

## Coopers Brewery – “Fast Homebrew!”



With the challenge to increase the line speed from **85 to 110 cans per minute**, it's no wonder Coopers Homebrew products are quickly approaching our households!

Now celebrating their 150<sup>th</sup> year since establishment, **Coopers Brewery** located in Regency Park SA continues to achieve great success with their TPM & Lean improvement program!

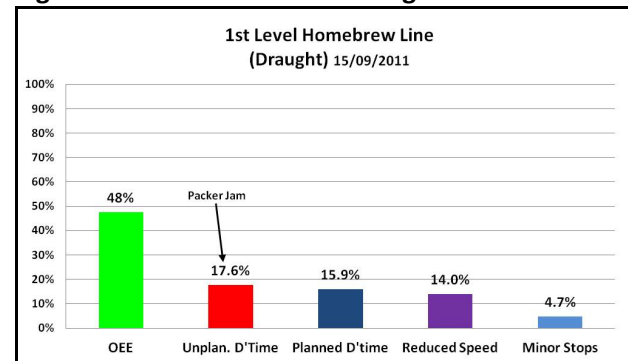


Following on from their successful installation of the De-palletiser and Packer from the Bottling Line to the Homebrew Line, a Cross-functional Improvement Team was set-up to embark on a mandate to improve **Overall Equipment Effectiveness (OEE)** from an average of 46% to 57%.

The team started off by conducting an OEE Loss Analysis which involved reviewing production downtime, waste data, as well as carrying out OEE Line Observations. Since the Homebrew Line produces a large number of products with lots of short runs, the team decided to conduct two line observations, one with multiple product short runs, and the second with a single product long run.

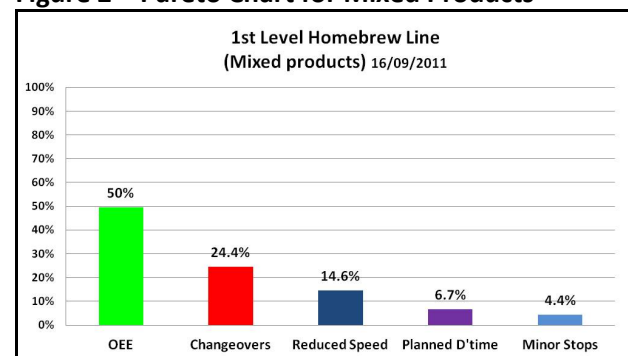
The analysis identified **reduced line speed loss of approximately 15%** for both observations as seen in Figures 1 and 2. Hence the team decided to focus on improving the line speed to achieve the team mandate.

Figure 1 – Pareto Chart for Draught



Amid the OEE Loss Analysis results, the team now faced the monumental task of increasing the line speed from 85 to 110 cans per minute (cpm); hence the team name “State Limit 110”.

Figure 2 – Pareto Chart for Mixed Products



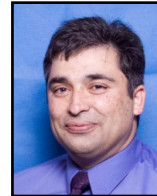
By conducting line speed trials, gathering line observation data and using operator observations / experiences, the following minor stoppages and problems were investigated and resolved to improve the Line speed:

- Fallen cans between De-palletiser and Filler;
- Can jamming in singuliser;
- De-palletiser faults;
- Product line Pressure Transmitter replaced;

- PT Parameter – Large Flow Angle changed from 3.1 to 3.5;
- All Filling Valves overhauled;
- Pump timing between Pack R & Coopers Mono pumps;
- All Scales Checked for correct readings (done on a Weekly PM);
- Can Presentation on Scale foot Improved; and
- Hop oil dosing.

These improvements and more have allowed the operators to run most products at 110cpm and improve the **average OEE to 55%** as seen from the results in Figure 3 below. On behalf of CTPM we congratulate the team on their effort and impressive results.

For further information please contact:



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**Figure 3 – Homebrew Line OEE Results**

