

PrintCo Delta Team

I.D.	Improvement Barrier List Barrier Description		Impact				Wks	Relative Merit
			Prod	Wast	Qual	OTD		
1	Lack of previous job sample with docket	Dirk/WAQC	9	7	8	7	1	38.00
2	Lack of combination orders	Ken/CFT	9	7	1	7	1	31.00
3	Error Policy	Doug/David	8	8	8	8	2	20.00
4	Operator fatigue (12 hour shifts)	Bud/Khris	9	6	9	8	2	19.00
5	Split Shifts (12 hour vs. 8 hour)	Bud/Khris	10	10	10	8	3	16.00
6	Handling equipment damage to stock	Carl	6	6	4	6	2	14.00
7	Paper availability	Dee/Jeff	9	9	6	9	3	14.00
8	Runability of slit paper (equip./training)	Dee	9	8	6	8	3	13.00
9	Uneven sheet quantities to collator	Khris/Jeff	5	6	2	5	2	12.00
10	Maint. coverage for night-shift/ wknds	Ray	9	5	5	8	3	10.67
11	Lack of production notes on docket	Kevin/CSC	8	4	7	7	3	10.00
12	Production notes process failures	Kevin	6	6	8	4	3	10.00
13	Lack of operator Maintenance	Ron/Ray	8	8	8	7	4	9.75
14	Plant vs. Department Seniority	Doug	8	4	4	9	3	9.67
15	Not using Atlas Perf plates	Terry/Dean	8	9	5	7	4	9.50
16	Not following Quality Procedures	Carl/Jeff	8	7	9	6	4	9.25
17	Lack of Static M/R	Mike/Dean	9	9	3	7	4	9.25
18	Overtime inequality (Distribution)	Bud	8	7	7	5	4	8.50
19	Attitudes of operators	Mike	9	10	9	8	6	7.67
20	Weekend coverage at CSC	Dirk/CSC	8	6	2	7	4	7.25
21	Incomplete specs. (usage) on orders	Ken/Dirk	6	6	2	7	4	6.75
22	Lack of supervision on floor	Jeff/Doug	9	8	9	9	7	6.14
23	Prelim. machines--repair or upgrade	Carl	9	3	4	8	8	3.38
24	Photopolymer plates arriving late	JoAnn	8	4	4	8	14	2.00
25	Manufacturing system response time	Kevin	7	7	7	7	30	1.17
26	Order sequencing improvement	Kevin	8	8	4	6	50	0.68
27	Dedicated roll enhancer operators	Backlog	9	3	7	9	3	10.33
28	Communication among departments	Backlog	4	6	7	8	3	10.33
29	Shift change - Hand-off	Backlog	8	7	8	6	5	7.20
30	Run to Quality too long	Backlog	8	9	3	6	6	5.83
31	Excess Slitting (combine with mat avail)	Backlog	2	8	4	2	5	4.80
32	Communication on waste importance	Backlog	1	5	2	1	3	4.67
33	Press Run Speeds not optimized	Backlog	9	2	3	9	6	4.17
34	Incorrect negatives to MC from CSC	Backlog	6	7	4	7	8	3.88
35	Raw Material Storage not organized	Backlog	5	1	1	4	4	3.00
36	Training of operators	Backlog	7	9	7	7	13	3.00
37	Lack of helpers	Backlog	8	2	5	8	13	1.92
38	Short run capability for P-seal	Backlog	8	10	5	9	26	1.62
39	Test Tech. for Pressure Seal	Backlog	5	8	10	2	26	1.27
40	Mftg. system down time - (maint.)	Backlog	7	7	7	7	30	1.17
41	Insufficient test equipment	Backlog	2	8	10	2	26	1.15
42	Lack of qual. support during MR/run	Backlog	9	3	5	9	30	0.97
43	Individual machine incentives	Backlog	9	9	9	9	50	0.90
44	Pay for skills	Backlog	9	7	7	8	50	0.76
45	Equipment Maintenance PM, ERP	Backlog	8	8	9	4	50	0.74
46	Plant layout	Backlog	7	3	3	3	26	0.73
47	Marginal words not in billing set info.	Backlog	6	3	7	3	50	0.44
48	Overall housekeeping	Backlog	8	6	9	3	78	0.41
49	Break-ins to existing schedule	Backlog	7	7	8	7	102	0.35
50	Butt Rolls (too large)(too small)?	Backlog	4	6	2	4	102	0.22

$$[(\text{Prod}) + (2 * \text{Waste}) + (\text{Qual}) + (\text{OTD})] / \text{Wks} = \text{Relative Merit}$$