

## Coopers “Dirty Dozen-1” Team hit the OEE target!

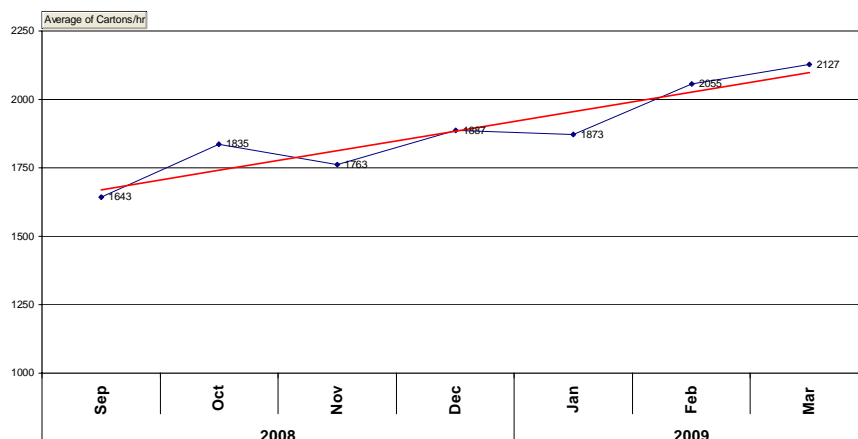


The end of March 2009 saw Coopers Brewery complete its seventeenth cycle of its Lean & TPM (TPM<sup>3</sup>) Journey with great success.

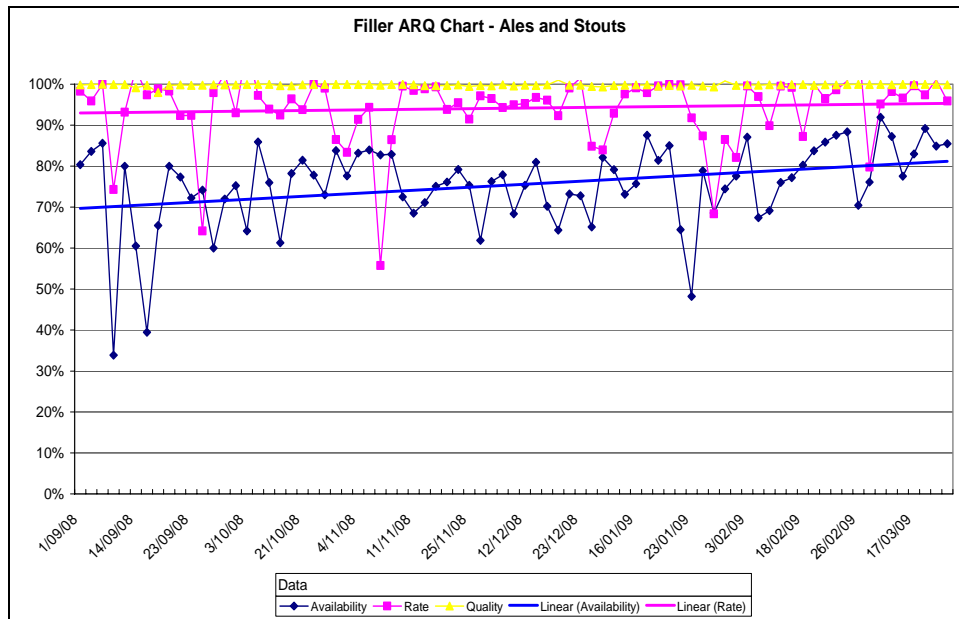
A part of Cooper’s medium to long term TPM<sup>3</sup> Improvement Plan is to undertake a Macro Focused Equipment & Process Improvement team on their Bottling Line at the start of each year while maintaining Area Based Team activity. This gives the Coopers Leadership Team an updated Overall Equipment Effectiveness (OEE) Loss Matrix for subsequent Pre-cycle Strategy meetings. Coopers Brewery have also been upgrading their Bottling Line equipment over the past 3 years, thus changing the characteristics of the line.

The latest Macro Focused Equipment & Process Improvement team, the infamous “Dirty Dozen-1”, has been very successful by achieving its challenging mandate of improving Ale/Stouts OEE from **68% to 77%** and carton per hour rate from **1873 to 2127** (see diagram below) within the 12 weeks, which is a fantastic **13% improvement**.

Average Cartons per Hour For Ales / Stouts



The Bottling Line has also seen good gains in Availability and Performance Rate as displayed in the graph below.



What's made this team's result even more pleasing for the Coopers Leadership Team, is that the majority of the cycle was undertaken while the Bottling Line was running on a double shift with resources fairly stretched.

Coopers continues its Journey to World Class Performance with 7 active teams pursuing Manufacturing Excellence as part of Cycle 18 which commenced in mid April.



For further information about Lean & TPM (TPM<sup>3</sup>) please contact Larry Mazza – CTPM Technical Director who is providing on-site assistance to Coopers Brewery, on 0408 743 214 or CTPM Head Office on +61 2 4226 6184 or visit [www.ctpm.org.au](http://www.ctpm.org.au)

