



Case Study 2

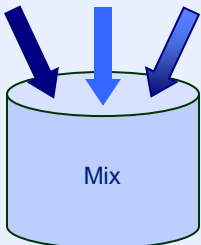
Processing Plant with Quality Control Problems

Result
Trained, empowered employees.
Net saving to client of £200,000 pa
Establish a clear operating process

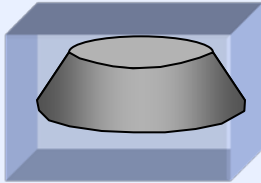
Previous Condition

Sand Core Machine

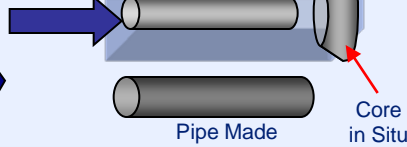
Resin Sand Catalyst



No SPC



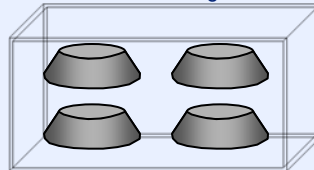
Casting Machine



Core Store Area

No FIFO order

Cores in Stilage



Scrap Graph



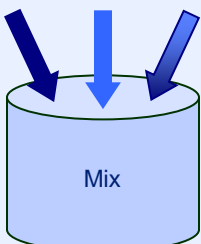
Summary

10% Scrap per shift
No scrap pattern
High re-melt rate
Old mix equipment
No FIFO in core store

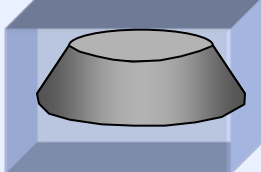
Current Condition

Sand Core Machine

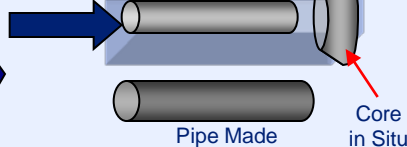
Resin Sand Catalyst



Introduced SPC



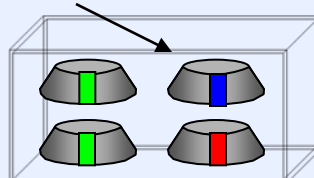
Casting Machine



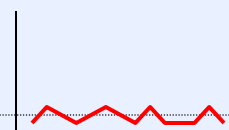
Core Store Area

FIFO order for use

Cores in Stilage with Visual Control.



Scrap Graph



Summary

<1.5% Scrap per shift
FIFO in place
Clear shift marked cores
Accurate mix equipment

Tools Used

Problem Solving, Quality Tools, 5S
Standard Work, Visual Control and
Lean Internal Logistics

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