



Business Improvement Techniques

The grand finale!

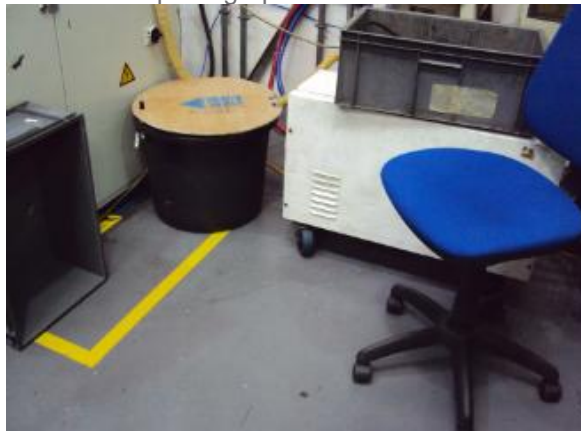
Firstly a massive thank you to everyone that attended our final presentation. It was really encouraging to see so many people.

For those of you who couldn't make it, we started on the mezz floor where the 9 o'clock meetings are held and had a brief introduction from Ro, then moved straight down to F cell.

SSSSS

Billy started us off with the 5S project, and he was like a police officer doing a talk on the crime wave of F cell!!! Very enjoyable and put the rest of the group at ease!!

Nixon then followed on with handing round the crime scene photographs like the one below.



Wendy finished off with an explanation of the 5s board and the audits/actions plans that have taken place over the last 6 months.

Over the period of this project, our audit score has gone from a miserable 38% up to 69%!!!

Delivery Project

We then moved across to the weighing scales and new cabinet in F Cell where Christine gave a brief introduction to the project and then Steve Allen went straight in with the facts and figures:

Team leader: Ro

Team members: Steve G, Christine, Graham, Wendy, Nixon, Steve A, Kevin, Andrew B, Billy

Over a 1 month period, we benchmarked the current situation and found that purely on day shift, Steve had to re-weigh 96 boxes, taking a total of 219 minutes! Over a year this equates to over 1200 boxes and more than 40hrs in wasted time!

By simply making the weighing up process easier, over the following month Steve didn't have to re-weigh a single box, and to date has only found 1 with a quantity error.

Everyone agrees that weighing boxes to a weight now instead of a quantity has been a great improvement and we have also reduced the risk of short supplying to our customers by a considerable amount.

We also have a new cabinet which is larger and easier to use.



Christine followed on and explained that as part of this project we used a the tool called Flow Processing to map out the process of weighing up boxes to give us a clear and detailed view of all the steps involved.

It soon became apparent that very often, the box making area is empty of boxes and people have to walk to stores several times to pick up more boxes.

So, by introducing a very simple kanban system,

Keep it going!

Delivery continued.....

we have been able to ensure there are always boxes at the station, significantly reducing the trips to stores.



To conclude, Christine explained that we have not only saved over 40hrs of time in not needing to re-weigh boxes, but have also saved another 50hrs out of the whole weighing up process by making it easier, quicker, and reducing the trips to the stores. And this is only looking at one shift!

Get up those stairs ;)

We then took everyone up to the meeting room in unit 6 and switched the lights off, I can't repeat what happened in those first 30 seconds....but once everyone had regained composure:

Quality Project

Andrew started us off with an introduction into our Quality project and gave us a run through of a couple of instances where gauges have not been used correctly, causing us to produce scrap parts. Our overall scrap production last year was a whopping:

£Too Much!

Graham then took us through the changes we have made to the in-process sheets, the training that has been rolled out and the results so far.

There has been significant drop in the mistakes being made on the in-process sheets and

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-Team Members: Steve G, Christine, Graham, Wendy, Nixon, Steve A, Kevin, Andrew B, Billy

particularly with the 2 hourly gauge checks we have gone from nearly 50% of sheets being filled out incorrectly to fewer than 18%!!

Cost Project



Kevin started us off by explaining how we have been auditing machinery and office equipment with respect to items being left on after use.

Kevin also explained how we have researched energy saving items such a bulbs and motion sensors, and as a start we have introduced signs everywhere to remind us all to switch of lights where possible.

Steve groves then continued with the results so far. Interestingly, we have gone from an average of 16 machines being left on after use, down to just 3. Computers, monitors and lights etc have stayed pretty much the same at around 4 or 5.

If we consider these machines left on for just 1 single hour after use, over the 74 days since starting our audits, we have saved a minimum of £152!!

And over the last 2 months, our electricity bill has come down from approx £9K to £8K! We cannot claim all of this saving but have surely contributed to this by a significant amount.

Conclusion

As a group, we all felt the course was worthwhile, but highlighted the need for support in all areas. We also felt it could have been condensed and perhaps completed in a shorter time scale.

We really hope another group continues on as there are so many potential projects out there, and we hope the momentum will continue on the projects that we have started.

We also felt that there maybe opportunity for an action team and/or champion to be created in order to keep the focus on this continuous improvement..... Volunteers anyone??