

₹1.83 crore**More revenue a month**

One year. Two plants.

2.8 to 0.5 h**Unplanned stops**

One year. 14 packing heads.

70% to 84%**OEE**

One year. 8 packing machines.

GODREJ JERSEY | TWO PLANTS

Godrej Jersey — Design Partner

Unplanned stops reduced from 2.8 hours a day to 0.5 on dairy packing. Two plants, six lines, for a year. Packing and maintenance could not see the same stop.

The stop was a note after the fact.

The machine, the reason, and the minutes were not one record. A planned stop has an allowed time. When it ran past that time, the extra minutes were not on the machine.

Neuron put the stop and the reason on the same machine.

Packing saw the minutes. Maintenance saw the reason. On milk, unplanned stops fell from 2.8 hours a day to 0.5. On curd, OEE rose from 70% to 84%.

The stop

Start, end, and minutes

The reason

What was picked

The allowed time

When the extra minutes count

Packing and maintenance see that machine

Two plants, six lines.

First month against the last.

Milk and curd. The minutes stayed on the machine.

FINDING

The reason was not on the machine.

On milk, the printer took 3,664 minutes in the first month. On curd, the long stops were power, hot water, batch delay, and the incubation room.

ACTION

One record for both teams.

The operator picked the reason. Minutes past the allowed time stayed on that stop. Packing and maintenance read the same record.

RESULT

0.5 hours a day on milk.

Unplanned stops on milk fell from 2.8 hours a day to 0.5. The printer fell from 3,664 minutes to 135. OEE on curd rose from 70% to 84%.

Milk, hours a day

	First month	Last month
Unplanned stops	2.8 hours	0.5 hours
Unplanned downtime	4.1 hours	3.0 hours
Printer stops	3,664 min	135 min

A day is that month's minutes divided by the days in the month. Eight packing machines on curd. OEE rose from 70% to 84%.

On curd.

Power fell from 1,802 minutes to 52. Hot water running past its time fell from 3,373 minutes to 2. Batch delay and the incubation room went to zero.

Two plants, six lines, for a year. Hours a day are that month's minutes divided by the days in the month, 31 days then 30. Milk is 14 packing heads: unplanned stops 2.8 hours a day to 0.5 (5,130 minutes to 966), unplanned downtime 4.1 hours a day to 3.0 (7,671 minutes to 5,363), printer stops 3,664 minutes to 135. Curd is eight packing machines: OEE 70% to 84%. Neuron.