

## Tomorrow's Technology Today

### Client Details

Name	Major UK Retailer
Production Type	Bacon Production
No of Lines	12

### Executive Summary

Having been approached by a major UK retailer in the UK to assist in their continued pursuit of improved productivity, we engaged our 10 steps to productivity and set about a detailed project scope to deliver the required results. **Translated into monetary terms this has resulted in a £24,000.00 per week increase in net profit from the 12 lines.**

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### Project Scope

250 production lines, spread diversely across the United Kingdom, where productivity, reliability and performance across 13 sites were a clear concern for the business.

The need was to quickly identify where information was either manual in collection or missing, with an objective of automating data collection and identifying the six big reasons for loss of productivity.

This information was subsequently re-presented in a format whereby management, operations and line staff were able to analyse, view and take appropriate action.



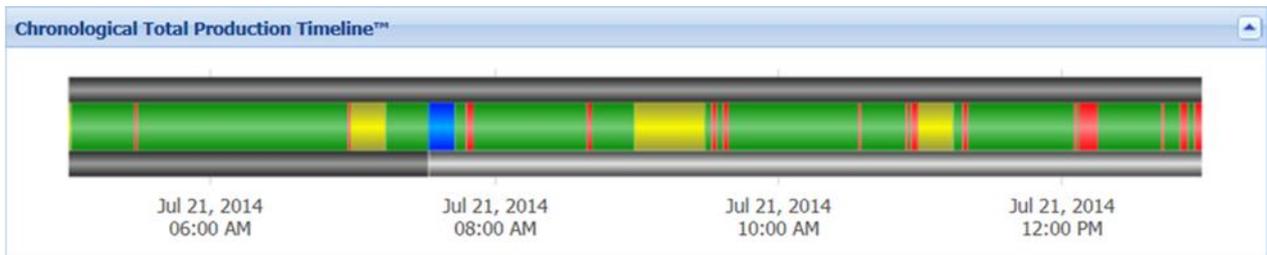
The installation comprised of installing twelve main XL800 systems in the Bacon situated at the end of each line. Using this method of deployment meant that the entire production line staff were all engaged and had sight of the boards, rather than just a proportion.



After an initial period of testing it was found that in many instances targets had either been set too high or too low, so revised targets were put in place and uploaded to the system.

A period of four weeks was used to establish a baseline for improvement where all sections of the OEE formula were monitored and recorded both by shift and by product.

Taken as part of the DRM process, (Daily Review Meeting) this information was translated into a series of actions designed to improve productivity.



Timeline Events

View Type:

Production State	Reason	Time Percentage ...	Occurrences	Total	Min.	Average	Max.
Run	(1 Reason Type)	45.94%	17	-663:05:15	-42:12:00	-39:00:18	-34:20:00
Down	(7 Reason Types)	41.17%	15	-594:09:08	-42:15:00	-39:36:36	-34:47:00
Setup	(1 Reason Type)	2.55%	1	-36:51:00	-36:51:00	-36:51:00	-36:51:00
Standby	(2 Reason Types)	10.34%	4	-149:13:02	-40:18:00	-37:18:15	-34:19:00

By focusing on the 6 main reason for loss of productivity it was soon established that the biggest two causes of loss of production was the time taken in **product changeover** and the amount of time

lost to **breakdown**. Followed closely with **break time management**.

Using this information managed to achieve a 35% reduction in the time taken for each changeover the system was already showing a return on Investment.

Working with Engineering and the machine manufacturer's breakdown times were substantially reduced on the check weigher and metal detectors, combined with the reduced changeovers, an overall improvement in OEE was measure at 4%.

### Improvement Summary

1. Changeover reduction in time taken 35%
2. Line breakdown times reduced.
3. Overall increase in productivity by 4%

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