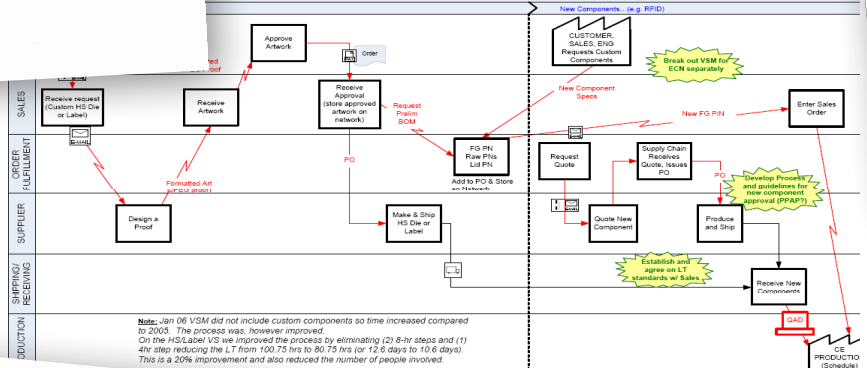
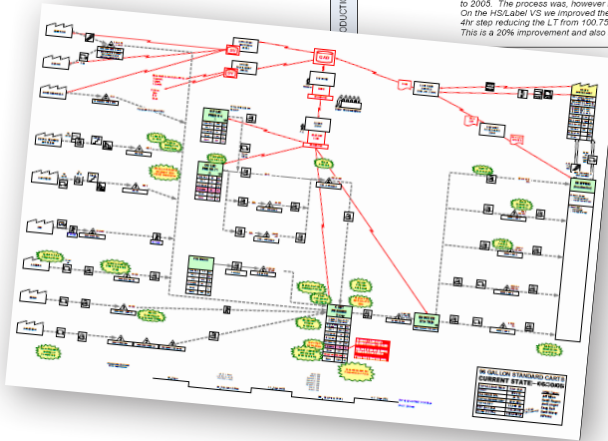


Order Process (Includes new component sourcing)



Note: Jan 06 VSM did not include custom components so time increased compared to 2005. The process was, however improved. On the HCL label VSM we improved the process by eliminating (2) 8-hr steps and (1) 4hr step reducing the LT from 100.75 hrs to 90.75 hrs (or 12.6 days to 10.6 days). This is a 20% improvement and also reduced the number of people involved.



CURRENT STATE - June 2006

Demands = 22, new part numbers per year (210 parts, 100 lbs)
 TT = 6.2 hours (based on a 5 day 40-hr week)
 FPCT = 142.25 hrs
 LT = 27.25 Days

Performance Dashboard for Lean Value Stream Management Projects
 5/24/05 Report Out

PRODUCTION VALUE STREAMS

Value Stream Project Name	Key Issue(s)	Required Action(s)	Status	Key Accomplishments	Plan 45 Day	Actual 45 Day	Financial Savings YTD	YTD %
146-407	Scheduling with discussions Not separating & labeling parts Manual handling single parts	Schedule ppt team to conduct on event to see what opportunities by mid June Schedule follow by separating into 10 to different location on spot More machine July evaluation Schedule all event to conduct on event to see what opportunities	Green	to create chronology improved 3 cases events consultation on roll take by stock lot prices laborage study completed Studying china color change	20.3%	0	149.2k	
319-446-168	Change over time & leading productivity goals Many flow lines used Scheduling issues Days on hand new material 4.65	Reduce changeover time Reformat material correspondence Review by end of July Schedule system for scheduling Schedule material on hand from 540,000 to 180,000	Green	Delays no change over Have observation for material complete Manage for print handling completed Reduced material on hand to 180,000 from 540,000	27.7%	29.7%	29.7%	
440-190	Many flow lines used New process about information Scheduling issues	Eliminate material conversation line area for end of July Complete by mid October Schedule system for scheduling	Green	New roll development in progress Cushion 400 roll color completed	13.9%			
162-A-145	Flow and stock changing based on what you talk with, causing production issues Scheduling issues	Complete future state VSM to get everyone on the same page Schedule system for scheduling	Red	Customer state completed Future state in process Reformat china wash projects	10%			

Note date: 5/20/05
 Revised date: 5/23/05

Note: For project results see the following link: \\WorkArea\Corporate\Learn\ValueStreamManagement\Projects

Value Stream Project Name	Key Issue(s)	Required Action(s)	Status	Key Accomplishments	Plan 45 Day	Actual 45 Day	Financial Savings YTD	YTD %
146-407	Material handling, too much conversation SOT floor commitment	Review contract with SCUs Material handling, too much conversation SOT floor commitment	Yellow	Reduced CT from 10k to 8k secs Material one side Elimination of the flaring Achieved cycle time of 45 sec	5.3%	33.3%	12.8k	
All Induction	Lead modifications don't meet criteria full 200 weight savings Long term testing of legend displayed due to customer request for testing & future availability	Work on reducing size of the tool and head Purchasing additional testing fixture	Green	Other Reduced expense Temp fixture continues to hard down Machine uptime continues to improve	381.8%	381.8%	381.8%	
Sales	New Current state/ future state map not done	Identify members and build for next state event	Yellow	Supplier location change Call center 100% to 47% Future Cost savings on material 100% (176.4k)	27.8%	10.3%	10.3%	
Tool	Using obsolete CT issue No conveyor signs Space constrained packaging	Get packaging approved Complete coat work order Deliver new event date	Green	Removed one separator Conveyor and Robot added	200%	283%	283%	

TOTAL PERFORMANCE FOR PRODUCTION VALUE STREAMS:

1,023.1% 776.4k 2,471.1k 238.1k

Note date: 5/20/05
 Revised date: 5/23/05

Note: For project results see the following link: \\WorkArea\Corporate\Learn\ValueStreamManagement\Projects

Value Stream Project Name	Key Issue(s)	Required Action(s)	Status	Key Accomplishments	Plan 45 Day	Actual 45 Day	Financial Savings YTD	YTD %
Acquity	Scope of work exceeded the ability to get responsibility in a short time frame Pkg. & inventory taking Inventory not tracked	Re-organize project plan with needed dates Establish inventory processes to track and create checklist Continue to work with all 4 teams to open "reading" area	Yellow	Partial order flow thru 250-325 Completed Roll of new hardware from which fourth was left on hand Established Business Operating System Method	1.6%	30%	0	
Plygem Disc Car	Interface issue between program controller and ACE causing "reading" of documents to be	Scheduled weekly project meetings to stay focused	Green	47% reduction in "right" to get to a Reconnect 46.5% reduction of disc - 3200 (34.4k)	46.5%	93%	0	
Cushion OM 4 Scheduling	Time of delivery a long causing project management team a challenge	Schedule weekly project meetings to stay focused	Green	46.5% reduction of disc - 3200 (34.4k) 5 roll-reduce were completed Waste on floor were identified and one being worked on Business Operating System affinity being implemented	61.4%	20%	0	

Value Stream Management

Launched a lean manufacturing technique used to analyze and design information, product and people flows necessary to deliver a product or service.