund and client related measurements to enhance forms. Different instruments like the circumstances and end results examination, pareto and run outlines, esteem stream mapping and relapse investigation add to Six Sigma's institutionalized nature of recognizing the underlying drivers of process variety (Linderman et al., 2003).

C. Six Sigma Strategies

The vital significance of specific procedures very decides the craved execution level. Achieving a Six Sigma (6σ) execution level for a procedure can be expensive in light of the fact that the "the exertion and trouble increment exponentially as the procedure sigma builds" (Linderman et al., 2003: 195). More complex factual devices and learning is required to get the procedure to the 6σ execution level. The advantages and expected quantifiable profit should in this manner be obvious before such a venture is started

(Linderman et al., 2003). A wide assortment in application and usage of Six Sigma programs exists. Other than the vast multinationals which are reporting high investment funds, additionally little and medium endeavours can apply the Six Sigma procedure effectively inside their business. Be that as it may, it is prescribed for littler firms to be mindful of starting ventures in regards to the preparation of change authorities and painstakingly create information (Kumar et al., 2008). A study by Chakravorty (2009) shows that numerous Six Sigma programs fizzle in view of the inaccessibility of a grouping for executing the different components of Six Sigma into an association. The execution itself appears to withhold firms from achieving the full abilities of Six Sigma and use its potential for effective process upgrades.

D. Human Resources

Zu et al. (2008) express that an association's administration needs to build up a structure of Six Sigma pros into the current human foundation. This organized chain of importance of experts is a particular normal for the Six Sigma philosophy. The experts object is to oversee and bolster the change ventures (Schroeder et al., 2008). This chain of command comprises of Champions, Master Black Belts, Black Belts and Green Belts which are ordered by their insight and aptitudes with respect to Six Sigma's measurable instruments extend administration, preparing or authority (Zu et al., 2008). In the Six Sigma authority structure the Champion is regularly the venture support and initiator and is the immediate report of the venture pioneer. Ace Black Belts are talented experts ready to prepare and bolster Black Belts in their procedure of overseeing Six Sigma ventures. The Black Belts are in charge of the venture advance and bolster Green Belts who have the errand to get ready and break down factual information and tackle issues inside the different Six Sigma stages (DMAIC/DMADV) (Schroeder et al., 2008; Kumar et al., 2008).

E. Criticism

Associations discover Six Sigma to put too little accentuation on representative inclusion and directors are generally utilizing the strategy to address specialized process execution issues (McAdam and Lafferty, 2004). Nonetheless, Zu et al. (2008) recommend that top administration duty is essential for workers to perceive the significance and importance of value change inside the association, mindfulness should be made all through the firm. Näslund (2008) suggests that Six Sigma is the same as a prior quality change philosophy, called Total Quality Management (TQM). In any case, the creator's announcement that "Six Sigma basically has the same key way to deal with change with TQM" (Näslund, 2008: 281) is negated by Kumar et al. (2008). They express that Six Sigma contrasts from TQM on three perspectives: (1) Six Sigma is result-situated and concentrates solidly on investment funds, (2) the apparatuses utilized all through change activities are to be utilized as a part of an organized consecutive way and (3) the technique utilizes a various levelled association of change authorities.

V. DIFFERENCES BETWEEN LEAN AND SIX SIGMA REGARDING VARIOUS CHARACTERISTICS

Lean and Six Sigma can supplement each other in different ways. The sort of item is critical for the Lean creation logic in light of the fact that the item should be institutionalized with a low item assortment. The adaptability of Lean is the most essential explanation behind this, for Six Sigma, this is not really a requirement. A steady market circumstance is ideal for Lean while Six Sigma can be valuable inside any market. The same applies for the request where Lean wants to manage high volume circumstances, Six Sigma can manage all conceivable request circumstances.

As to hierarchical outline of a firm, both systems push the dedication from administration to the shop floor. Six Sigma uses a structure of masters which oversee change ventures, which needs inside the Lean technique. The duty of Six Sigma's masters is to give direction and structure to change activities, such an organized chain of command can likewise be fitting for Lean. Both philosophies accentuate the significance of the client inside a procedure. An alternate centre can be recognized in regards to Lean and Six Sigma, in which they can supplement each other.

Lean and Six Sigma have diverse methodologies in regards to the utilization of an association's HR and the going with culture. Inside the Lean technique, all representatives are seen as process specialists who are urged to be basic towards their own work. This prompts change activities to be started in a base up way from the representatives themselves (inherent). Six Sigma utilizes the master structure for consummation of change activities which are chosen on among others quality change increment in shareholder esteem or effectiveness change. This is to a greater degree a top-down way to deal with use the association's human resource and can be seen as extraneous on the grounds that most workers (aside from the masters) are not specifically included in the choice to start a change extend and the genuine procedure change itself.

Where Lean concentrates predominantly on the lessening of waste and increment of process stream and institutionalization, Six Sigma has a firm concentrate on controlling procedure variety and measurable basic leadership. Impediments for both procedures come the type of the real execution and the related costs.

The writing study in regards to both Lean and Six Sigma has uncovered that both procedures underline an organized way to deal with critical thinking and process change. Further, both procedures will in the end prompt an institutionalized procedure yet they achieve this in an alternate matter. Lean can be seen as a base up approach (from the shop-floor), though Six Sigma is to a greater degree a top-down technique.

Lean Six Sigma has been created by consolidating the Lean Manufacturing and Six Sigma strategies. As George (2002) recommends, the blend of these two can prompt the best of both universes: the waste-disposing of and speed enhancing attributes of Lean Manufacturing, and the factually based and organized method for process change and (re)design taken from Six Sigma.

VI. LEAN SIX SIGMA

Lean Six Sigma is a business change philosophy which consolidates apparatuses from both Lean Manufacturing and Six Sigma. Lean Manufacturing concentrates on disposal of waste and in this way expands general speed of the procedure/operations. Six Sigma concentrates on quality. By joining the two, the outcome is better quality, cost effective, quicker and improved process. Lean Six Sigma has not been utilized as a part of reusing to the degree it has been in Manufacturing. The goal of this examination is to explore the application and advantages of Lean Six Sigma in the reusing business. In particular, the target of the venture is to enhance the procedure for material recuperation office at Toledo, Ohio. This incorporates adjusting and improving procedures and the expulsion of process produced imperfections and mistakes.

The work explanation demonstrates to execute a Lean Six Sigma green belt's DMAIC system inside a little scale India bundling organization, and to utilize it as model for other Indian bundling organizations to take after. Considering the development capability of accomplishing more business with USA organizations because of enhancing the nature of bundling item and inside the Indian bundling industry in view of manufacturing procedure enhancements from actualizing Lean Six Sigma instruments. An India bundling organization speaks to the little scale India businesses area which assumes an indispensable part in the development of the nation. It contributes right around 40% of the gross modern esteem included the Indian economy (Small and Medium Enterprises).

This segment will plainly demonstrate the instructive procedure essential for changing the present condition of the India bundling generation handle by utilizing the DMAIC devices. This segment will start with a brief instructional exercise on the real parts of Lean Six Sigma. This segment will go up against a lesson arrange approach where every period of the DMAIC will be distinguished and outline how to utilize the numerous apparatuses of the DMAIC. In connection to the instructive level, the Lean Six Sigma will be disentangled so that the fifth grade instructive level individual can get it. The deliverable of the strategy segment will be to represent the suitable DMAIC apparatuses that will get ready organization to creating quality bundling items available to be purchased in the USA.

This work is an after effect of my enthusiasm for executing Lean Six Sigma into Indian bundling organizations on the grounds that the Indian business is developing at 18-20% yearly.

The principle target of this work is to fulfil a few noteworthy errands:

- 1) Introduce a Lean Six Sigma Green Belt DMAIC philosophy to an India bundling organization and
- 2) Show how a Lean Six Sigma Green Belt would execute the DMAIC approach in a little Indian bundling organization
- 3) Utilize this bundling organization as a model for other India bundling organizations to take after if their arrangements are to offer quality bundling materials to alternate organizations.

VII. RESULTS

Total Defect before & after Lean Six Sigma implementation in two successive months (May and June of 2015)

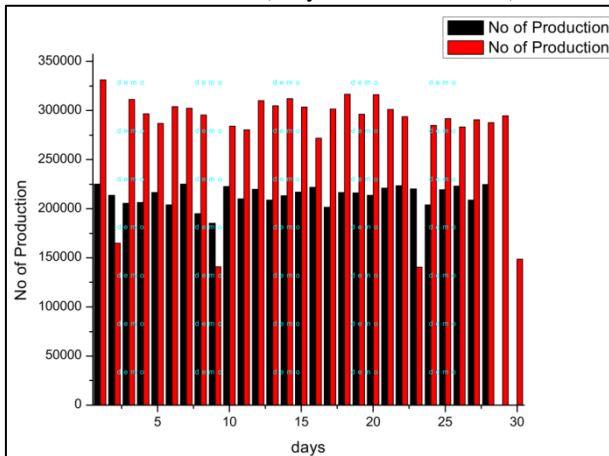


Fig. 1: No. of Production before & after Lean Six Sigma implementation in two successive months

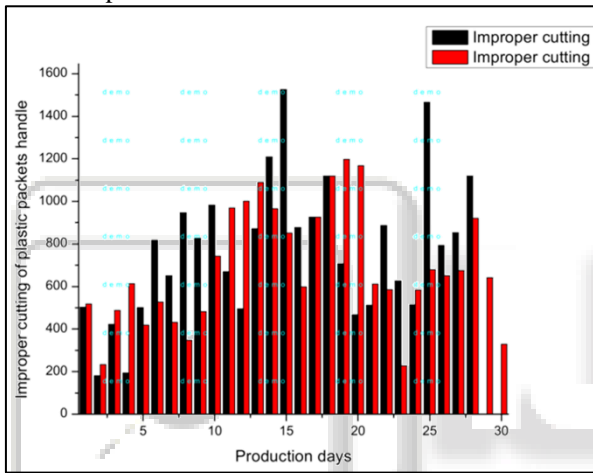


Fig. 2: Improper cutting of plastic bags handles before & after Lean Six Sigma implementation in two successive months

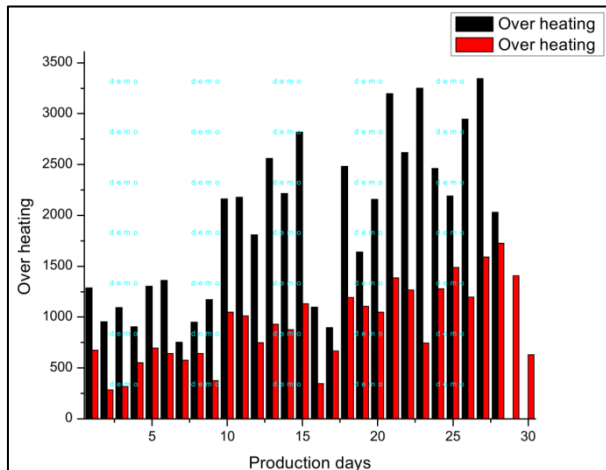


Fig. 3: Overheating before & after Lean Six Sigma implementation in two successive months

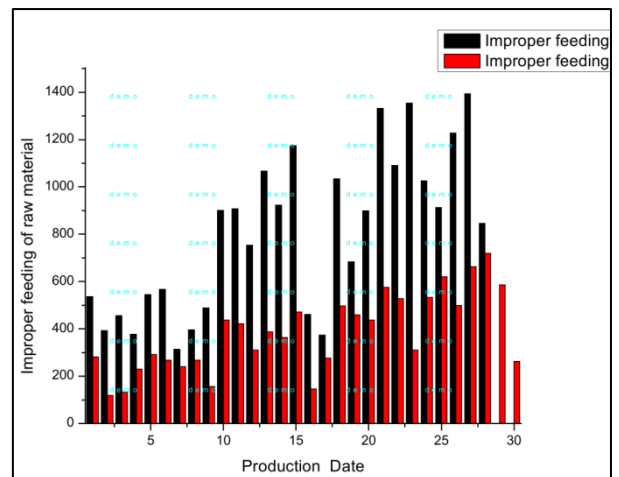


Fig. 4: Improper feeding of raw material in machine before & after Lean Six Sigma implementation in two successive months

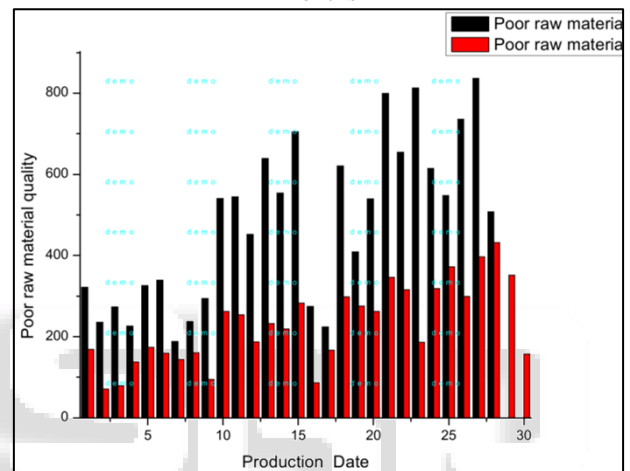


Fig. 5: Poor raw material quantity before & after Lean Six Sigma implementation in two successive months

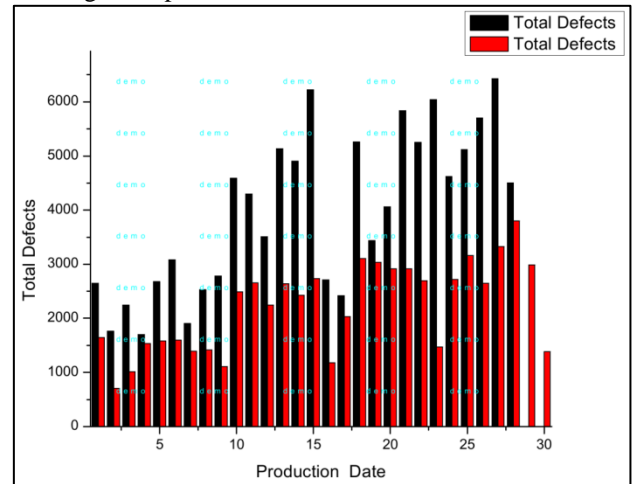


Fig. 6: Total Defect before & after Lean Six Sigma implementation in two successive months

Category	Current Process at Packaging Industry (May 2015)	Proposed process at Packaging Industry (June 2015)	Difference
No of production Pieces	5983398	8348574	2365176 Increase (28.33%)

Improper Cutting of Bags	19674	18986	668 Decrease (3.5%)
Bags waste	89715	45973	43742 Decrease (48.76%)
Total wastage	111369	66602	44767 Decrease (40.2%)
No of machine stoppage	90	25	65 Decrease (72.2%)

Table 1:

Below is the Comparison between costs of Manufacturing Bags in both Manufacturing process.

A. Cost of 100 Kg of Raw Material Used In Current Manufacturing Process

– HDPE (80%) + LDPE (9.75%) + Reproduced HDPE (10%) + Tinopal (.25%) = 6400 + 780 + 550 + 20 = Rs.7750

So the present Raw material cost for 1 kg of pack is Rs.77.5

5 Rupees expense is included for work and power for every Kilogram of Bags.

So last cost is (77.5 + 5) = Rs.82.5

– Offering cost is Rs.100 (Selling Price changes 2-5 Rupees up or down. However, to clarify figuring we have utilized 100 as a standard recognition. Generally Selling cost of Bags chose by board of trustees in Bhopal on each Wednesday at 5PM Indian time) so advantage for every kilogram is 100-82.5= Rs.17.5

– Which produce 5983398 pieces (13296.44 Kilogram) per month.

Net Production of Bags per month = Total Production - Total wastage = 5983398 - 111369 = 5872029.

– 5872029/450 = 13048.95 Kilogram of Bags produced each month

– Net profit for each month = 13048.95 * 17.5 = Rs.228356

B. Cost of 100 Kg of Raw Material Used In Proposed Manufacturing Process

HDPE (85%) + LDPE (9.75%) + Reproduced HDPE (5%) + Tinopal (.25%) = 6800 + 780 + 275 + 20 = Rs.7875

– So the present Raw material cost for 1 kg of pack is Rs.78.75

– 5 Rupees expense is included for lab our and power for every Kilogram of Bags.

– So last cost is (78.75 + 5) = Rs.83.75

– Selling commendation is 100 rupees so advantage for every kilogram is 100 - 83.75 = Rs.16.25

– Company produce 8348574 pieces (18552.39 Kilogram) every month.

– Net Production of Bags every month = Total Production - Total wastage = 8348574 - 66602 = 8281972 Bags for each month.

– 1 kg contains 450 Bags. 8281972 Bags measure up to 18404.38 Kilogram.

– Each Kg of Bags can make benefit of 100 (offering cost) - 83.75 (Raw material cost) = Rs.16.25

– So general advantage for Packaging Industry with proposed procedure is 16.25 * 18404.38 = Rs.299071
Data provided below show Manufacturing cost of two current and proposed processes.

Categories	Current Process	Proposed Process
Raw material price for 1 Kg	77.5 Rupees	78.75 Rupees
Labour, electricity and other Cost	5 Rupees	5 Rupees
Total cost for 1 Kg	82.5 Rupees	83.75 Rupees
Selling Price of 1 Kg of Plastic bag	100 Rupees	100 Rupees
Profit	17.5 Rupees	16.25 Rupees
Net Production Per month	13048.95	18404.38
Total Profit in Indian rupees	228356 Rupees	299071 Rupees

Table 2:

C. Difference between Two Manufacturing Process

– Difference is 5,255.95 Kg. So it is a major Difference. Packaging Industry has roughly fabricated 500 Kilogram of Plastic Bags every day. So unmistakably proposed fabricate limit of 30 days is equivalent to 40 days of current assembling process.

– Moreover as machine stoppage goes from 90 to 25 which essentially imply that machine stoppage was 3 every day and now is under 1 a day.

– Benefit Differences is \$6646 - \$5075 = \$1571. Benefit increment by 23.64%.

– Differences is 78.75 - 77.5 = Rs.1.25

– Production in Packaging Industry increments by 28.33%.

– This is only for Raw material. Different costs like work cost, power cost has not been considered on the grounds that no adjustments in those ranges. Changing in extent of Raw material so has been talked about in point of interest.

Previously mentioned information demonstrates that with the assistance of Lean Six Sigma DMAIC approach if Packaging Industry can build its profitability, Reduce its waste, Reduce number of machine stoppage time then it's likewise can helpful for other small scale enterprises in India who imagines that Six Sigma is not for small organizations.

VIII. CONCLUSION

The investigation coordinated in this proposition shows that my work can pass on improvement and advancement to India. There is in like manner an unmistakable business prerequisite for executing Lean Six Sigma's DMAIC strategy into India, particularly in Indian little scale industry where change open entryways in amassing are clearly recognized. In case India associations need to create quality things and organizations for American usage, then my one of a kind investigation shows India a beginning spot – at Packaging industry. In this examination clearly a little association having 12 labourers can construct its favourable position by 23.64%, machine stoppage is diminished by

72.2% and era extended by 28.33%. At Packaging Industry they simply have one machine in progress line so it was definitely not hard to quickly observe the creation and Lean Six Sigma comes to fruition. This open entryway at Packaging Industry will be the foundation for what can be expert at other India associations, who have around 50 - 500 delegates or at various associations, who have an enormous number of workers and agents participating amassing and assembling parts.

As DMAIC is productive in American associations, then executing this logic in India will in like manner bring an extensive divide of the same preferences. It is clearly recognized that there are social troubles. In any case, it has been clearly exhibited that there is a need of adult learning strategies for working up the worker in making countries like India. The open entryway at Packaging Industry has obviously demonstrated that informative level of the labourers should be considered while realizing the DMAIC's gadgets. Elective planning strategies should be viewed as in order to bolster this logic inside an affiliation, for example, keeping it fundamental, for changing new capacities into each one of agents' practices.

Working with Packaging industry's pioneer has similarly displayed that the official organization ought to be incorporated from the most punctual beginning stage. This experience has exhibited that an official needs to take begin by learning DMAIC if the entire affiliation is to learn and execute these system change philosophies adequately. Additionally, arranging workshops at standard intervals to educate experts is pivotal if Lean Six Sigma is to be another example in India. (This ought to be conceivable if association has enough sponsors to support the workshops) With the sponsorship of the proprietor and delegates, together they can manage improving as far as possible and nature of its things. Be that as it may, to execute this kind of advance, an association needs to change the standpoints entire gathering bunch in a space where proprietor of little scale industry must be correct continually. It may oblige speculation to tail this thinking in Indian little scale industry. However, we should not to disregard the famous saying that says "it is perfect to late than never".

The data that this hypothesis displayed will positively help other proposed manufacturing associations handle makes diverse associations in India need to take subsequent to Packaging industry's lead.

It is the vision of our Lean Six Sigma bunch that distinctive associations in India are going to take after Six Sigma DMAIC systems when they see such a noteworthy complexity in focal points and decreasing in machine stoppage time. What's more, this will in like manner make sound contention among the associations in India. Case in point, if an association benefits something to grow the creation other association will in like manner endeavour to enhance by engaging their experts. In addition, association proprietors will endeavour to interest in connection to what is going in the endeavours since long time. From this delineation, if a man needs to show that if an association which feel that they are doing honourably and does not require any do any better besides told that not a great deal ought to be conceivable to make creation less costly and speedier. Be that as it may, around the end of this examination, association proprietor was confused.

This is same case for every single distinctive wander in all making countries. Particularly in India, Lean Six Sigma DMAIC system can be completed in different domains. Associations said in composing review shows that Six Sigma is adequately done in Indian associations yet amounts of associations are less. There is one reason behind not executing Lean Six Sigma is questions about Lean Six Sigma that completing Six Sigma require some portion of money required, remarkable strategy to take subsequent to, getting expensive equipment and get some person with Six Sigma assertion in association continually.

By virtue of these questions associations flounder to execute Lean Six Sigma. Bundling Industry is doing capable amassing since the summit of Six Sigma wander.

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