

59% to 86%
Effectiveness

Month 1 to Month 2. Goal 85%.

51 to 4
Mechanical stops

Month 1 to Month 2. 1,750 to 112 minutes.

₹4.8 lakh
Revenue a day

Month 2, this line

HIGH-SPEED BOTTLING

Above the goal on one high-speed bottling line.

The line had to stay effective while production moved from 60 ml bottles to mainly 90 ml. Seeing which interruptions were taking the time gave the team a clear place to act.

The goal was a more reliable production run.

The line was below its 85% effectiveness goal, and production was moving from 60 ml bottles to mainly 90 ml. In Month 1 it packed 362,825 bottles at 59%. The monthly figure showed the gap. It did not show which interruption was taking the time, or which bottle was being filled. Mechanical stops were the loss: 51 stops took 1,750 minutes.

Neuron put the bottle, the hour and the stop in one view.

Planning, production and maintenance could see the bottle being filled, the hour the line ran, and the stop maintenance recorded. They could look at a mechanical stop next to that hour, including while the bottle changed from 60 ml to 90 ml.

Production activity

Bottles and running time

Product context

60 ml and 90 ml bottles

Loss reasons

Mechanical and other stops

A shared operating view for planning, production and maintenance

Mechanical stops became the priority: 51 interruptions had accounted for 1,750 minutes in Month 1.

Mechanical interruptions became the priority.

Month 1 to Month 2. Month 2 ran mostly the 90 ml bottle.

FINDING

Mechanical stops were taking Month 1.

Fifty-one mechanical stops took 1,750 minutes, and effectiveness was 59%.

ACTION

Clear the mechanical stops.

The team cleared those stops. Late starts, tilted labels, and instrumentation stops cleared with them.

RESULT

Four stops, and 112 minutes.

From Month 1 to Month 2, mechanical stops went from 51 to 4, and from 1,750 minutes to 112. Effectiveness went from 59% to 86%. The last stretch of Month 2 ran at 92% and 93%.

The same line, two months

	Month 1	Month 2
Bottle	60 ml	Mostly 90 ml
Effectiveness	59%	86%
Mechanical stops	51	4
Mechanical minutes	1,750	112
Bottles packed	362,825	1,961,113
Unplanned minutes	2,040	603

Month 2 includes 29,829 bottles of the 60 ml. ₹4.8 lakh is revenue a day in Month 2, on this line.

The line finished above its goal.

Effectiveness reached 86%, above the 85% goal. The last stretch of Month 2 ran at 92% and 93%. Unplanned time fell from about 85 minutes a running day to 26.

One high-speed bottling line, two-month operating report. Effectiveness, mechanical stops, and mechanical minutes compare Month 1 with Month 2. ₹4.8 lakh is revenue a day in Month 2.