



Lean Six Sigma Green Belt Project Storyboard



Project Name: Line OEE Loss	Start Date:4/12/16
Project Leader: A N Other	End Date:26/3/17
Project Type: Operational Efficiency	Industry: Food and Drinks

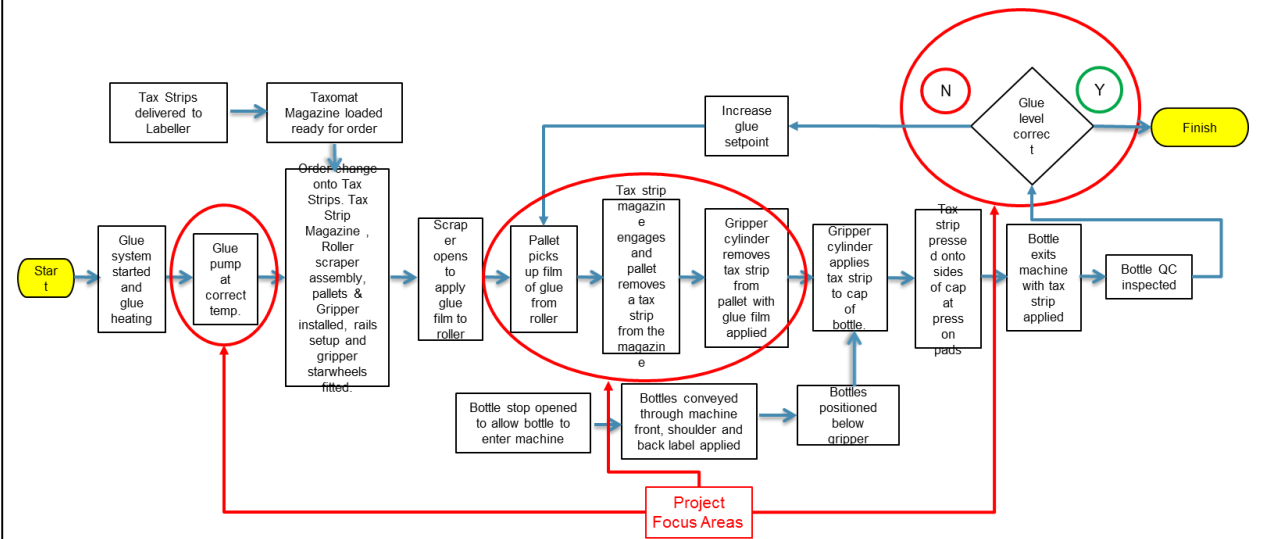
DEFINE: PROBLEM / BASELINE / GOAL

Problem Statement: The TS downtime in the Bottling Hall is problematic resulting in frequent stops of the Labelling machine requiring manual cleaning intervention.

Baseline: In the past 12 months (December 2015 - December 2016) the total OEE (Overall Equipment Effectiveness) downtime is at 5.92%

Goal: To reduce OEE downtime by 2.92% from 5.92% to 3% by April 2017 for TS downtime. This is approximately a 50% saving in line with International Supply OEE reduction targets.

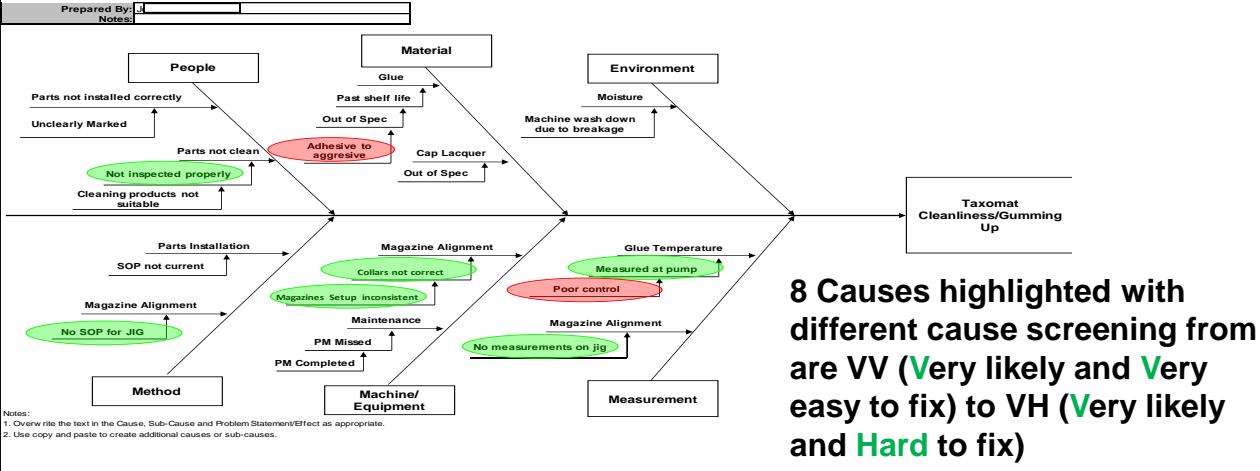
MEASURE: PROCESS / EXPERT KNOWLEDGE / DATA



Process Map Analysis identified 3 Focus areas identified

- Glue temperature control
- Glue level on T Strip
- Glue contamination on label handling parts

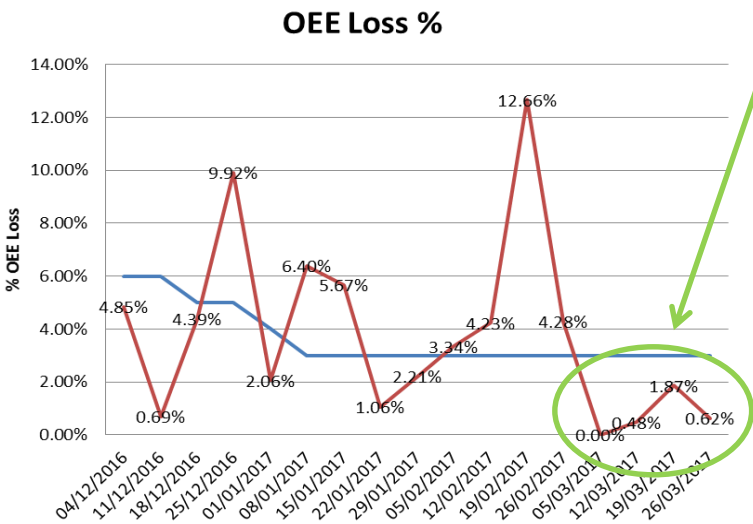
ANALYZE: DRIVERS / ROOT CAUSES / VITAL FEW



IMPROVE: INNOVATION / IMPLEMENTATION PLANNING

Tool	Recommendation	Action	Owner	Deadline	Status
SAP	Centreline tax strip magazine	Manufacture new collars	J.V.	22/1/17	Complete
SAP	Update Preventative Maintenance with critical control points to be inspected	Update SAP Work order with new inspection criteria	G.C.	19/2/17	Complete
SAP	Source suitable thermocouple and install	SAP notification raised for work to be planned	J.V.	22/1/17	Complete
Training	Brief team on new glue level and temperature control method	Brief at both SBM	J.V.	29/1/17	Complete
Training	Add glue temperature and control method to SOP	Amend current SOP	C.H.	12/3/17	Complete

CONTROL: RESULTS / SUSTAINING



Project goal achieved during the last 4 weeks

Results

- OEE Downtime reduced to 0.76% for the last 4 weeks during the control phase
- Reduction from average of 12 events per month to 6
- Estimated £17197 annualised savings

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