

PrintCo Delta Team



I.D.	Improvement Barrier List Barrier Description	Leader/Backup	Impact (Score)				Impact (% of Goal-Start)				Measurement Impact (Units)			
			P	W	Q	D	Prod	Waste	Quality	OTD	Prod	Waste	Quality	OTD
1	Lack of previous job sample with docket	Dirk/WAQC	9	7	8	7	2.5%	2.2%	2.7%	2.2%	0.12	0.2%	4.23	0.3%
2	Lack of combination orders	Ken/CFT	9	7	1	7	2.5%	2.2%	0.3%	2.2%	0.12	0.2%	0.53	0.3%
3	Error Policy	Doug/David	8	8	8	8	2.2%	2.5%	2.7%	2.5%	0.11	0.2%	4.23	0.3%
4	Operator fatigue (12 hour shifts)	Bud/Khris	9	6	9	8	2.5%	1.9%	3.1%	2.5%	0.12	0.2%	4.76	0.3%
5	Split Shifts (12 hour vs. 8 hour)	Bud/Khris	10	10	10	8	2.7%	3.1%	3.4%	2.5%	0.14	0.3%	5.29	0.3%
6	Handling equipment damage to stock	Carl	6	6	4	6	1.6%	1.9%	1.4%	1.9%	0.08	0.2%	2.12	0.2%
7	Paper availability	Dee/Jeff	9	9	6	9	2.5%	2.8%	2.0%	2.8%	0.12	0.2%	3.17	0.4%
8	Runability of slit paper (equip./training)	Dee	9	8	6	8	2.5%	2.5%	2.0%	2.5%	0.12	0.2%	3.17	0.3%
9	Uneven sheet quantities to collator	Khris/Jeff	5	6	2	5	1.4%	1.9%	0.7%	1.5%	0.07	0.2%	1.06	0.2%
10	Maint. coverage for night-shift/ wknds	Ray	9	5	5	8	2.5%	1.6%	1.7%	2.5%	0.12	0.1%	2.65	0.3%
11	Lack of production notes on docket	Kevin/CSC	8	4	7	7	2.2%	1.2%	2.4%	2.2%	0.11	0.1%	3.70	0.3%
12	Production notes process failures	Kevin	6	6	8	4	1.6%	1.9%	2.7%	1.2%	0.08	0.2%	4.23	0.2%
13	Lack of operator Maintenance	Ron/Ray	8	8	8	7	2.2%	2.5%	2.7%	2.2%	0.11	0.2%	4.23	0.3%
14	Plant vs. Department Seniority	Doug	8	4	4	9	2.2%	1.2%	1.4%	2.8%	0.11	0.1%	2.12	0.4%
15	Not using Atlas Perf plates	Terry/Dean	8	9	5	7	2.2%	2.8%	1.7%	2.2%	0.11	0.2%	2.65	0.3%
16	Not following Quality Procedures	Carl/Jeff	8	7	9	6	2.2%	2.2%	3.1%	1.9%	0.11	0.2%	4.76	0.2%
17	Lack of Static M/R	Mike/Dean	9	9	3	7	2.5%	2.8%	1.0%	2.2%	0.12	0.2%	1.59	0.3%
18	Overtime inequality (Distribution)	Bud	8	7	7	5	2.2%	2.2%	2.4%	1.5%	0.11	0.2%	3.70	0.2%
19	Attitudes of operators	Mike	9	10	9	8	2.5%	3.1%	3.1%	2.5%	0.12	0.3%	4.76	0.3%
20	Weekend coverage at CSC	Dirk/CSC	8	6	2	7	2.2%	1.9%	0.7%	2.2%	0.11	0.2%	1.06	0.3%
21	Incomplete specs. (usage) on orders	Ken/Dirk	6	6	2	7	1.6%	1.9%	0.7%	2.2%	0.08	0.2%	1.06	0.3%
22	Lack of supervision on floor	Jeff/Doug	9	8	9	9	2.5%	2.5%	3.1%	2.8%	0.12	0.2%	4.76	0.4%
23	Prelim. machines--repair or upgrade	Carl	9	3	4	8	2.5%	0.9%	1.4%	2.5%	0.12	0.1%	2.12	0.3%
24	Photopolymer plates arriving late	JoAnn	8	4	4	8	2.2%	1.2%	1.4%	2.5%	0.11	0.1%	2.12	0.3%
25	Manufacturing system response time	Kevin	7	7	7	7	1.9%	2.2%	2.4%	2.2%	0.10	0.2%	3.70	0.3%
26	Order sequencing improvement	Kevin	8	8	4	6	2.2%	2.5%	1.4%	1.9%	0.11	0.2%	2.12	0.2%
27	Dedicated roll enhancer operators	Backlog	9	3	7	9	2.5%	0.9%	2.4%	2.8%	0.12	0.1%	3.70	0.4%
28	Communication among departments	Backlog	4	6	7	8	1.1%	1.9%	2.4%	2.5%	0.05	0.2%	3.70	0.3%
29	Shift change - Hand-off	Backlog	8	7	8	6	2.2%	2.2%	2.7%	1.9%	0.11	0.2%	4.23	0.2%
30	Run to Quality too long	Backlog	8	9	3	6	2.2%	2.8%	1.0%	1.9%	0.11	0.2%	1.59	0.2%
31	Excess Slitting (combine with mat avail)	Backlog	2	8	4	2	0.5%	2.5%	1.4%	0.6%	0.03	0.2%	2.12	0.1%
32	Communication on waste importance	Backlog	1	5	2	1	0.3%	1.6%	0.7%	0.3%	0.01	0.1%	1.06	0.0%
33	Press Run Speeds not optimized	Backlog	9	2	3	9	2.5%	0.6%	1.0%	2.8%	0.12	0.1%	1.59	0.4%
34	Incorrect negatives to MC from CSC	Backlog	6	7	4	7	1.6%	2.2%	1.4%	2.2%	0.08	0.2%	2.12	0.3%
35	Raw Material Storage not organized	Backlog	5	1	1	4	1.4%	0.3%	0.3%	1.2%	0.07	0.0%	0.53	0.2%
36	Training of operators	Backlog	7	9	7	7	1.9%	2.8%	2.4%	2.2%	0.10	0.2%	3.70	0.3%
37	Lack of helpers	Backlog	8	2	5	8	2.2%	0.6%	1.7%	2.5%	0.11	0.1%	2.65	0.3%
38	Short run capability for P-seal	Backlog	8	10	5	9	2.2%	3.1%	1.7%	2.8%	0.11	0.3%	2.65	0.4%
39	Test Tech. for Pressure Seal	Backlog	5	8	10	2	1.4%	2.5%	3.4%	0.6%	0.07	0.2%	5.29	0.1%
40	Mftg. system down time - (maint.)	Backlog	7	7	7	7	1.9%	2.2%	2.4%	2.2%	0.10	0.2%	3.70	0.3%
41	Insufficient test equipment	Backlog	2	8	10	2	0.5%	2.5%	3.4%	0.6%	0.03	0.2%	5.29	0.1%
42	Lack of qual. support during MR/run	Backlog	9	3	5	9	2.5%	0.9%	1.7%	2.8%	0.12	0.1%	2.65	0.4%
43	Individual machine incentives	Backlog	9	9	9	9	2.5%	2.8%	3.1%	2.8%	0.12	0.2%	4.76	0.4%
44	Pay for skills	Backlog	9	7	7	8	2.5%	2.2%	2.4%	2.5%	0.12	0.2%	3.70	0.3%
45	Equipment Maintenance PM, ERP	Backlog	8	8	9	4	2.2%	2.5%	3.1%	1.2%	0.11	0.2%	4.76	0.2%
46	Plant layout	Backlog	7	3	3	3	1.9%	0.9%	1.0%	0.9%	0.10	0.1%	1.59	0.1%
47	Marginal words not in billing set info.	Backlog	6	3	7	3	1.6%	0.9%	2.4%	0.9%	0.08	0.1%	3.70	0.1%
48	Overall housekeeping	Backlog	8	6	9	3	2.2%	1.9%	3.1%	0.9%	0.11	0.2%	4.76	0.1%
49	Break-ins to existing schedule	Backlog	7	7	8	7	1.9%	2.2%	2.7%	2.2%	0.10	0.2%	4.23	0.3%
50	Butt Rolls (too large)(too small)?	Backlog	4	6	2	4	1.1%	1.9%	0.7%	1.2%	0.05	0.2%	1.06	0.2%

Totals: 366 322 293 323

Delta: 5.00 8.7% 155.0 13.0%

Goal:	12	17.3%	230	95%
Start:	7	8.6%	75	82%
Delta:	5	8.7%	155	13%

