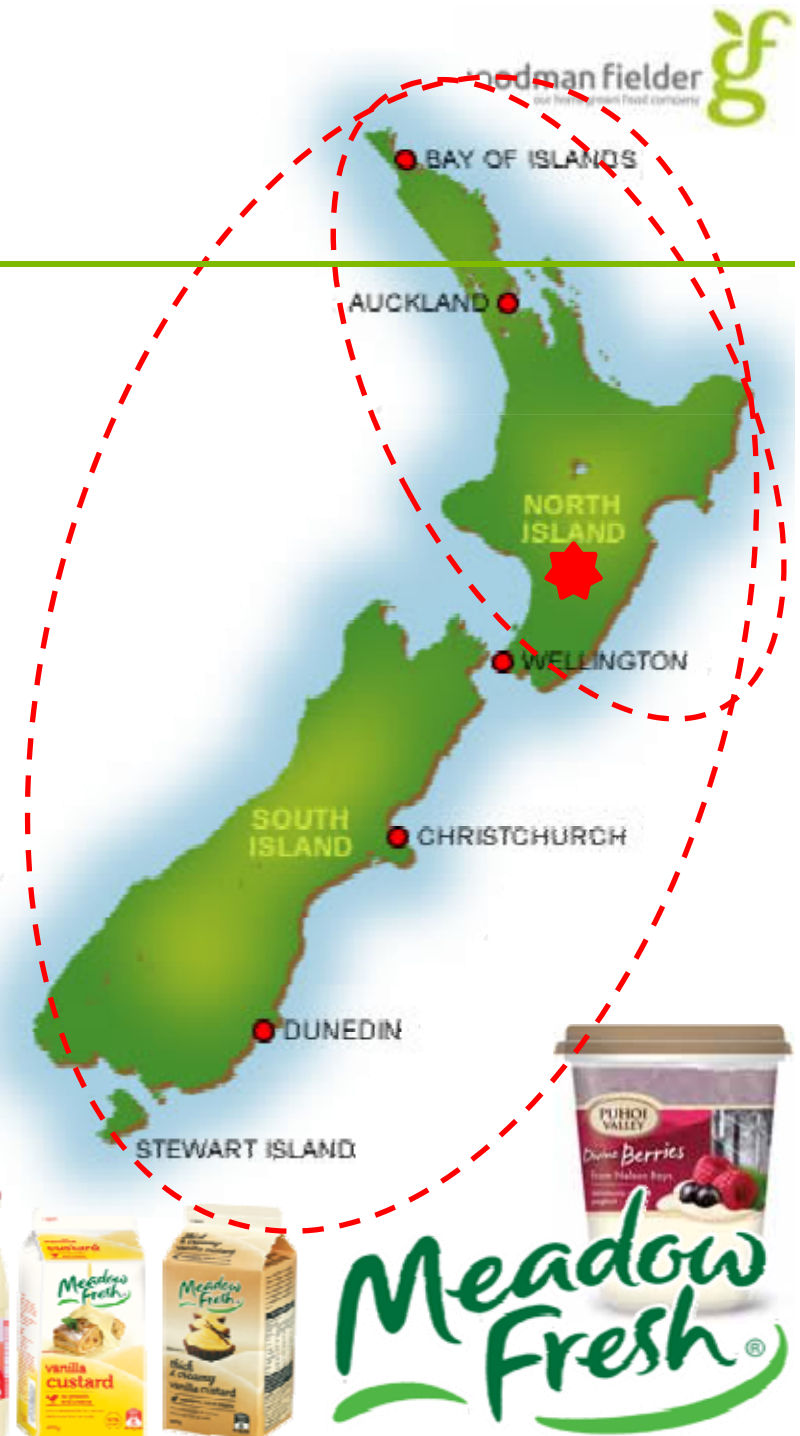


Goodman Fielder Palmerston North Dairy

KEY FACTS	DETAILS
Total number of People	212
Total Volume	93m Bev 16m Cultured
SKUs	Beverages = 93 Cultured Foods = 115
Shift Structure	Beverages - 7 days; 2 shifts; 12 hours per day; 20 per shift Cultured - 5 days; 2 shifts; 18 per shift Process - 24/7; 4 Shifts; 5 per shift
Key Brands & Products	Meadowfresh, Tararua, Puhoi



Cultured Club Micro 2 Line

Macro FE&PI Final Presentation

20th August 2015



Cultured Club



The Team

- Tania (Lead), Gerard (Eng), Tim (Elec), Tania (Tech), Steve (SLT), Patrick (Op), Ross (Super)

Mandate

- Identify all losses across the Micro 2 filler (Filler through to Robot)
- Improve the OEE
- Recommend further actions

Attendance & Schedule

- Attendance 84%
- Schedule 100%



Cultured Club



Macro FE&PI

All Losses within the DPA



Filler



Coding



Packer



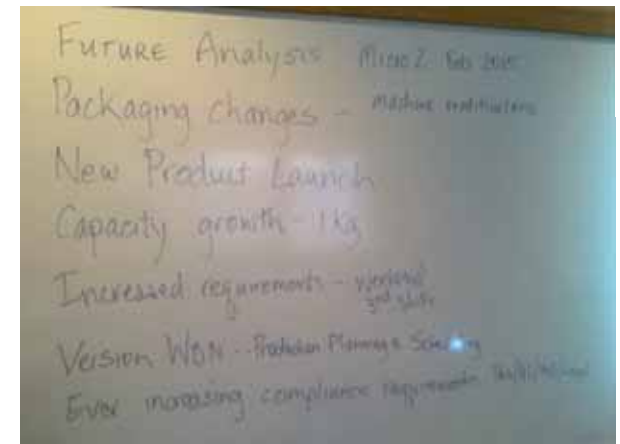
Robot

As is Situation



Future Analysis

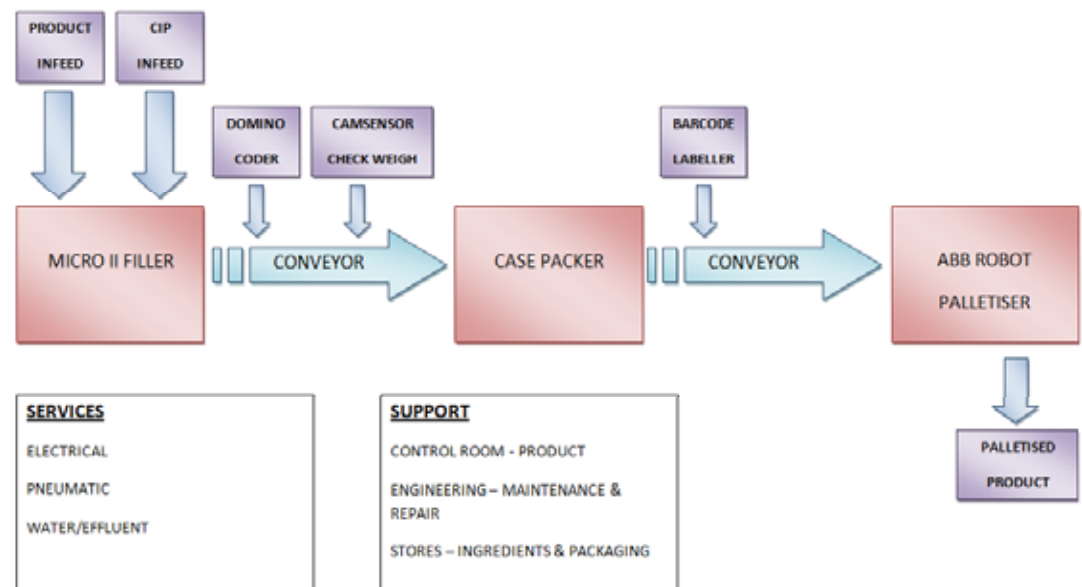
- Packaging changes
- NPD
- Version Won
- Capacity growth 1kg



Process Map

- Identifying the inputs, outputs, support services etc

MICRO II PRODUCTION MAP



As is Situation



Base Skills Analysis

- Staff training matrix
(Train track data base)
37% complete
- Packing area high
level of multi skilling
required
- Filling area specialized
skills

Production Planning Analysis

- 61 Skus
- Version Won project team

Micro 2	
MF YOG BOYSENBERRY 1KGX6	MF CHEESECAKE FILLING 500GMX6
MF YOG APRICOT SUNRISE 1KGX6	MF CHOCOLATE MOUSSE 500GMX6
MF YOG STRAW PATCH 1KGX6	MF COT CHEESE CHIVES 250GMX12
MF YOG NATURAL 1KGX6	MF COT CHEESE GAR/CHIVES 250GMX12
MF YOG BERRY BLISS 1KGX6	MF COT CHEESE LITE 250GMX12
MF YOG LITE BERRY BLISS 1KGX6	MF COT CHEESE LITE GAR/CHIVES 250GMX12
MF YOG LITE VANILLA BEAN 1KGX6	MF COT CHEESE 250GMX12
PUHOI DIVINE BERRIES YOG 450GMX6	MF COT CHEESE 500GMX6
PUHOI APRICOT & HONEY YOG 450GMX6	MF CRM CHEESE LITE 250GMX12
PUHOI DIVINE BERRIES YOG 200GMX12	MF CRM CHEESE SPREADABLE 150GMX12
PUHOI GREEK STYLE YOG 450GMX6	MF CRM CHEESE SPREADABLE 250GMX12
PUHOI LEMON DELICIOUS YOG 450GMX6	MF CRM CHEESE 150GMX12
TARARUA GHERKIN RELISH DIP 250GMX12	MF CRM CHEESE 250GMX12
TARARUA ROAST GARLIC&ONION DIP 250GMX12	MF CREME FRAICHE 250GMX12
TARARUA CREAMY ONION DIP 250GMX12	MF SOUR CREAM LITE 250GMX12
TARARUA SOUR CREAM & CHIVE DIP 250GMX12	MF SOUR CREAM LITE 500GMX6
TARARUA SWEET CHILLI DIP 250GMX12	MF SOUR CREAM 250GMX12
MF YOG SMOOTH FRST BERRIES 1KGX6	MF SOUR CREAM 500GMX6
MF YOG SMOOTH FRENCH VAN 1KGX6	MF YOG GREEK LITE 1KGX6
MF YOG SMOOTH STRAW 1KGX6	MF YOG GREEK 1KGX6
PUHOI LEMON DELICIOUS YOG 200GMX12	MF YOG LOVELY LEMON 1KGX6
PUHOI HEAVENLY RHUBARB YOG 450GMX6	MF SOUR CREAM 1KGX6
M/F NAT SMOOTH YOG 1KG (6)	MF CRM CHEESE 1KGX6
PUHOI FABULOUS FEJOA YOG 450GX6	PUHOI HEAVENLY RHUBARB YOG 200GMX12
PUHOI LUSCIOUS NECTARINE YOG 450GX6	PUHOI YOG BLACK DORIS PLUM 450GX6
PUHOI LUSCIOUS NECTARINE YOG 200GX12	PUHOI YOG BLACKCURRANT VAN 450GX6
PUHOI FABULOUS FEJOA YOG 200GX12	MF GREEK CENTRES YOG PINACOLADA 175GX12

The Base Line



Measure	Weekly average
Production OEE	52.3%
ATP	67.99%
Waste	1.89%
Near miss reporting	1
\$ per kg	\$0.277
Customer Complaints	4

Audits



Are Specification, SOP's, Manuals, Drawings, Maintenance records etc...

- Were they easy to find
- Were they easy to understand
- Are they up to date



Audits



Maintenance Knowledge Base Summary Sheet

Defined Production Area: *Cultured Micro II Line*

Mechanical or ~~Electrical~~ (cross out)

Date:

Maintenance Knowledge Base Summary Sheet

Defined Production Area: *Micro II*

~~Mechanical~~ or Electrical (cross out)

Date: *04-03-2015*

Operator Knowledge Base Summary Sheet

Defined Production Area: *Cultured Foods micro 2.*

Date: *9-03-2015*

Area of Focus	What are we Reviewing	What did we find?	What does this mean?
Materials Specifications (Input) <i>How do we know we are using quality input materials?</i>	Easy to find	<i>The Operator was confused me too a little bit.</i>	<i>Are we talking about Specs that we don't see eg. COA on fruit?</i>
	Easy to understand	<i>The Operator can identify the correct packaging & product by visual and taste.</i>	
	Up to date	<i>?</i>	
Standard Operating Procedures (SOPs) <i>How do we know how to produce our output correctly?</i>	Easy to find	<i>Yes. Either in the Specs office or technical office</i>	<i>We should all be operating the same but to be honest I never look at the manual.</i>
	Easy to understand	<i>Yes easy to read and understand.</i>	
	Up to date	<i>Yes</i>	

Operator Survey Ratings



Defined Production Area: Micro 2

Date: 4 March

Number of Respondents: 9

Rating	Ease of Operation	Reliability	Process Capability	Housekeeping	Safety	Waste Performance	Maintenance Practice
Excellence	Very easy to operate	Never breaks down	Setup machine with no further adjustments needed	Very clean and well organised workplace	Very safe, no known safety hazards	Zero waste or rework	Weekly maintenance servicing and inspections
	Easy to operate	Reliable machine, breakdowns are rare	Few adjustments needed while running	Clean and organised workplace	Safe with known safety hazards	Very little waste or rework	Monthly maintenance servicing and inspections
	Fair to operate	Fairly reliable	Some adjustments needed while running	Fair workplace	Safety hazards are a concern	Average waste rate	Quarterly maintenance servicing and inspections
	Hard to operate	Often breaks down, not very reliable	Many adjustments needed while running	Dirty and unorganised workplace	Safety hazards are a big concern	High waste rate	Yearly maintenance servicing and inspections
Innocence	Very hard to operate	Always breaking down	Constant adjustments needed while running	Very dirty and very unorganised workplace	Serious safety hazards present	Very high waste rate	Maintenance only comes when machine breakdowns

Operator Survey Ratings



Defined Production Area: **Casepacker/Robot**

Date: **4 March**

Number of Respondents: **5**

Rating	Ease of Operation	Reliability	Process Capability	Housekeeping	Safety	Waste Performance	Maintenance Practice
Excellence	Very easy to operate	Never breaks down	Setup machine with no further adjustments needed	Very clean and well organised workplace	Very safe, no known safety hazards	Zero waste or rework	Weekly maintenance servicing and inspections
	Easy to operate	Reliable machine, breakdowns are rare	Few adjustments needed while running	Clean and organised workplace	Safe with known safety hazards	Very little waste or rework	Monthly maintenance servicing and inspections
	Fair to operate	Fairly reliable	Some adjustments needed while running	Fair workplace	Safety hazards are a concern	Average waste rate	Quarterly maintenance servicing and inspections
	Hard to operate	Often breaks down, not very reliable	Many adjustments needed while running	Dirty and unorganised workplace	Safety hazards are a big concern	High waste rate	Yearly maintenance servicing and inspections
Innocence	Very hard to operate	Always breaking down	Constant adjustments needed while running	Very dirty and very unorganised workplace	Serious safety hazards present	Very high waste rate	Maintenance only comes when machine breakdowns

Operator Survey Comments



Defined Production Area: **Micro 2**

Date: **4 March**

Number of Respondents: **9**

What do you like most about operating Micro 2 Filler?	What do you dislike most operating Micro 2 Filler?	How can we improve the operation of Micro 2 Filler?
<ul style="list-style-type: none"> - It's capability. When it's running good inside and out, it's a good day or night..... - I like doing the long runs of product - That a good form help operator helps with packaging, change parts etc - Easy to run when settings have not been adjusted. - Easy to operator - I like M2 if I didn't have the problems below (next two columns) - When it's running it is awesome 	<ul style="list-style-type: none"> - When doing Puhoi cup detector doesn't work. Which can cause high wastage. Also foil alignment on Puhoi can be annoying - The small things that need to be fixed and aren't. - Make operating a whole lot easier. - The camera doesn't work, hasn't for years, waste of money, get rid of it cause it's in the way. - Walking up and down the steps to fill the lids on kilos!!! - No maintenance done except when it breaks, even then it's a patch up job. - Standing on the uneven platform. - The camera doesn't work. - The number of times you have to walk up and down both sets of steps in a shift. - How hot it gets. - The cup & foil detectors don't work. - Having to adjust foils for Puhoi. - The check weigher weight is different from the operator scales weight. - Lifting the jet coder head is heave. - Only have log sheet now not log book, so you can't look back to the day before to see if there were problems with parts etc. - It's not easy to clean "properly". - Too many changes and change parts. - CIP pipes hard to attach. - Heaters awkward to change over. - Bulk filling is awkward and cramped - 10kg bucket filling not safe or hygienic. - The 1kg cup dispensers are heavy and hard to lift out of place to change over. - Settings / parts moved and not told. - Standing on the hard platform - Puhoi foils randomly misplaced 	<ul style="list-style-type: none"> - Fix cup detector - Fix camera - Foil alignment – reset block - Regular maintenance work on the machine. - Fix things when operators ask – not just a patch up. - Set lids / foils up (fix position) so there isn't any movement – has to be adjusted every time for a new product. - Fix the cup & foil detectors - God back to log "books" - Easier system for heater removal etc - Set up better bulk filling area & system - Fix camera - Build conveyor for 10gk bulk - Settings stayed the same so it will run smoother - More maintenance and inspections/servicing - Maybe platform from cups to foils that's easily removed - Do not do 1kg sour cream and trad com cheese in the old pots - Have settings/recipe for each sku so nothing has to be changed/alterd to get machine to run well - Overhaul of the foil placement setup
	<ul style="list-style-type: none"> - Puhoi white spitting over the edge of the pots causing non sealers - Boxes to big getting them up the landing and heavy - Made it harder to operate when the filler was lifted (for me), maybe I'm just getting to old for this machine - When foil placement plays up and can't be sorted - Camera's not working - Cup detect does not work 	

Operator Survey Comments



Defined Production Area: Casepacker/Robot

Date: 4 March

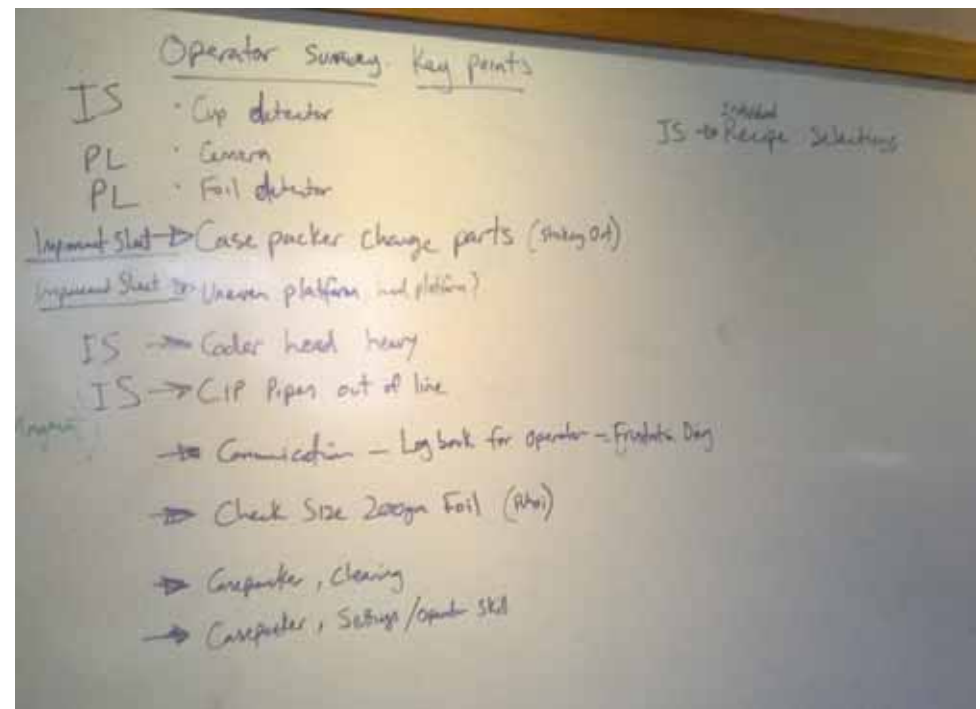
Number of Respondents: 5

<p>What do you like most about operating this line/equipment/machine?</p>	<p>What do you dislike most operating this line/equipment/machine?</p>	<p>How can we improve the operation if this line/equipment/machine?</p>
<ul style="list-style-type: none"> - When I have adjusted settings so boxes are glued etc, machine will usually run without fault for the day. - Not having to hand pack 1kgs - It keeps me thinking. - Learn something new all the time. - Easy to operate when people don't move setting and don't let you know. - Easy loading cases than packing on M1 or Smooth line - The fact that you are pretty much your own boss for the day, no one to bug you 	<ul style="list-style-type: none"> - Casepacker glue spraying everywhere. - Having to help adjust and set up Micro 1 (celltape machine) line sometimes especially when I have my own line to watch, setup and adjust. - Robot – broken or damaged pallets. Sometimes not holding onto bulk product boxes and dropping them and making a big mess, tape or suckers not holding onto boxes. - Haven't got any dislikes about operating it. But some of the equipment is bent, not working properly etc. - Change parts wrong sizes or not fitting. - Not being kept clean - Too many people keep changing settings. - When it plays up, can become a nightmare - Keeping an eye on micro 1 packers, making sure they don't run out of labels, tape etc, this happens quite a bit depending on who is on. - Taking over from the last casepacker operator, depending on who it is, loves to leave their \$%#@*& mess for you to clean up, &^%\$ me off, we don't do it to them 	<ul style="list-style-type: none"> - Fix all of the above if possible - Cleaning maintained regularly - Head plates need encasement (hazard) - I don't know this machine too well but I think some of the parts need adjusting like some of the attachments and also the numbers on the sheet don't always match up to what it's supposed to be set on. - Glue needs to be fixed so it doesn't spray everywhere, if it's not the glue it's the settings. - Needs to be cleaned on a regular basis. - One way to operate - Maintenance, service - Engineering very unreliable.

Operator Survey Key points



- Opportunity for better communication between maintenance and production
- Cup detector
- Foil detector
- Platform improvements
- CIP pipes
- Jet coder setup
- Case packer change parts



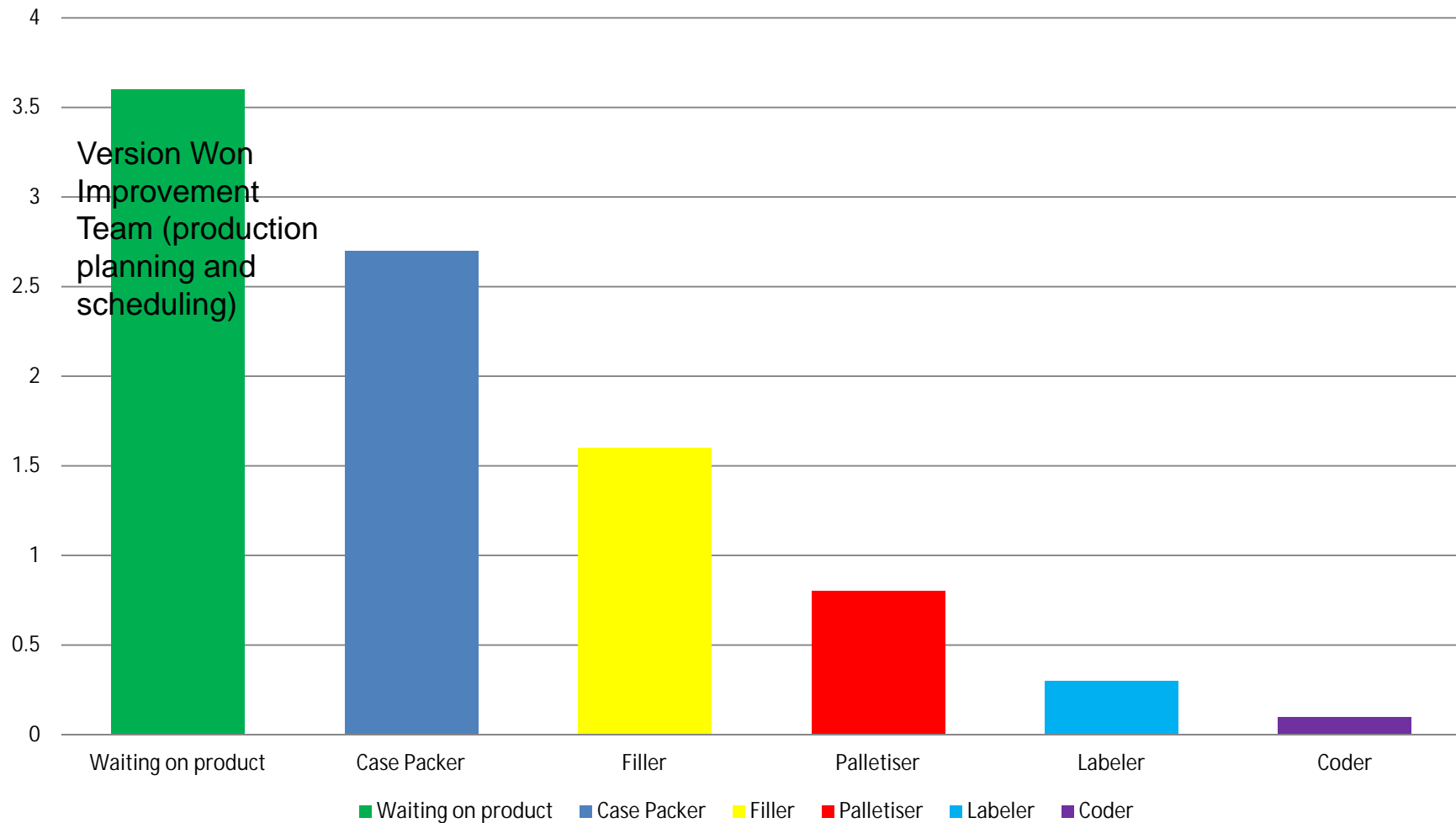
Go & See – OEE Loss Analysis



Go & See – OEE Loss Analysis



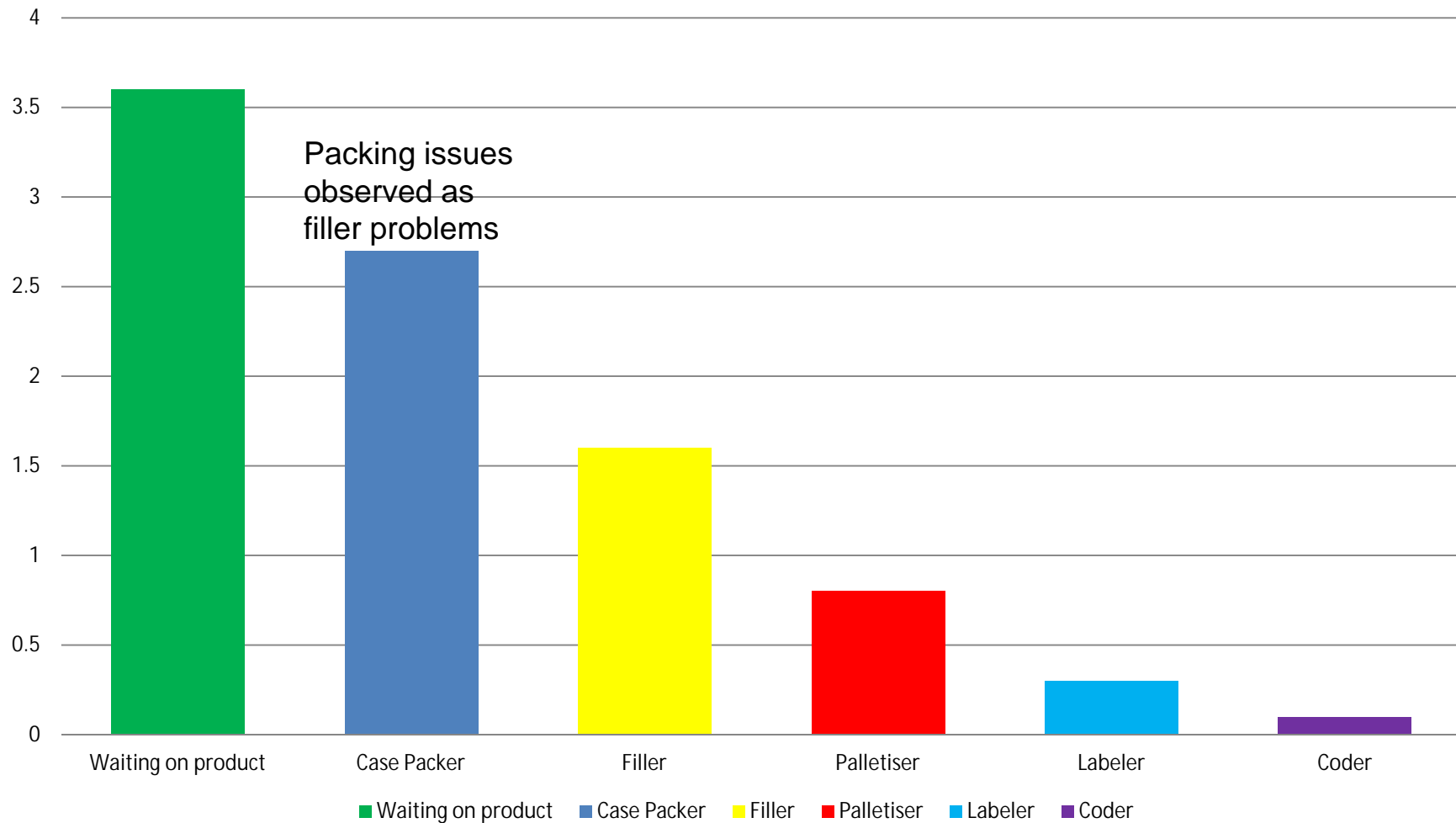
Culture Club 2nd Level Pareto Unplanned Downtime



Go & See – OEE Loss Analysis



Culture Club 2nd Level Pareto Unplanned Downtime



Go & See – OEE Loss Analysis



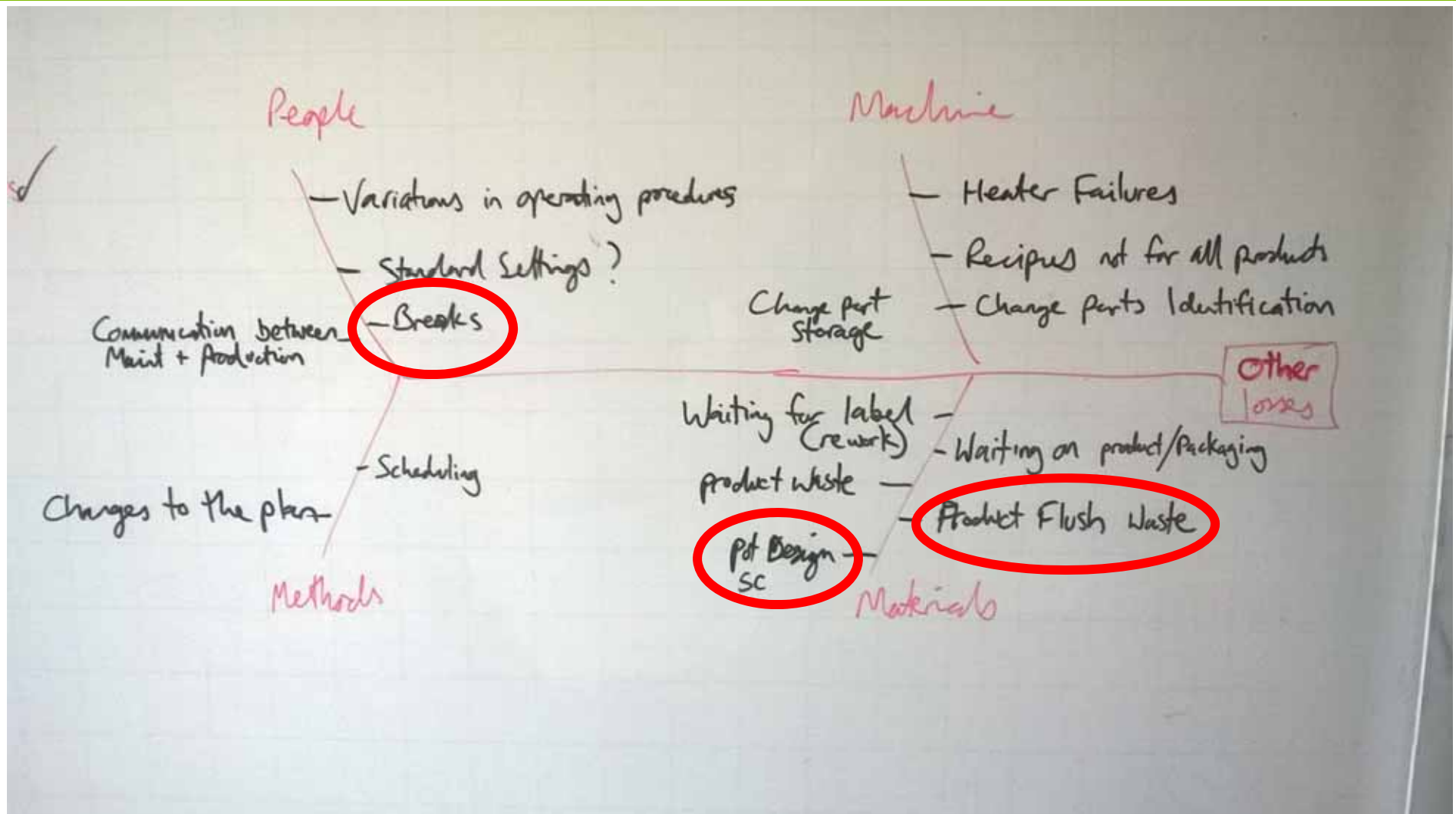
2nd Level OEE Loss Analysis			Analysis - Previous	Prod Reports (uk 2)	Prod Reports (uk 3)	Prod Reports (uk 4)	UD 1 (Mon) (14.30-15.00)	UD 2 (Mon) (07.00-9.00)	UD 3 (Thu) (15.30-16.30)	"As-Is" OEE	
Loss Description			% Loss	% Loss	% Loss	% Loss	% Loss	% Loss	% Loss	% Loss	
A	Planned Downtime	Planned Maintenance	0.0%							0.0%	
		Team Daily Review / Toolbox Meeting	1.7%	1.8%	1.8%	1.8%				1.8%	
		Planned Start of Shift Downtime								0.0%	
		Paid Breaker Downtime	8.9%	10.0%	7.3%	10.9%	15.2%			9.4%	
		CIP	1.0%		0.7%	2.2%		12.0%		1.0%	
										0.0%	
		Other Planned Downtime								0.0%	
	Set-up Downtime	Set-up / Changeover Time	10.8%	12.7%	13.6%	14.2%	8.9%	8.3%	12.7%	13.5%	
	Unplanned Recorded Downtime	Filler	1.6%	2.6%	2.3%	2.1%		10.4%	10.3%	2.3%	
		Camera	0.0%	0.0%	0.0%	0.0%				0.0%	
		Coder	0.1%	0.0%	0.0%	0.0%				0.0%	
		Check Weigher	0.0%	0.0%	0.0%	0.0%				0.0%	
		Casepacker	2.7%	1.2%	2.1%	1.7%				1.7%	
		Labeller	0.3%	0.0%	0.0%	0.0%				0.0%	
		Palletiser	0.8%	0.6%	0.4%	1.0%				0.7%	
	Waiting for product/packaging/QA etc	3.6%	12.0%	1.3%	9.6%		7.5%		7.6%		
R	Minor Unrecorded Stoppages	Filler		3.6%	14.9%	4.2%	0.4%	10.4%	12.0%	7.6%	
		Camera							0.0%		
		Coder									
		Check Weigher							0.0%		
		Casepacker					2.7%		2.4%	1.7%	
		Labeller							2.8%		
		Palletiser					1.7%		1.7%	1.1%	
			Waiting for product/packaging/QA etc					4.8%			1.6%
	Reduced Speed	Slow Running	12.3%							0.0%	
		Time to achieve Good Output at Correct Speed after start-up (eg from set-up or								0.0%	
Q	Rejects & Rework	Filler					0.6%	2.0%	0.1%	0.5%	
		Camera								0.0%	
		Coder									
		Check Weigher					0.1%		0.1%		
		Casepacker					0.2%	0.0%	0.2%	0.1%	
		Labeller									
		Palletiser								0.0%	
		Waiting for product/packaging/QA etc								0.0%	
	Start-Up & Yield	Start-up Product Loss till Good Output		Unknown	Unknown	Unknown	0.3%				0.1%
		Overfill Yield Loss while running		Unknown	Unknown	Unknown					0.0%
Error in Data Collection				n/a	n/a	n/a	12.4%	0.1%	5.3%	n/a	
Total Losses (Potential for Improvement)			43.8%	44.5%	44.4%	47.6%	34.9%	50.6%	42.3%	50.6%	
HLOEE			56.2%	55.5%	55.6%	52.4%	52.7%	49.3%	52.4%	49.4%	

Go & See – OEE Loss Analysis



			Baseline Analysis	"As-Is" OEE	Target for this Cycle		Improvem ent for this	Target at completion of Cycle
Loss Description			% Loss	% Loss	% Loss	Level Totals	% Loss	Reasons for Setting Target Improvements
A	Planned Downtime	Planned Maintenance	0.0%	0.0%	0.0%		0.0%	
		Team Daily Review / Toolbox Meeting	1.7%	1.8%	1.7%		0.1%	
		Planned Start of Shift Downtime	0.0%	0.0%	0.0%		0.0%	
		Paid Breaks Downtime	8.9%	9.4%	0.0%		9.4%	Cover to run through/make
		CIP	1.0%	1.0%	1.0%		0.0%	
		WAM / OEM Activity Time	0.0%	0.0%	2.0%		-2.0%	Increase CI activity
	Other Planned Downtime	0.0%	0.0%	0.0%	4.7%	0.0%		
	Set-up Downtime	Set-up / Changeover Time	10.8%	13.5%	10.8%	10.8%	2.7%	Jet color, CIP pipes, Pat and fail detectors - less clean up required
	Unplanned Recorded Downtime	Filler	1.6%	2.3%	1.5%		0.8%	Pat and fail detectors
		Camera	0.0%	0.0%	0.0%		0.0%	
		Coder	0.1%	0.0%	0.0%		0.0%	
		Check Weigher	0.0%	0.0%	0.0%		0.0%	
		Case packer	2.7%	1.7%	1.7%		0.0%	
		Labeller	0.3%	0.0%	0.0%		0.0%	
		Palletizer	0.8%	0.7%	0.0%		0.7%	
R	Minor Unrecorded Stoppages	Waiting for product/packaging/QA etc	3.6%	7.6%	5.0%	8.2%	2.6%	Version Wan Project
		Filler	0.0%	7.6%	5.0%		2.6%	Pat and fail detectors
		Camera	0.0%	0.0%	0.0%		0.0%	
		Coder	0.0%	0.0%	0.0%		0.0%	
		Check Weigher	0.0%	0.0%	0.0%		0.0%	
		Case packer	0.0%	1.7%	1.7%		0.0%	
		Labeller	0.0%	0.0%	0.0%		0.0%	
		Palletizer	0.0%	1.1%	1.1%		0.0%	
	Reduced Speed	Waiting for product/packaging/QA etc	0.0%	1.6%	1.6%	3.4%	0.0%	
		Slow Running	12.3%	0.0%	0.0%		0.0%	
		Time to achieve Good Output at Correct Speed after start-up (e.g. from start-up or	0.0%	0.0%	0.0%	0.0%	0.0%	
	Q	Rejects & Rework	Filler	0.0%	0.5%	0.5%		-0.1%
Camera			0.0%	0.0%	0.0%		0.0%	
Coder			0.0%	0.0%	0.0%		0.0%	
Check Weigher			0.0%	0.0%	0.0%		0.0%	
Case packer			0.1%	0.1%	0.1%		0.0%	
Labeller			0.0%	0.1%	0.1%		0.0%	
Palletizer			0.0%	0.0%	0.0%		0.0%	
Waiting for product/packaging/QA etc			0.0%	0.0%	0.0%	0.7%	0.0%	
Start-Up & Yield Loss		Start-up Product Loss till Good Output	0.2%	0.1%	0.1%		0.0%	
		Overfill Yield Loss while running	0.0%	0.0%	0.0%	0.1%	0.0%	
Total Losses (Potential for Improvement)			44.1%	50.6%	33.9%	33.9%	16.7%	
OEE			55.9%	49.4%	66.1%			

Go & See – Other Losses



The Improvement Plan



Result of the...

- Audits
- Operator Surveys
- OEE Observations

Culture Club Improvement Plan



	Improvement Sheet Action	Benefit
1	Case packer changeover parts guard	H&S+
2	Realign CIP Pipes for easier/faster connections	H&S+, DT-
3	Platform with teleplanks, improving platform stability and cleaning/servicing access	H&S+, DT-, Hygiene+, R&M+
4	Jet coder mount for easier and faster changeovers.	H&S, C/O time-, Quality+
5	Re-instate foil sensor to proper operation	OEE+, Waste-, DT-
6	Re-instate pot sensor to proper operation	OEE+, Waste-, DT-, Hygiene,
7	Schedule smoko breaks to keep critical lines operating all the time	Output+, OEE+
8	Monty: change pots from old square tub to Monty for all grades	OEE+, Waste-, C/O time-
9	Amalgamate existing 6 check books, update and combine into one book	Save time, Quality+
10	Communication between Maintenance and Operations- weekend Maintenance Plan	DT-
11	Establish agreed centreline settings and visual controls for the case packer	OEE+, Waste-, Quality+
12	Establish agreed centreline settings and visual controls for the filler	OEE+, Waste-, Quality+

Culture Club Improvement Plan



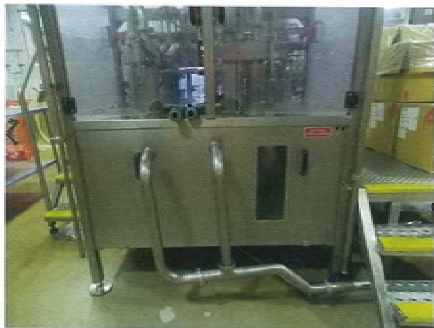






	Improvement Sheet Action	Cost	Benefit
1	Isolate/guard spikey case packer changeover parts	\$1,000	H&S+

TPM ³ Improvement Sheet							
Team Name:	Culture Club		Location:	Culture Packing		Initiated Date:	01-04-15
Initiator:		Item:		Completed Date:			
Team Leader:	Tania Wilton						
1. Problem (Plan)							
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)				
Photo:			Sketch:				
							
Improvement Target:	To encase protruding size change parts		Expected Cost:	Expected Completion Date:	Expected Saving:		
4. Results: (Check)			5. Future Actions: (Act)				
		Actual Cost:					
		Actual Savings:					
Approved by:		TL - Shift A	TL - Shift B	Maintenance	Technical	LT Member	
Discuss with team then sign off acceptance of Proposed Change							
CTPM Australia							
<input type="checkbox"/> Risk Assessment Completed			<input type="checkbox"/> Proposed Change Approved		<input type="checkbox"/> Improvement Being Worked On		

Culture Club Improvement Plan





	Improvement Sheet Action	Cost	Benefit
2	Realign CIP Pipes for easier/faster connections	\$1,000	H&S+, DT-

TPM ³ Improvement Sheet						
Team Name:	Cultured Foods	Location:		Initiated Date:	18/03/2015	
Initiator:	Gerard B	Item:	Micro 2 CIP Pipes	Completed Date:		
Team Leader:	Tania W					
1. Problem (Plan) The CIP Pipes are very hard to connect and need adjusting or straightening. Most of the time you need a second person to help line up the pipes before doing them up. A Work Request has been put into the system (C76827)						
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)			
Photo:			Sketch / Photo:			
						
Improvement Target:	To get the Pipes Straightened or adjusted so the Operators can put them on without struggling.		Expected Cost:	Expected Completion Date:	Expected Saving:	
4. Results: (Check)			5. Future Actions: (Act)			
		Actual Cost:				
		Actual Savings:				
Approved by:		TL - Shift A	TL - Shift B	Maintenance	Technical	LT Member
Discuss with team then sign off acceptance of Proposed Change						
CTPM Australasia						

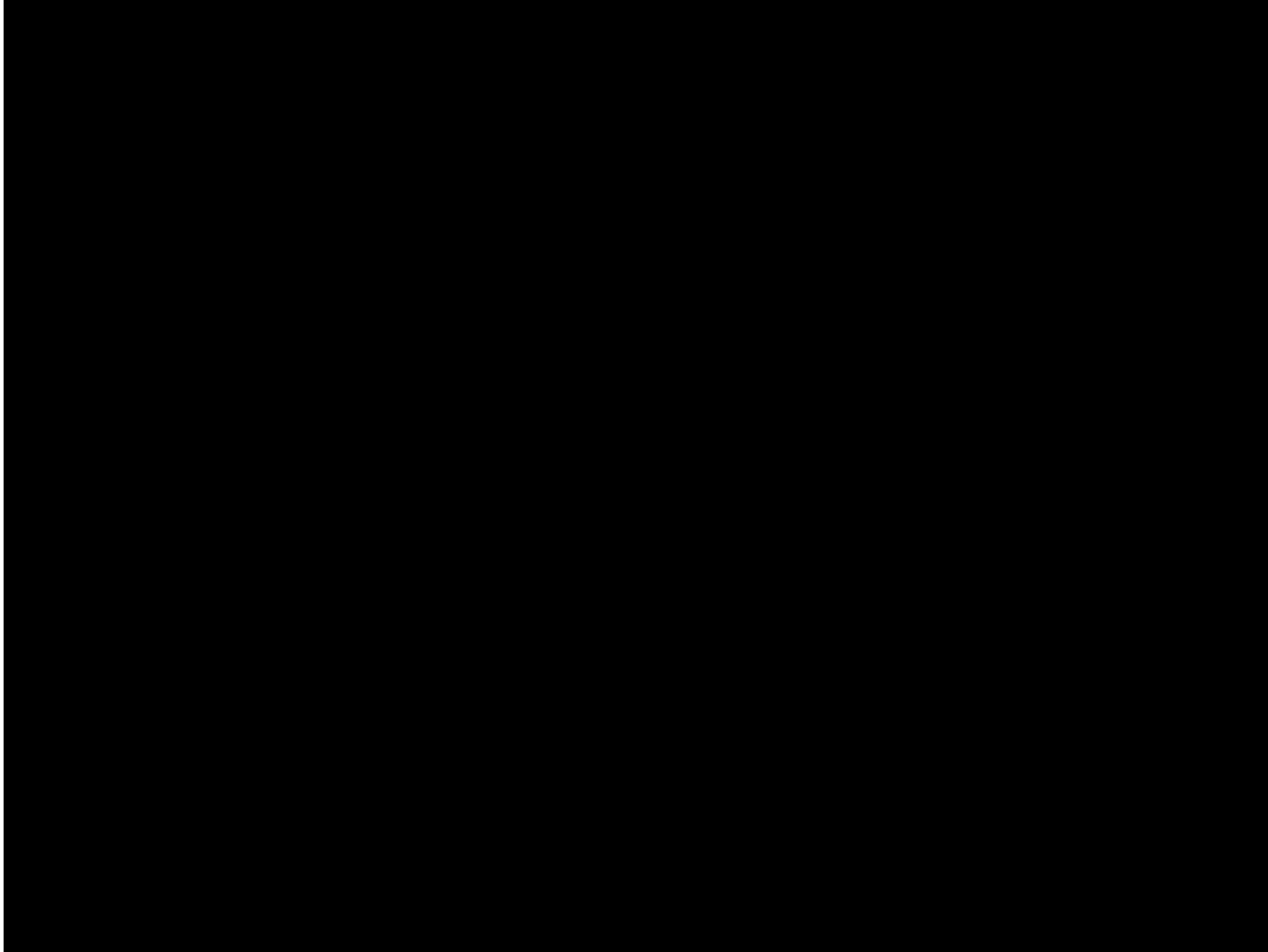
Culture Club Improvement Plan



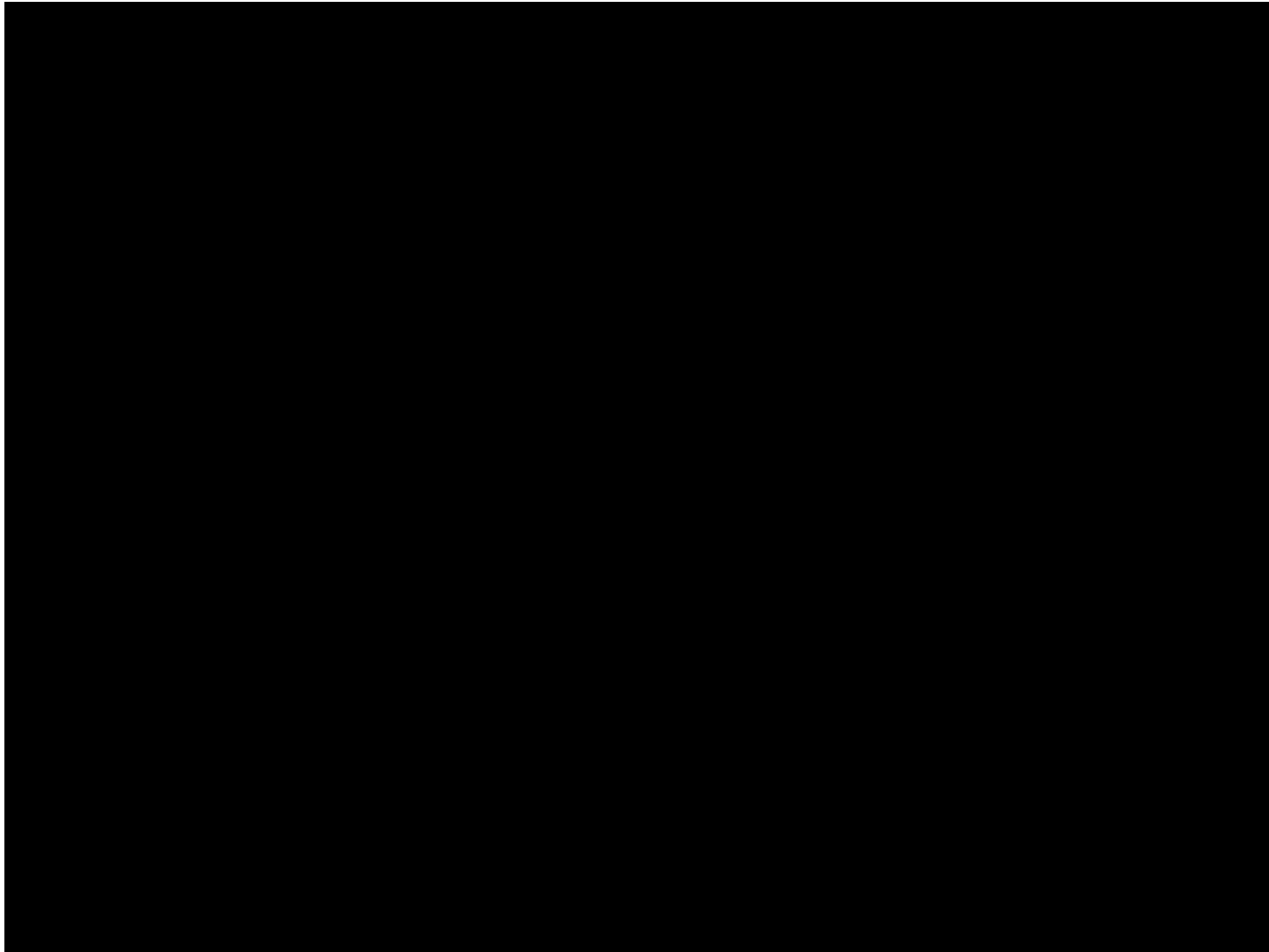
	Improvement Sheet Action	Cost	Benefit
3	Replace platform with teleplanks, improving platform stability and access for cleaning and servicing	\$10,000	H&S+, DT-, Hygiene+, R&M+

TPM ³ Improvement Sheet						
Team Name:	Culture Club	Location:	Cultured Filling Room	Initiated Date:	17-03-15	
Initiator:	Gerard Buys	Item:	Micro 2 Operator Platform	Completed Date:		
Team Leader:	Tania Wilki					
1. Problem (Plan)						
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)			
Photo:			Sketch / Photo:			
						
Improvement Target: Improve operator platform for ease of cleaning, machine maintenance and operator stability			Expected Cost:	Expected Completion Date:	Expected Saving:	
4. Results: (Check)			5. Future Actions: (Act)			
Actual Cost:						
Actual Savings:						
Approved by:			TL - Shift A	TL - Shift B	Maintenance	Technical
Discuss with team then sign off acceptance of Proposed Change						
CTPM Australasia						

Culture Club Improvement Plan



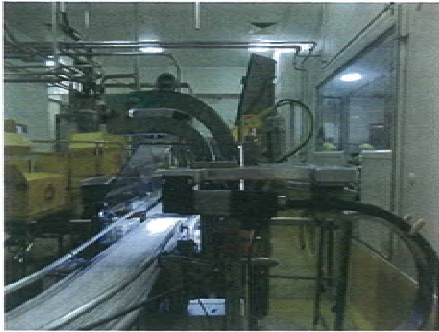
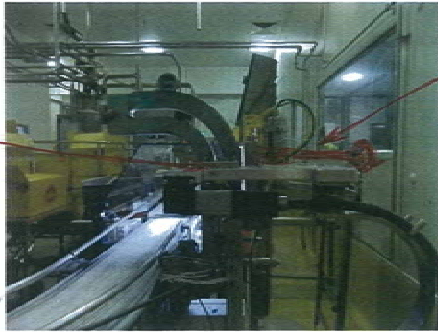


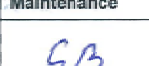

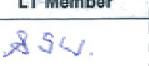
Culture Club Improvement Plan



Culture Club Improvement Plan

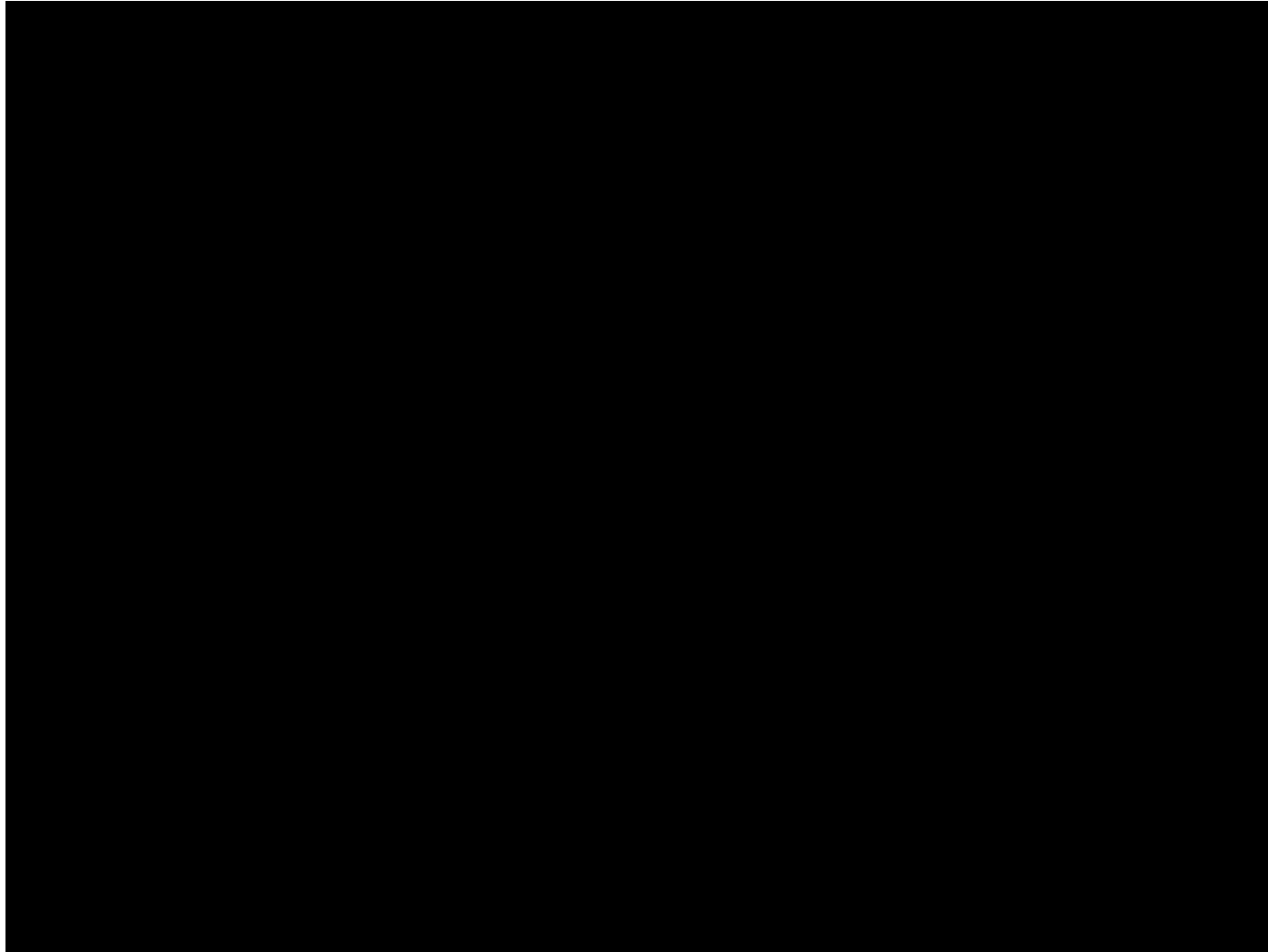


	Improvement Sheet Action	Cost	Benefit
4	Mount date jet coder on stand with threaded adjusters for easy and faster changeovers. Installation next week	\$4,000	H&S, C/O time-, Quality+

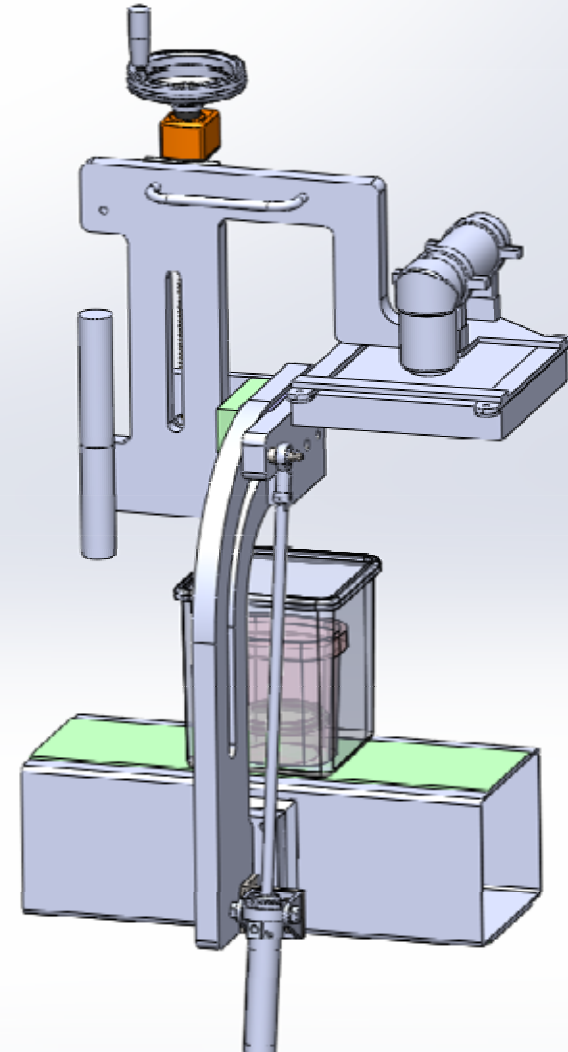
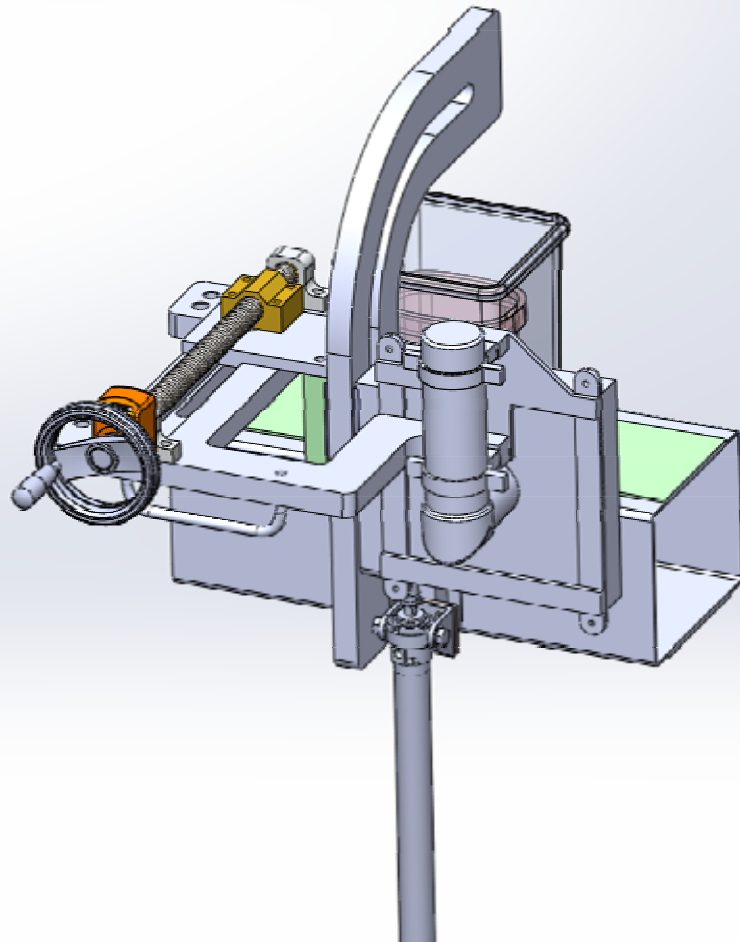
TPM ³ Improvement Sheet					
Team Name:	Cultured Club	Location:	Cultured Filling Room	Initiated Date:	17-03-15
Initiator:	Gerard Buys	Item:	Micro 2 Jet Coder Stand	Completed Date:	
Team Leader:	Tania Wiki				
1. Problem (Plan)					
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)		
Photo:			Sketch / Photo:		
					
Improvement Target: To make it easier for operators to set up Jet coding			Expected Cost:	Expected Completion Date:	Expected Saving:
4. Results: (Check)			5. Future Actions: (Act)		
Actual Cost:					
Actual Savings:					
Approved by: TL - Shift A:  TL - Shift B:  Maintenance:  Technical:  LT Member: 					
Discuss with team then sign off acceptance of Proposed Change					

CTPM Australasia

Culture Club Improvement Plan



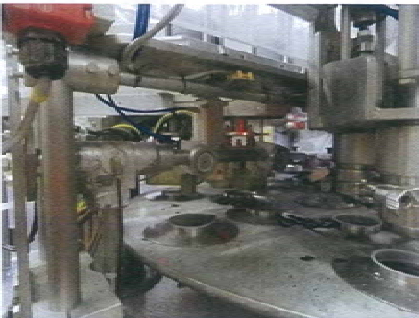

Culture Club Improvement Plan



Culture Club Improvement Plan



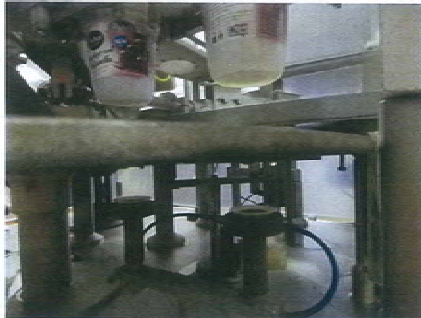


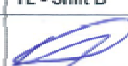


	Improvement Sheet Action	Cost	Benefit
5	Re-instate foil sensor to proper operation reducing waste, cleaning time and increase output and OEE	\$2,000	OEE+, Waste-, DT-

TPM ³ Improvement Sheet								
Team Name:	Culture Club		Location:	Cultured Filling		Initiated Date:	24-03-15	
Initiator:			Item:			Completed Date:		
Team Leader:	Tara							
1. Problem (Plan)								
Foil sensor that should pick up missing foils does not work.								
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)					
Photo:			Sketch / Photo:					
								
Improvement Target:	To design and fit a reliable foil missing sensor.		Expected Cost:		Expected Completion Date:		Expected Saving:	
4. Results: (Check)			5. Future Actions: (Act)					
Actual Cost:								
Actual Savings:								
Approved by:			TL - Shift A	TL - Shift B	Maintenance	Technical	LT Member	
Discuss with team then sign off acceptance of Proposed Change			Tara	[Signature]	JS	[Signature]	[Signature]	
CTPM Australasia								
<input type="checkbox"/> Risk Assessment Completed			<input type="checkbox"/> Proposed Change Approved		<input type="checkbox"/> Improvement Being Worked On			

Culture Club Improvement Plan





	Improvement Sheet Action	Cost	Benefit
6	Re-instate pot sensor to reduce waste, downtime, cleaning requirements and increase output and OEE	\$2,000	OEE+, Waste-, DT-, Hygiene,

TPM ³ Improvement Sheet						
Team Name:	Culture Club	Location:	Cultured Filling.	Initiated Date:	17-03-15	
Initiator:	Gerard Buys	Item:		Completed Date:		
Team Leader:	Tania					
1. Problem				(Plan)		
Current pot missing sensor not reliable,						
2. Current Situation		(Plan)		3. Proposed Change / Approved Improvement (Do)		
Photo:		Sketch / Photo				
						
Improvement Target:	To improve pot missing sensor so it works reliably.		Expected Cost:	Expected Completion Date:	Expected Saving:	
4. Results:			5. Future Actions:			
Actual Cost:						
Actual Savings:						
Approved by:		TL - Shift A	TL - Shift B	Maintenance	Technical	LT Member
Discuss with team then sign off acceptance of Proposed Change				GP		
CTPM Australia						
<input type="checkbox"/> Risk Assessment Completed <input type="checkbox"/> Proposed Change Approved <input type="checkbox"/> Improvement Being Worked On						

Culture Club Improvement Plan



	TPM Improvement Sheet Action	Cost	Benefit	
7	Schedule smoko breaks to keep critical lines operating all the time. Won't fully capture benefits as impacted by multiple outside factors	TBA	Output+, OEE+	8% increase in production OEE

Team Name:	Cultured Club	Location:	Cultured Foods	Initiated Date:	23/04/15
Initiator:	Tania	Item:	Continuous Running	Completed Date:	
Team Leader:	Tania				
1. Problem (Plan)					
Micro2 is a heavily load machine production wise and running this line continuously through breaks would give up to 2 hrs a day extra production time also providing gaps for other activities like cleaning, training, CI etc					
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)		
Photo: Currently up to 2/hrs per day can be lost through stopping the filler while operators have their smoko breaks			Sketch / Photo: Provide cover to ensure the line can run through smoko breaks		
					






Culture Club Improvement Plan



	TPM Improvement Sheet Action	Cost	Benefit
8	Monty: change pots from old square tub to Monty for all grades, reducing waste and changeover time and OEE	TBA	OEE+, Waste-, C/O time-

	Old	Monty
Waste	6.98%	1.26%
Run times	160 ctns per hour	346 ctns per hour

	Old	Monty	Total
BOM	+20k	-10k	\$30k
Our people			

Culture Club Improvement Plan

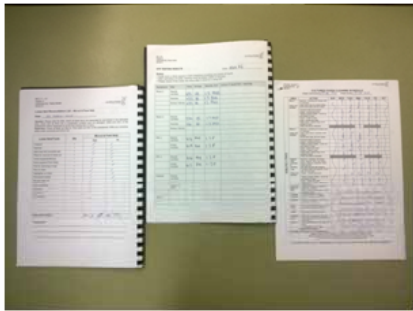
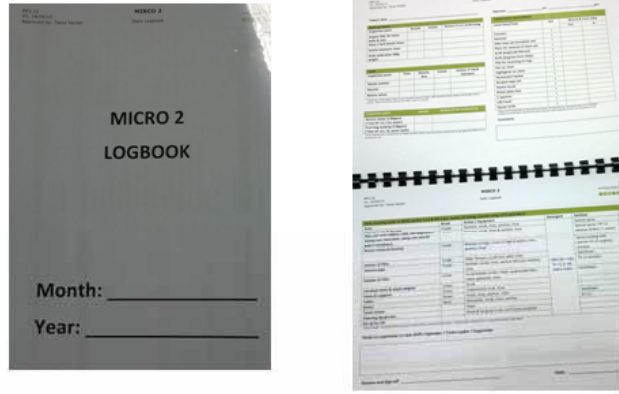


Operator reaction to the Monty

Culture Club Improvement Plan



	TPM Improvement Sheet Action	Cost	Benefit	
9	Amalgamate existing 6 check books, update and combine into one book	Operator time	Save time, Quality+	

Team Name:	Cultured Club	Location:	Cultured Foods	Initiated Date:	23/04/15
Initiator:	Tania	Item:	Log books	Completed Date:	
Team Leader:	Tania				
1. Problem (Plan)					
To many log books					
2. Current Situation (Plan)			3. Proposed Change / Approved Improvement (Do)		
Photo: Separate log books and also not reflecting actual practices <ul style="list-style-type: none"> • Cleaning roster • ATP swab records • Loose items register • 			Sketch / Photo: 		
Improvement Target:		Expected Cost:		Expected Completion Date:	
Expected Saving:					
4. Results: (Check)			5. Future Actions: (Act)		
		Actual Cost:			
		Actual Savings:			

Culture Club Improvement Plan



	TPM Improvement Sheet Action	Cost	Benefit
10	Improve communication between Maintenance and Operations- weekend Maintenance Plan	Planner report	DT-

WO							
Team Name:	Cultured Club	Location:	Cultured Foods	Initiated Date:	23/04/15		
Initiator:	Tania	Item:	Planned Maintenance Communication	Completed Date:			
Team Leader:	Tania						
1. Problem (Plan)							
After weekend maintenance work has been carried out when issues occur on Monday morning start up there is no knowledge of what work has been done on the machines, this can cause lengthy delays in rectifying the problem.							
2. Current Situation (Plan)				3. Proposed Change / Approved Improvement (Do)			
Photo: No communication to production staff on what maintenance is being carried out during the weekend				Sketch / Photo: Maintenance plan to be sent to production staff on Friday pm once the weekend maintenance schedule has been finalised			
Improvement Target:				Expected Cost:		Expected Completion Date:	
Expected Saving:							
4. Results: (Check)				5. Future Actions: (Act)			
		Actual Cost:					
		Actual Savings:					

P41620 48LZR201 FFS 2 Laser six mnth bottom filter replacement TS 10/05/2015

Culture Club Improvement Plan



	TPM Improvement Sheet Action	Cost	Benefit
11	Establish agreed centreline settings and visual controls For the case packer	Operator time	OEE+, Waste-, Quality+

Team Name:	Cultured Club	Location:	Cultured packing	Initiated Date:	22/04/15
Initiator:	Ross	Item:	Case packer	Completed Date:	
Team Leader:	Tania				

1. Problem (Plan)

2. Current Situation (Plan) 3. Proposed Change / Approved Improvement (Do)

Photo:

Case packer settings are outdated



Sketch / Photo:

Update case packer settings and tidy up sheet



Improvement Target:	Tidy up and update case packer settings sheet to improve changeovertimes	Expected Cost:		Expected Completion Date:		Expected Saving:	
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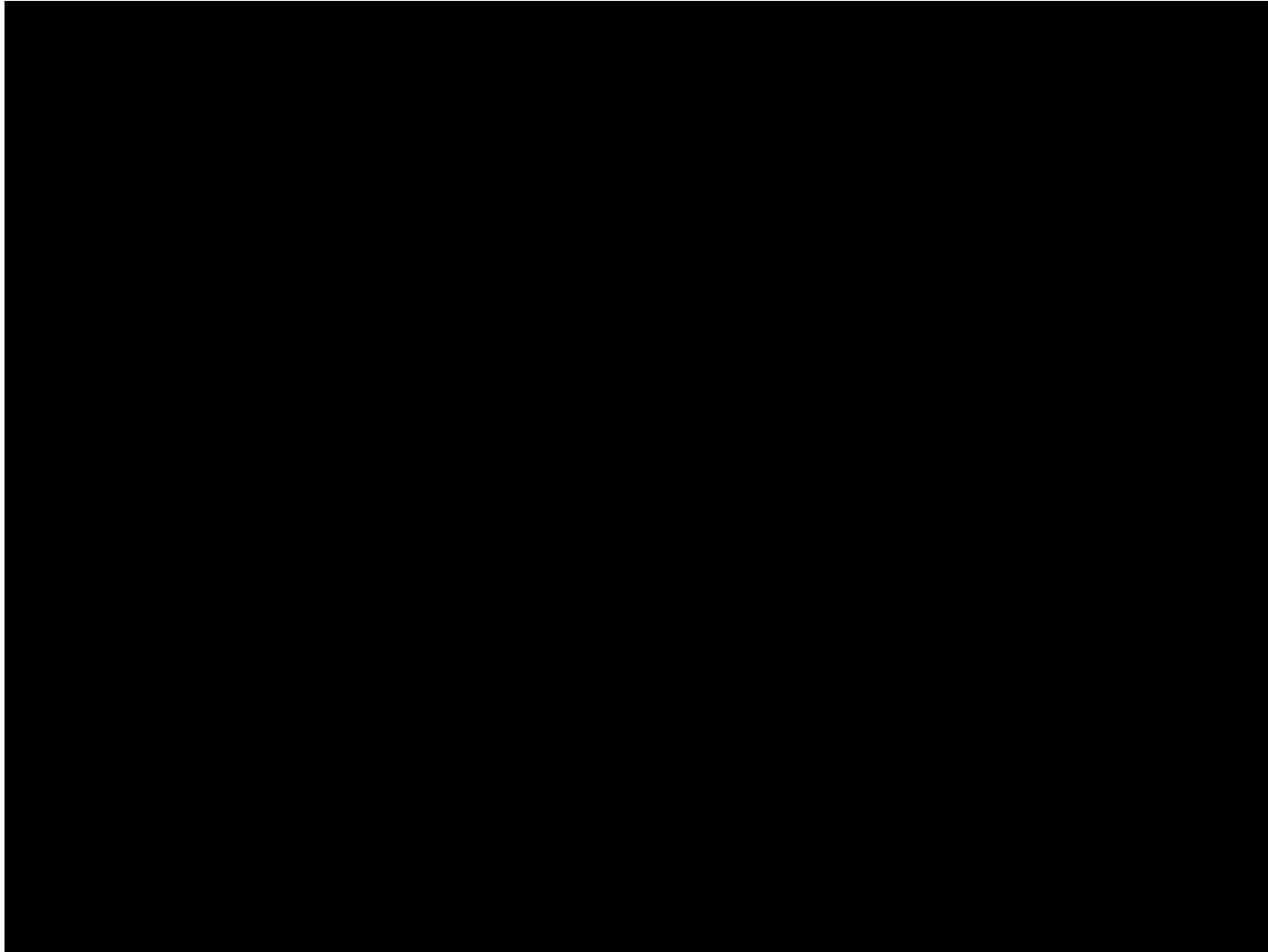
Culture Club Improvement Plan



	TPM Improvement Sheet Action	Cost	Benefit
12	Establish agreed centreline settings and visual controls For the filler	Operator time	OEE+, Waste-, Quality+



Culture Club Improvement Plan



Culture Club Improvement Plan



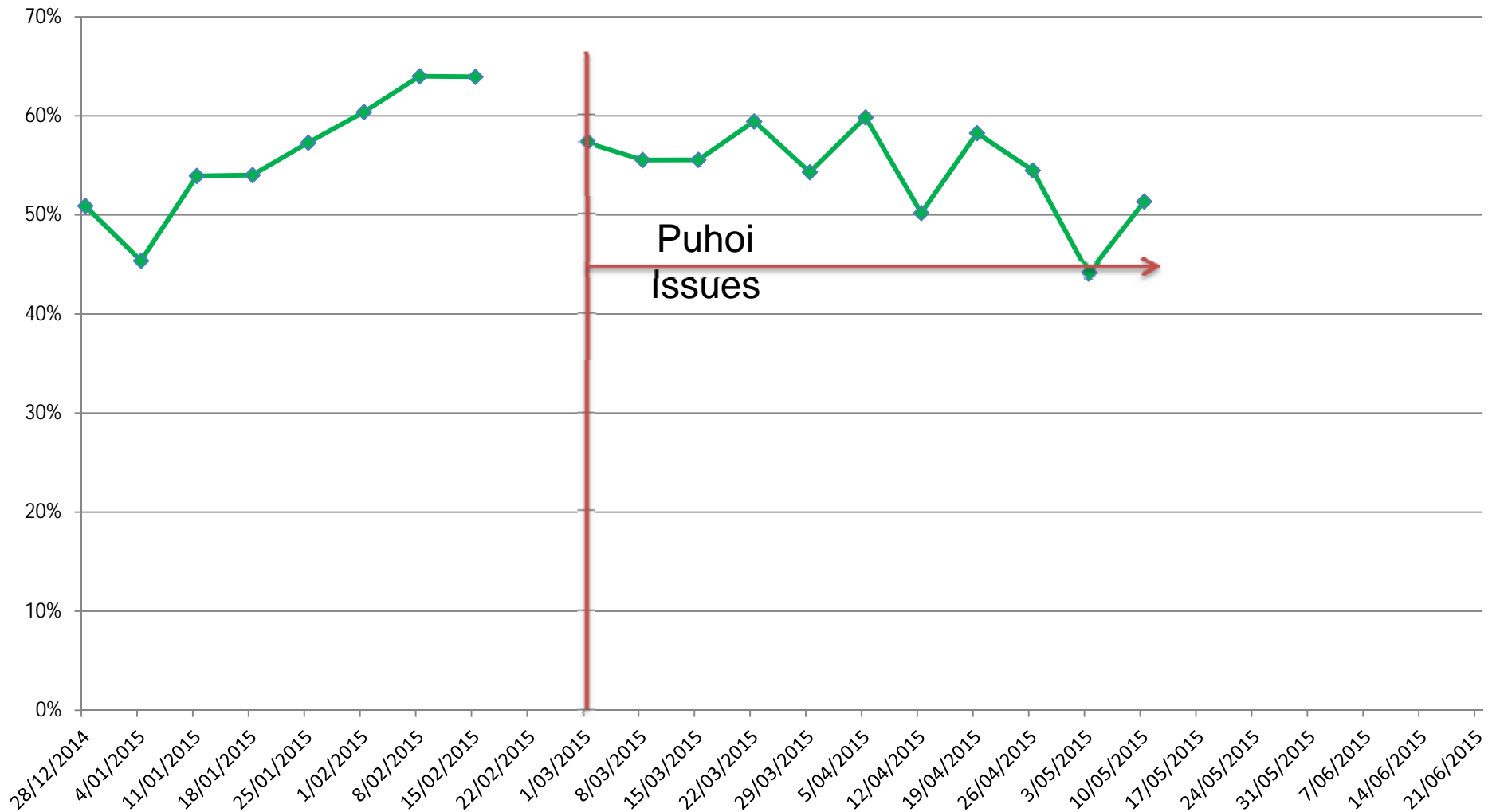
- 11 out of 12 Improvements Complete

	Improvement Sheet Action	Status
1	Case packer changeover parts guard	Complete
2	Realign CIP Pipes for easier/faster connections	Complete
3	Platform with teleplanks, improving platform stability and cleaning/servicing access	Complete
4	Jet coder mount for easier and faster changeovers.	Complete
5	Re-instate foil sensor to proper operation	Complete
6	Re-instate pot sensor to proper operation	Ongoing
7	Schedule smoko breaks to keep critical lines operating all the time	When required
8	Monty: change pots from old square tub to Monty for all grades	October 2015
9	Amalgamate existing 6 check books, update and combine into one book	Complete
10	Communication between Maintenance and Operations- weekend Maintenance Plan	Complete
11	Establish agreed centreline settings and visual controls for the case packer	Complete
12	Establish agreed centreline settings and visual controls for the filler	Complete

Results



Production OEE



OEE



- Base line 52% - Now 54%
- Puhoi issues (makes up to 50% Micro 2 production)
 - From 3rd March
 - 29 batchs made
 - 11 thin/runny/fruit sinking
 - 38%
- Greek Centers

Recommendations



- Product flush waste
 - Cycle 2, Special Micro FPI: Effluent Reduction
- Pot sensor completion
 - Weekly progress reporting to the SLT or another cycle
- Review non value added administrative tasks
 - Cycle 2, Micro FPI Planning paperwork
- Complete training requirements

Key Learnings



- Resourcing (250t 2 yrs ago vs 380t last few months)
- Working within a team with different skills, knowledge and experience
- 12 week structure
- From the team...

Thank you



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