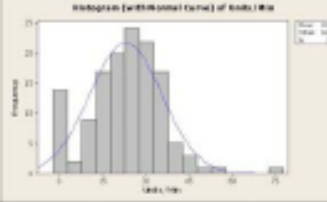
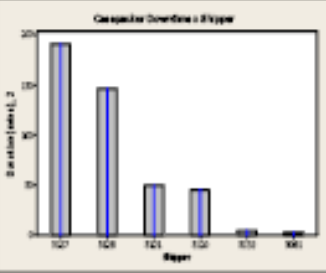

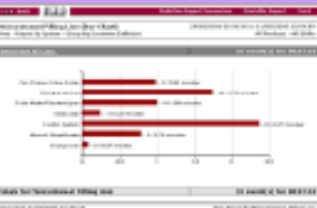
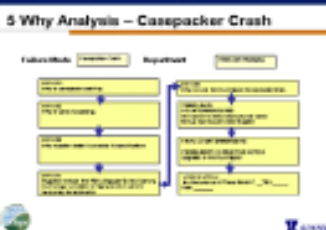


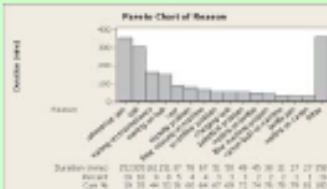
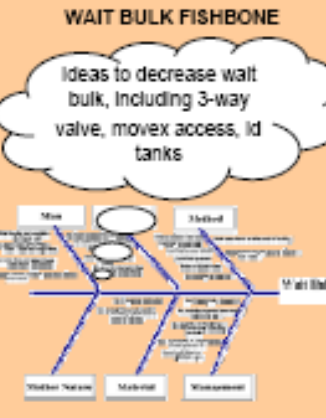



Pharma Company Black Belt Project Storyboard

DEFINE PHASE	MEASURE PHASE	ANALYSE PHASE	IMPROVE PHASE	CONTROL PHASE																				
OBJECTIVE: Grow revenue by enabling expanded capacity through increased throughput on Bosch1 line.	SUMMARY STATISTICS 	CASEPACKER DOWNTIME 	IMPROVEMENT ACTION  •Number tanks on top to facilitate finding •facilitate dual connection of tanks •Get Movex access for material handlers in order that they can find out the number of the tanks Fit new cap hopper	CONTROL New SOP for Bulk handling in Mobile tanks New OEE data collection and reporting system Visual Management System Hand over to process owner Generate OEE Data 																				
GOAL Current average of 22 units/minute•Target 33 units/minute	Average of 22.8 units/min measured over 7 weeks.	5 WHY ANALYSIS 5 Why Analysis – Casepacker Crash 		Introduce Visual management System 																				
FACTORS TARGETED Identify top 5 reasons for downtime and reduce by 50%	STD of 12.5 shows opportunity for improvement.																							
BUSINESS CASE <u>Labour Saving On Bosch One.</u> Increasing Units/Minute from 22 to 33 will reduce required labour (direct) by 33% on this line = 91,675 Euro savings.		WAIT BULK FISHBONE 	Pilot Die- Cut Shipper 5128 <table border="1"><thead><tr><th>Shipper</th><th>Unit</th><th>Shipper</th><th>Unit</th><th>Shipper</th><th>Unit</th><th>Shipper</th><th>Unit</th><th>Shipper</th><th>Unit</th></tr></thead><tbody><tr><td>5127</td><td>32.5</td><td>5132</td><td>32.5</td><td>5125</td><td>32.5</td><td>5128</td><td>32.5</td><td>5129</td><td>32.5</td></tr></tbody></table> Introduce Die-Cut Shippeers 5127, 5132, 5125	Shipper	Unit	Shipper	Unit	Shipper	Unit	Shipper	Unit	Shipper	Unit	5127	32.5	5132	32.5	5125	32.5	5128	32.5	5129	32.5	
Shipper	Unit	Shipper	Unit	Shipper	Unit	Shipper	Unit	Shipper	Unit															
5127	32.5	5132	32.5	5125	32.5	5128	32.5	5129	32.5															
<u>Additional Overhead Recovery.</u> With the saving of the 3,667 hours we can produce an additional 1,222,333 units annually. Fixed overhead recovery per unit is 0.15 Cents. 1,222,333 units at 0.15 fixed overhead per unit would account for 183,349 Euro in additional	Pareto shows areas for further investigation: Casepacker Spills Waiting on bulk Cap Problems Wait Maintenance																							
PROJECT COMPLETION 	OPPORTUNITIES Increase awareness on impact of wait bulk and wait maintenance on downtime.			Units / minute average 32.5 for 2009 Hand over to System owner																				