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How we Engaged our Operators through Equipment Care Activities







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What worked – Get Involved!!







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What worked – Get Involved!!



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What worked – Recognition



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What worked – Recognition



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What worked – Recognition



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What worked – Recognition



26/07/2006

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What worked – Don't Worry About Changeovers

Four(4)

and

Three(3)

in

Five(5)

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How we Engaged our Operators through Equipment Care Activities



By Carmine Caruccio

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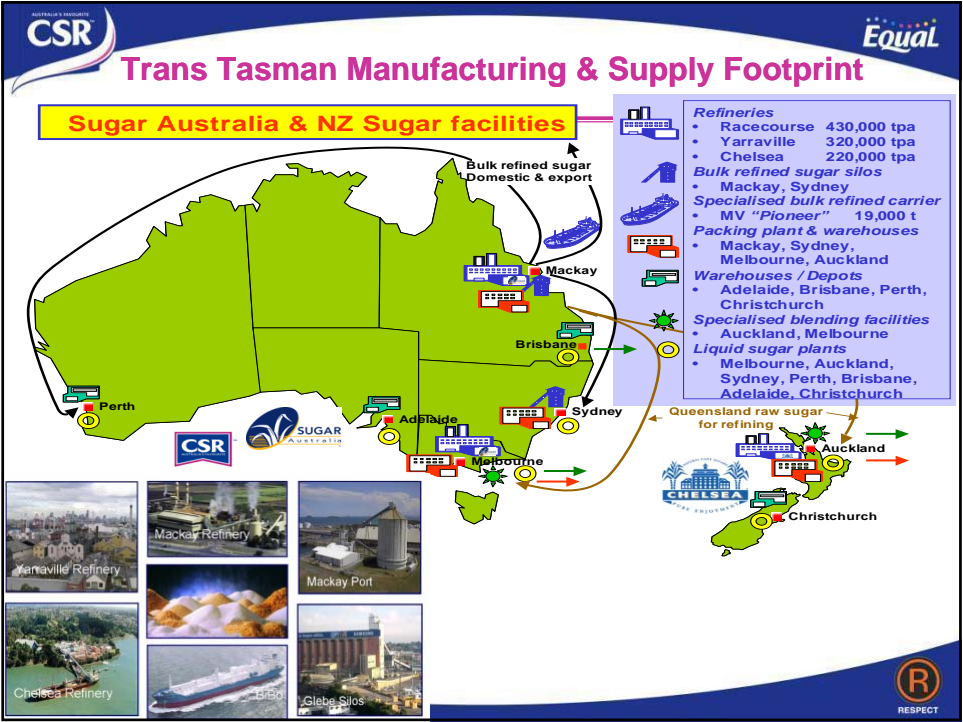
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Site Information

- Glebe consists of 14 bulk storage silos (2,000t each), a bulk distribution facility for white sugar & liquid sugar. Also 2 packaging lines - Retail (1,2 & 3kg) and Industrial (15 to 1250kg)
- Contract carriers transport all bulk and packed goods direct to customers and into a Warehouse at our Prestons site.
- Facility is operated by 24 persons on a 24 x 6.5 day continuous shift roster.
- We have operated for over 8 years without an LTI.
- DIFOTIS YTD is 99.4%.
- ISO 9001:2008, HACCP certified and BRC accredited.

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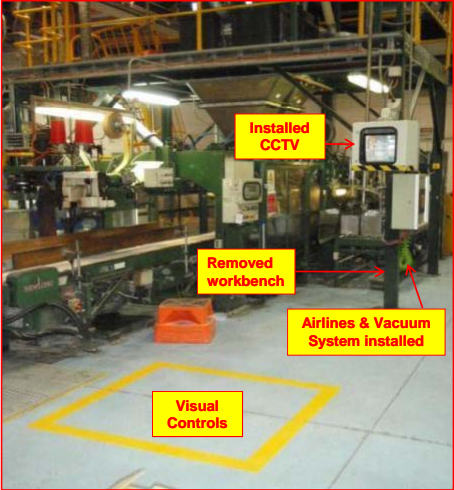
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Industrial Line




Taken in 2006



Installed CCTV
Removed workbench
Airlines & Vacuum System installed
Visual Controls
Taken in 2010






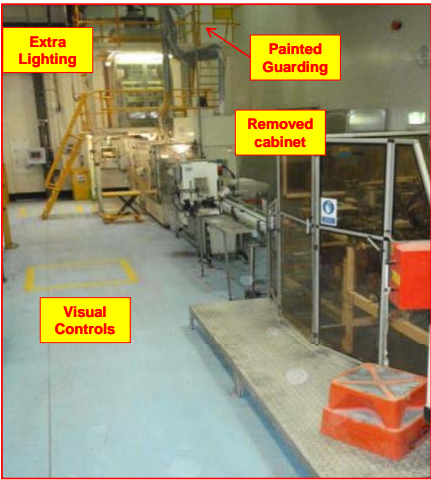
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Retail Line




Taken in 2006



Extra Lighting
Painted Guarding
Removed cabinet
Visual Controls
Taken in 2010






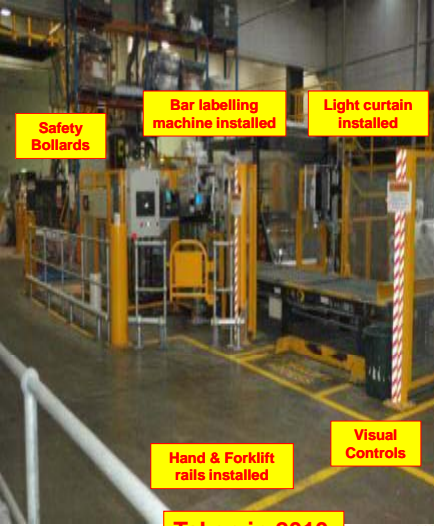
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Palletiser



Taken in 2006



Taken in 2010


Safety Bollards


Bar labelling machine installed

Light curtain installed

Hand & Forklift rails installed

Visual Controls





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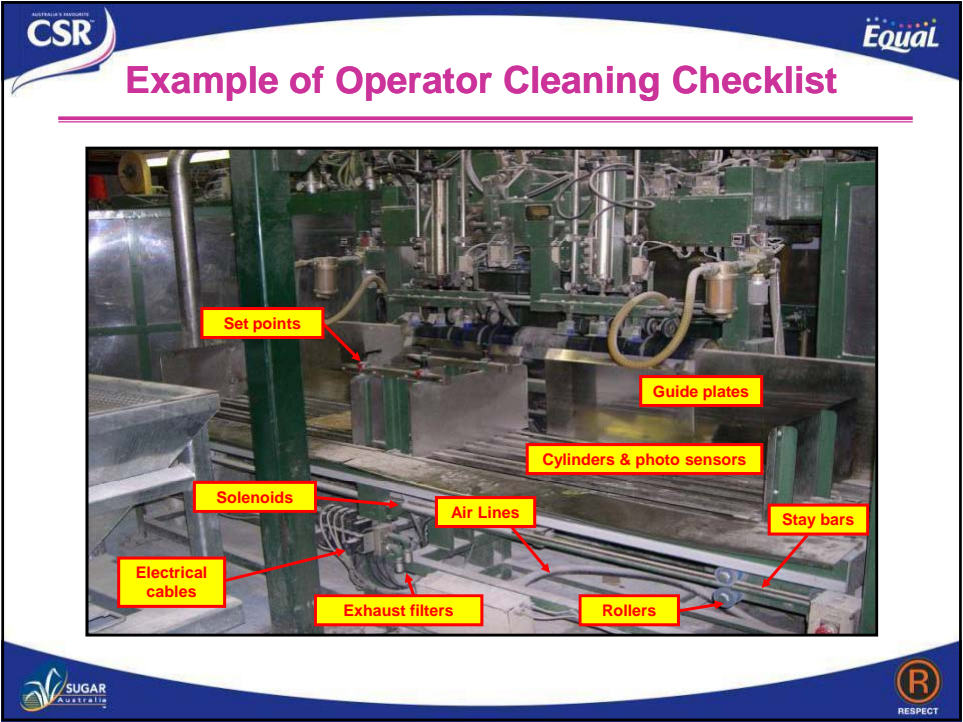
Communication the Key



- Our 30 metre Visual noticeboard highlighting site performance.
- Teams began to communicate & challenge themselves in a positive manner, striving to achieve higher performance measures.
- Relationships between Operators & Maintenance the key to success assisting with defects & improvements.
- Results achieved through the TPM³ process boost team morale, create a safer work environment & operator ownership of the packing lines.
- TPM³ encourages the operators to continually improve the quality & safety standards throughout the site.







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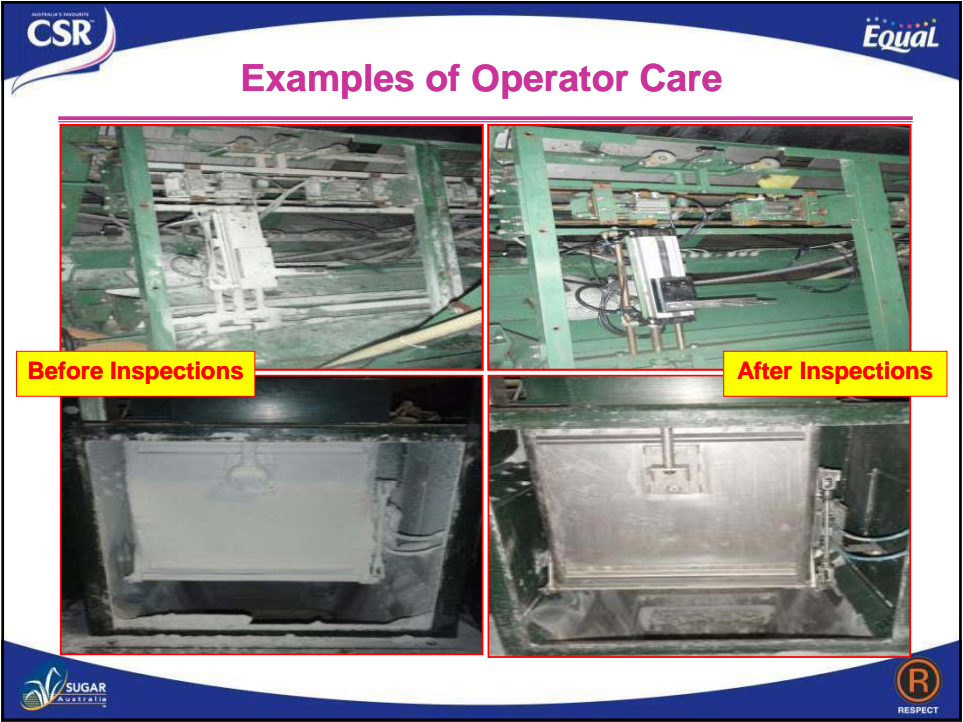
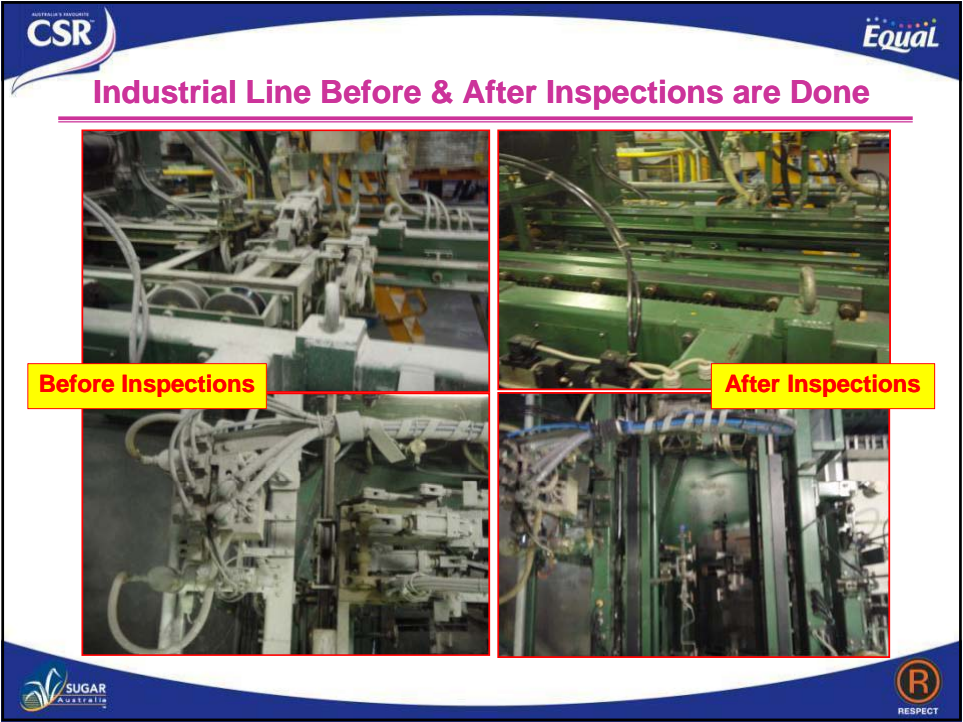
Checklist Used for Weekly Inspections

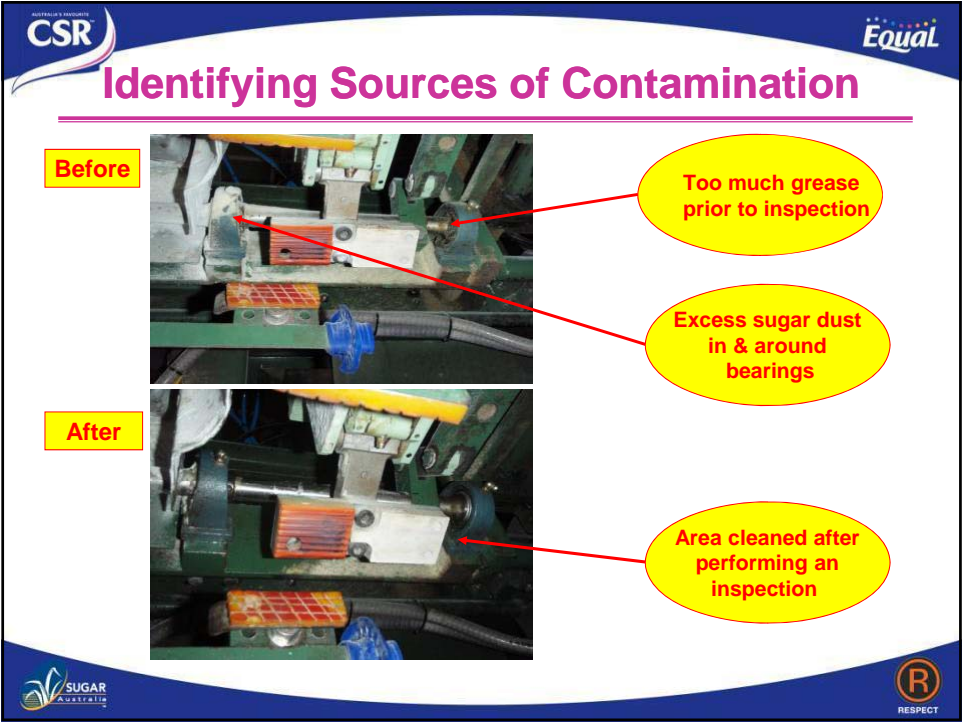
Visual	<div>Correct isolating procedures must be followed</div> <div><div>Date of clean:Operators:</div><div><div>Item: Newlong Bag Magazine Date Developed:17/10/2007 Developed by: Carmine Caruccio Date Reviewed: Reviewed By: Signed Off: Pages: 2 of 3</div></div></div>
Remove	
Listen	
Clean	
Adjust	

Item	Standard	Target Time	Method	Action	Completed	
1.Clean & check the stay bars	Clean, No cracks visible	2 mins			Yes	No
2. Check & clean photo sensors	Clean, No damage to sensors	2 mins			Yes	No
3. Inspect all cylinders	Clean, no air leaks , nuts & bolts all tightened	2 mins			Yes	No
4. Check & clean air lines, inspect for air leaks	Clean, No air leaks in hoses	2 mins			Yes	No
5. Check & clean rollers	Clean, operates freely	2 mins			Yes	No
6. Check all electrical cables & wipe down	Clean no Frade or loose wiring	5 mins			Yes	No
7. Clean & check support frame for cracks broken welds	Clean, No cracks visible,nuts & bolts all tightened	5 mins			Yes	No

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Visual Controls Set for Easy Location

A photograph of industrial machinery, likely a sugar mill, showing two yellow visual markers on green metal components. Red lines point from a yellow box labeled 'Visual Marking' to these markers. The machinery includes various pipes, valves, and a label that partially reads 'V...UM ONE'.

Visual Marking

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Training for Operators



- EP2 for Non-food grade
- Rocol for food grade
- Inox for Chain drives
- Training provided on how to load Grease cartridges

- Storage cabinet made for easy access of lubrication equipment.
- For visual controls, all staff agreed to have Yellow colour for all non food grade grease points and White colour for all food grade grease points.





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Old Workshop











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Cleaning stations set up on all levels



Before WAM



After WAM



PLEASE DO NOT REMOVE ANY OF THESE
ITEMS FROM THIS AREA



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TPM³ at Glebe

- **Started October '05**
- **12 Cycles completed**
- **Gains in addition to OEE**
 - 250 SOP's written
 - 95 One point lessons written
 - Over 500 Defects identified & rectified
 - Retail & Industrial changeover manuals produced
 - Clean to Inspect programs developed for all items of equipment
 - Problem Solving skills
 - 100% of Glebe staff involved in TPM³
 - Achieved Level 2 of the 5 Level Milestone TPM³ Excellence Awards





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Procedures Incorporating Safety



AUSAR

Issue Date: 16th February 2010

Written By: Carmine Caruccio

Authorised By: _____ Page 1 of 1

Isolation of Fire Fly

Subject: Isolation of the Fire Fly system

Safety: Use PPE at all times, follow correct procedures

What is it: Fire Fly sensors detect any hot bodies passing within the area

Purpose: To eliminate any false activation & to isolate

Location: Elevator 1 & 2 has six sensors on each elevator, BCO2/03 transfer house has two sensors

Isolation Location: Level 9 Electrical room

When do I isolate: When we wash BCO2/3 Transfer house



Fire Fly cabinet Level 9



Fire Fly Sensors

1. Turn key on cabinet
2. Open cabinet door
3. The state on the touch screen will read "Running"
4. To isolate, press the E button on the touch screen to menu
5. Press the B button which is to next step x 2
6. Change system state will be illuminated
7. Press E button to enter x1
8. Press the B button which is to next step x 1
9. No Rel / Out will be illuminated
10. Press the E button to enter
11. This will revert back to the menu screen
12. LED's on the left side will flash
13. Fire Fly is now isolated, State will read No Rel / Out
14. Close cabinet door
15. Lock with Key



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GMP Calendar

JUNE 2010 CLEANING CHECKLIST CALENDAR

MON

TUE

WED

THU

FRI

SAT

SUN

	1	2	3	4	5	6
7	8	9	10	11	12	13
14	15	16	17	18	19	20
21	22	23	24	25	26	27
28	29	30				

Sunday cleaning requirements

Brown liquid pallean dispatching

Boiler and liquid tanks

Liquid pallean filling

Stretch wrapper

Under the silos

Dry bulk weighbridge

IBC filling station checklist

Top sheeter cleaning checklist

Warehouse

Car park and loading dock

Liquid bulk weighbridge

Packing area

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GMP Checksheets

GMP Brown Liquid Pallean Dispatching Cleaning Checklist

Issue date: 2nd December, 2009

N-SHE-F-031-A

Written by: Carmine Caruccio

Authorised by:

Page 1 of 1


GMP Brown Liquid Pallean Dispatching

Safety : Ensure we use PPE at all times

Location: Opposite the maintenance workshop


Purpose: To Maintain a clean & safe environment continuously

Frequency: Monthly

Date:	Yes	No	Comments	Frequency
1. Empty Drip tray that sits on the bottom of the bulk box if full of water				Monthly
2. Wash around scale platform				
3. Remove any loose items on the floor & on top of cabinets				
4. Wipe clean hand rails on mezzanine floor				
5. Empty rubbish bin				
6. Wipe fire extinguishers				
7. Wipe clean all signs within the area				
8. Floor scrub around working area				

Check completed by: _____

Checked & approved by: _____

Date:	Yes	No	Comments	Frequency
1. Empty Drip tray that sits on the bottom of the bulk box if full of water				Monthly
2. Wash around scale platform				
3. Remove any loose items on the floor & on top of cabinets				
4. Wipe clean hand rails on mezzanine floor				
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Check completed by: _____

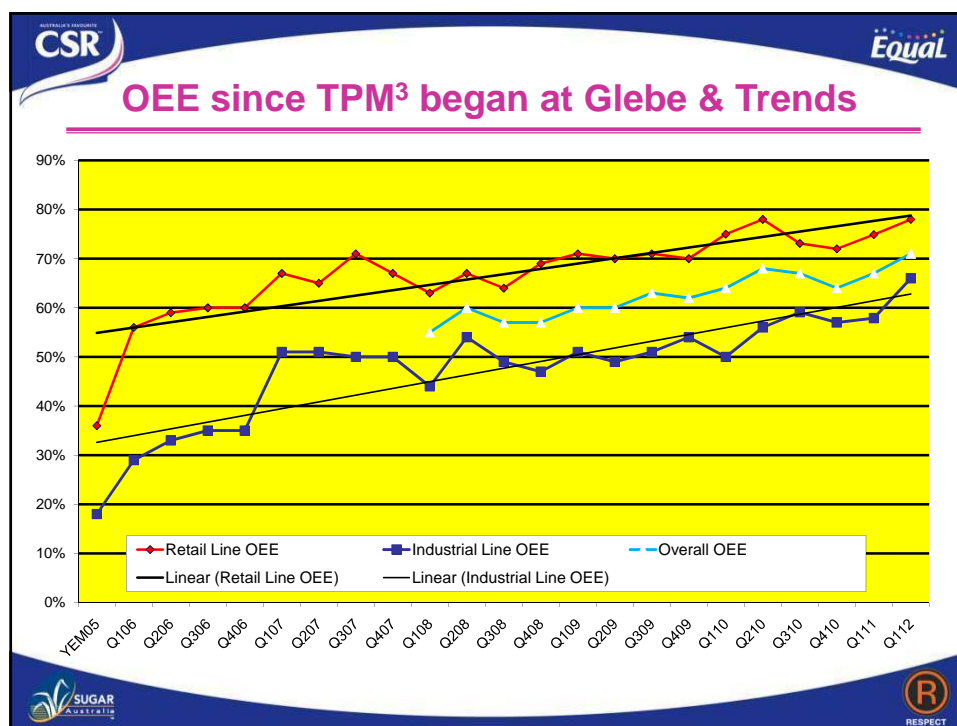
Checked & approved by: _____

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So How Did We Succeed?

- The right tools were supplied to perform tasks
- Equipment defects rectified
- PM system in place
- Operators committed to the journey
- Operators given the time to locate defects & carry out improvements
- Operators saw the benefits from the program as machine performance improves
- All staff are focused on effective communication

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What's In It For Me?

- Operator satisfaction
- Major improvement boost in OEE
- Safety to the site a priority
- Easy to follow Standard Operating Procedures / OPL's
- Increased Communication
- Customer relationships built from site tours

Video

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Questions



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