

Karnataka Co-Operative Milk Producers' Federation Limited
Unit: Cattle Feed Plant Rayapur, Dharwad-580 009.

BRIEF NOTE

Cattle feed plant Rayapur, Dharwad is the third unit of Karnataka co-operative milk producer federation ltd, Bangalore. National Dairy Development Board, Anand at the cost of Rs 233.78 Lakhs on "turn key basis", erects this plant. Out of Rs 233.78 lakhs, Rs 165.42 lakhs is loan and Rs 68.36 lakhs is subsidy. Loan will be cleared during the year 2004-2005. The capacity of the plant is 100 M.T./day.

Our plant has got license during the year 1988-89 from Licensing Authority and Joint Director (Development), Department of Animal Husbandry & Veterinary Services Bangalore to manufacture cattle feed. License is being renewed every year.

Our plant is divided into five blocks. They are as follows:

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|-----------------------------|-------------------------------|
| 1. Raw Material Godown | 2. Production Block |
| 3. Finished Material Godown | 4. Quality Control Laboratory |
| 5. Administrative Block. | |

1) RAW MATERIAL GODOWN;

94.00 % of raw materials used in cattle feed are agro based products and by products. They are not available through the year. We have to store the material, which are available seasonally depending upon plant's capacity. Our plant has got following storage capacity;

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|----------------------------|------------|-----------------------|--------------|
| 1. Raw Material Godown | : 350 M.T. | 2. Silos | : 1,000 M.T. |
| 3. New Raw Material Godown | : 300 M.T | 4. Old Dairy Building | : 400 M.T. |
| 5. Old Dairy Sheds | : 300 M.T. | | |

Apart from these, we have hired two private godowns on area basis i.e at the rate of Rs 2.80/Sq.Feet. The total area hired is 11,000 Sq.ft. We can store 3,270 M.T. of raw material in these godowns.

RAW MATERIAL PURCHASE;

Raw materials used for Cattle Feed production can be classified in to five groups. They are;

1. Grains : Maize, Jower, Ragi, Wheat and Bajra.
2. Brans : Rice polish, De-Oiled Rice Bran, Wheat Bran and Gram Bran.
3. De-Oiled Cakes : Ground Nut, Cotton Seed, Soya Seen, Rape Seed, Sunflower, Coconut, Ambadi and Karadi D.O.C's.
4. Pre-mix Materials : Salt, Mineral Mixer, Calcite and Urea.
5. Molasses : By product of sugar factory. It contains 50-55 % sugar.

All raw materials except molasses, urea and mineral mixture are being purchased by our central office. Till October 2000, raw materials were purchased through **Dynamic Purchase System**. From **4th October 2000** onwards raw materials are being purchased through **Tender System** as Government of Karnataka promulgated **ordinance Transferency in Public Procurement-2000**.

'A' Grade molasses is purchased from Government & Co-operative sugar factories by participating in tenders. Urea is being purchased from Karnataka Co-operative marketing federation, Hubli branch. Mineral mixture is being from cattle feed plant, Gubbi, which is our sister concern. We have got license from Excise Department of purchase & use molasses in cattle feed. During the year 2000-2001, we got increased our molasses permit quantity from 3,000 to 3,600 M.T./Year. Molasses storage capacity is 850 M.T.

2. PROCESSING BLOCK;

Different stages of Cattle Feed production are as follows;

Raw materials Intake → Grinding → Batching → Batch mixing → Molasses mixing → Pelleting → Bagging

We are manufacturing three type of Cattle Feed.

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|--------------------------------|-------|-----------------------|
| 1. Nandini Cattle Feed Type-I | ----- | Rate Rs 6,440.00/M.T. |
| 2. Nandini Cattle Feed Type-II | ----- | Rate Rs 5,600.00/M.T. |
| 3. Nandini Bypass Protein Feed | ----- | Rate Rs 7,410.00/M.T. |

Cattle Feeds are produced as per the quality specifications fixed by Licensing Authority. Feed batches are taken by microprocessor system. To have perfectness in weighing we have installed electronic bagging & weighing at the cost of Rs 2.25 Lakhs during January 2002. We have installed new Auto Batching System programmable logic control (PLC) at the cost of Rs 6,23,209.00.

Capacity utilization of the plant during the year 2003-04 is 88.5%.

3. FINISHED FEED GODOWN:

Finished feed is being packed in 50Kg H.D.P.E bags and they are stored in Finished Material Godown. The capacity of the godown is 350 M.Ts. After getting clearance from quality controls section feed will be dispatched. For easy identification of type of feed, Nandini Type- II feed is being packed in white colored bags, Type-I feed in Green colored bags and Bypass protein feed in Yellow colored bags. All type of bags are printed with requisite information as per Licensing Authority.

4. QUALITY CONTROL LABORATORY:

Unit has fully equipped laboratory has got equipments glass wares, Chemicals and others worth Rs. 6,11,090.34. Quality control Division has got qualified trained and experienced staff.

In laboratory, raw materials, finished feed and packing materials are being analysed. Quality control Division has got computer. Least cost formulae are being obtained by using Linear Program-88software, conforming to quality specifications fixed by Licensing Authority.

5. ADMINISTRATIVE SECTION:

From administrative point unit has got following six sections.

1) Administrative Section 2) Production Section 3) Stores Section 4) Quality Control Section 5) Finance Section 6) Purchase Section.

Since we sell feed mainly to our milk unions, we do not have separate sales section. The sales activities are being liked after by stores section.

In order to increase efficiency, productivity, quality consciousness and skill, employees were sent to N.D.D.B Anand/Mehasana, C.T.I Bangalore, ApTech – Dharwad

and U.A.S Bangalore for Training in varied subjects like plant management , Electrical systems, Computer Awareness programme, First Aid, Fire Extinguishers Handling, Boiler Maintenance, Raw material and Feed analysis etc.

In order to computerization of the unit, 05 computers are purchased and given to each section. Unit has got 31 permanent employees and 23 contract employees (who have come from contractor) Bagging, Dumping, Stocking, Unloading, Pre-Mix, Gardening, Security and canteen work is given annual contract.

6. OTHER FACILITIES OF THE UNIT:

Unit has got 300KVA electric sub station. There are two baby boilers having capacity of generating 400Kg steam/hour each. Boiler are fed by furnace oil. Unit has got 21,000 liter capacity furnace oil tank. Unit has got enough space for packing loading vehicles. Unit is located near Navalur railway station, which help us to procure raw materials through railway in bulk from Northern and Western India. Unit is not only located near railway station but also located on National High Way No.4. This helps the raw materials vehicles to come and go easily, in turn it reduces transportation cost.

TURNOVER:

During 2003-04 unit has made Rs 16.8 crores turnover with profit of 95.75 lacks. From seven years unit is running under profit.

I.S.O 9001-2000 CERTIFICATION

In order to provide good service, apart from giving food quality cattle feed to milk producers, and in order to bring good systems in cattle feed units and to make continuous improvement, our Central office has decided to have I.S.O-9001-2000 Certification to all cattle feed plants.

Poka Yoke, Quality Management Services, Pandithery was appointed as consultant. Preliminary preparations were started from 14th January 2003. After completion of modalities Indian Register Quality Systems, Mumbai, Bangalore branch was invited for certification. After verifying records and systems adopted Indian Register Quality Systems, Bangalore branch issued I.S.O. 9001-2000 Certificate No:IRQS/041193.

QUALITY POLICY

We at Karnataka milk producers' Co-Operative Federation Ltd, are committed to meet the requirements of our valued customers through manufacture and supply of cattle feed and allied products adopting scientific methods and linear programmed formulations.

While complying with the requirements, legal ant others, we strive to continually improve our performance, there by enhancing satisfactions of our customers.

QUALITY OBJECTIVES

1. Reduction in absenteeism level by 10% over the 2002=03 level.
2. Reduction in expenditure on account of over time 25% over the existing level.
3. Reduction in energy consumption per MT of finished product by 5% over the average of 2002-03.
4. Identification of all training need will be completed by December of each year.
5. Reduction in non conformance in supplies made to customers by 30% over the previous monthly average.
6. To reduce MTBF by 10% over the 2002-03 level.
7. All trucks arriving up to 16.30 hrs to collect normal demand will be loaded and released on the same day.
8. Attempts will be made to meet abnormal demand of a customer within 3 working days.

In total our unit is giving good services to milk producers for which it is constructed
