



Recovery UKAD Operations CW01

Supplier Development (POLF) – Serge Dislaire

All Customers OUTPUT MAP & ACTIONS

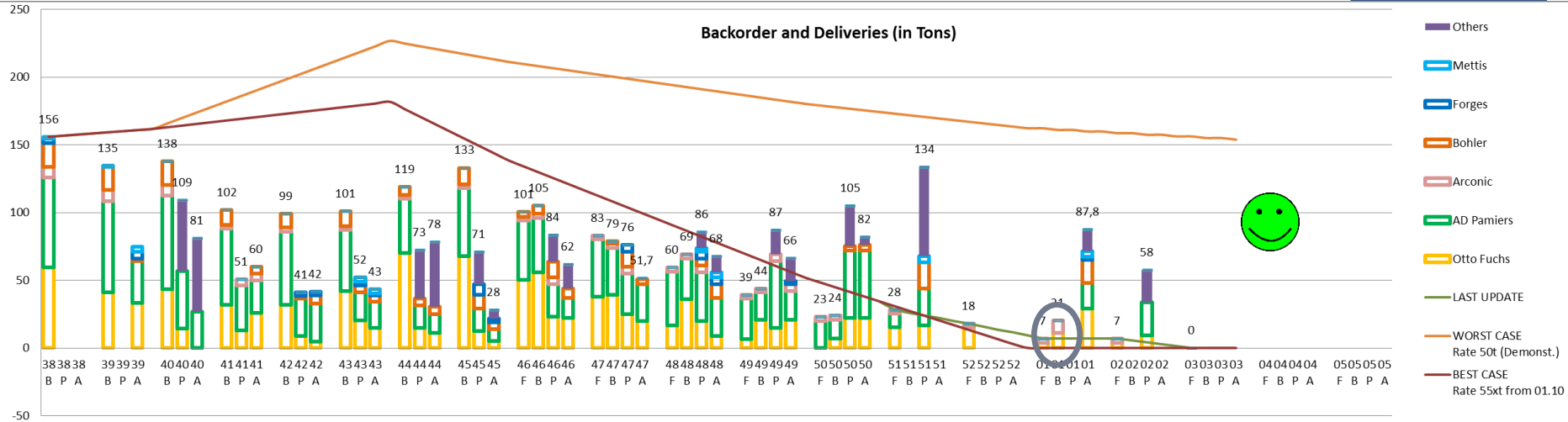
				All figures are in number of manufacturing orders						Detail of each step in "Steps" Spreadsheet					
Flow Output	Step 0: Release			Step 1: from Release to Quenching			Step 2: from Quenching to Finishing			Step 3: from Finishing to Slice for Lab			Step 4: from Slice for Lab to End		
	Week	Target	Achieved	Week	Target	Achieved	Week	Target	Achieved	Week	Target	Achieved	Week	Target	Achieved
W39				W39		6	W39		15	W39		16	W39		
W40		7		W40		1	W40		4	W40			W40		
W41	10	10		W41	12	16	W41	15	11	W41	10	8	W41	10	10
W42	16	19		W42	5	0	W42	10	13	W42	10	11	W42	8	8
W43	14	11		W43	5	7	W43	10	5	W43	10	8	W43	10	10
W44	16	7		W44	20	10	W44	10	9	W44	10	11	W44	14	14
W45	0	4		W45	7	13	W45	8	6	W45	10	5	W45	15	5
W46	13	21		W46	13	13	W46	12	1	W46	20	13	W46	20	16
W47	5	5		W47	12	9	W47	19	16	W47	16	13	W47	19	14
W48	7	7		W48	10	3	W48	12	10	W48	17	14	W48	27	15
W49	10	7		W49	8	11	W49	10	8	W49	23	16	W49	15	12
W50	14	14		W50	10	5	W50	10	7	W50	11	14	W50	25	17
W51	9			W51	3		W51	7		W51			W51	30	
W2				W2			W2			W2			W2		
W3				W3			W3			W3			W3		
W4				W4			W4			W4			W4		
W5				W5			W5			W5			W5		
WIP				W39		53	W39		51	W39		23	W39		42
				W40		53	W40		44	W40		26	W40		46
				W41		51	W41		45	W41		32	W41		63
				W42		62	W42		41	W42		34	W42		48
				W43		65	W43		45	W43		34	W43		35
				W44		39	W44		49	W44		29	W44		47
				W45		28	W45		41	W45		41	W45		45
				W46		22	W46		50	W46		39	W46		45
				W47		15	W47		36	W47		42	W47		54
				W48		23	W48		28	W48		39	W48		54
				W49		31	W49		26	W49		23	W49		64
				W50		37	W50		26	W50		14	W50		64
				W2		30	W2		19	W2		14	W2		41
				W3			W3			W3			W3		
				W4			W4			W4			W4		
				W5			W5			W5			W5		

Otto Fuchs OUTPUT MAP & ACTIONS

		All figures are in number of manufacturing orders			Detail of each step in "Steps" Spreadsheet										
Flow Output	Step 0: Release			Step 1: from Release to Quenching			Step 2: from Quenching to Finishing			Step 3: from Finishing to Slice for Lab			Step 4: from Slice for Lab to End		
	Week	Target	Achieved	Week	Target	Achieved	Week	Target	Achieved	Week	Target	Achieved	Week	Target	Achieved
	W39			W39		4	W39			W39			W39		
	W40		1	W40		0	W40		2	W40		7	W40		3
	W41	0	0	W41	4	6	W41	5	3	W41	5	4	W41	1	1
	W42	3	3	W42	0	0	W42	6	6	W42	4	3	W42	2	1
	W43	3	3	W43	0	3	W43	1	1	W43	4	3	W43	3	3
	W44	0	0	W44	4	3	W44	0	0	W44	2	2	W44	2	2
	W45	0	0	W45	0	1	W45	1	2	W45	1	1	W45	3	1
	W46	0	3	W46	3	3	W46	5	0	W46	7	7	W46	5	5
	W47	0	0	W47	3	0	W47	6	4	W47	6	7	W47	5	5
	W48	0	0	W48	3	3	W48	3	2	W48	4	5	W48	3	1
	W49	1	1	W49	3	3	W49	1	1	W49	4	5	W49	2	3
	W50	0	3	W50	0	0	W50	3	1	W50	1	1	W50	6	5
	W51	0		W51	0		W51	2		W51			W51	5	
	W2			W2			W2			W2			W2		
	W3			W3			W3			W3			W3		
W4			W4			W4			W4			W4			
W5			W5			W5			W5			W5			
WIP				W39		13	W39		16	W39		8	W39		14
				W40		13	W40		12	W40		9	W40		15
				W41		10	W41		13	W41		8	W41		22
				W42		13	W42		9	W42		11	W42		17
				W43		13	W43		9	W43		11	W43		13
				W44		7	W44		13	W44		7	W44		19
				W45		6	W45		7	W45		14	W45		18
				W46		6	W46		10	W46		8	W46		19
				W47		6	W47		5	W47		7	W47		20
				W48		4	W48		6	W48		5	W48		23
				W49		1	W49		9	W49		0	W49		25
				W50		4	W50		8	W50		1	W50		20
				W2		6	W2		7	W2		1	W2		11
				W3			W3			W3			W3		
				W4			W4			W4			W4		
				W5			W5			W5			W5		

BACKORDER

Delays for Otto Fuchs: lines to deliver in week 51 (recovery: week 3) and for Alcoa (Recovery: week 3)



Week/B: Backorder. P: Planned Deliveries; A: Achieved Deliveries per week

- OPPORTUNITIES:**
- Delays for Otto Fuchs: 150 beta delivered in week 1 but remaining quantity of 1,9t --> will be delivered in week 2. Two trucks were not enough to deliver the whole quantity for diameter 250 and diameter 250 beta --> will be done in week 2
- Delays for Arconic: two lines to deliver in week 1 for diameter 203 beta --> 2017 delays and the both lines for week 1/2018 will be delivered in week 3

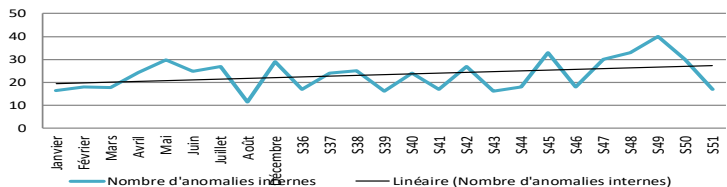
Internal Non Conformity (R1) STATUS



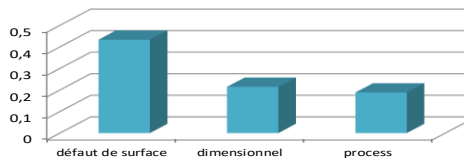
SYNTHESE DE PERFORMANCE : QUALITE INTERNE

SEMAINE 51

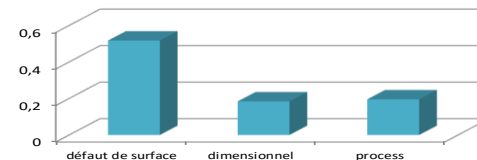
Nombre d'anomalies internes par semaine



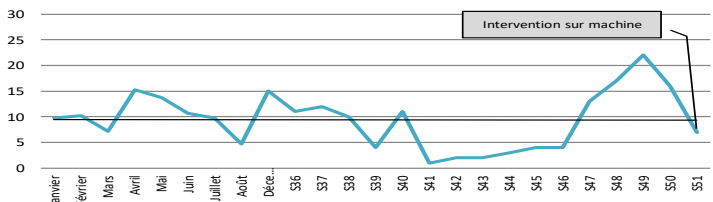
Pareto des anomalies - 2017



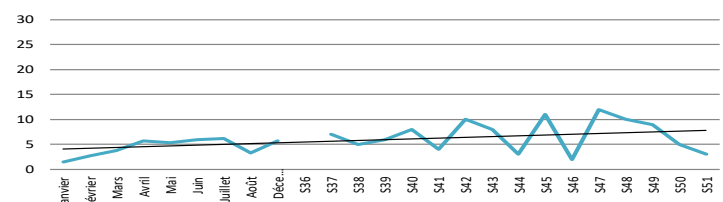
Pareto des anomalies - décembre



Nombre d'anomalies DEFAUT DE SURFACE par semaine



Nombre d'anomalies DIMENSIONNEL par semaine



Anomalie	Problème	Actions	Responsable	Date prévue	date réalisée	Avancement
Défaut de surface	Crique sur produit 330	Revoir gamme de forgeage sur 330	APN	S48	S46	100%
Défaut de surface	Crique sur produit après trempe	Revoir gamme de meulage sur carré ébauche	POV	S44	S43	100%
Dimensionnel	Erreur de coupe	Déploiement du nouveau mode opératoire de coupe	PJT	S42	S47	100%
Trace d'écroutage	Augmentation des défauts sur diam 330 (entraîne retouche)	Analyse des causes et construire le plan d'actions --> intervention fournisseur --> remise à plat des consignes et aide à la décision	POV	S51	S51	100%
Chauffage	Pannes	voir plan d'actions Forging Press				
Défaut de surface	Crique sur produit autre que 330	Appliquer les actions d'amélioration du 330 sur les autres produits	APN	S04		25%

Grinding weekly OEE

Will be updated next week

Forging weekly OEE

Will be updated next week

ACTION PLAN

Scope	Type	Action	To	Pilot	Progress	Effects	Impact	Impact when? (start date, end date if effects not at 100% level at the beginning)	Indicator to follow-up
Press area	Capacity	Starting additionnal furnace	W39	PTH (MAI)	Done	1. Respect of the forging press schedule. 2. 3 MO can be added to the production plan at each forging step of the routine. Increase of capacity to be assessed	Increase the throughput (55 operations --> ? Operations)	Assesment of the capacity increase thanks to the additionnal furnace: 3 weeks --> week 42 Impact on the final throughput: add 3 to 6 weeks: Week 47?	1. Number of forging press operations achieved versus number of forging press operations planned. 2. Additionnal number of operations which can planned. (currently: 55 operations --> ? operations) (owner: M.ElHadri)
Press area	Capacity	Additional working hours, 6h/week	W39	BDT (PROD)	Done				
Press area	Capacity	Additional working hours, 8 h /WE (not compulsory. Planning to end of december with volunteers).	W40	BDT (PROD)	Done				
All	Capacity	Subcontract grinding or sawing if too much load in front the machine (implementation of the flow rules)	W38	FHZ (SC)	Done				Load (hours) in front of the machine. Tons done par machine
Grinding Machine	Leadtime Quantity	Improve grinding process to eliminate surface defects during forging and grinding repairation	W40	MSR (MQP)	In Progress	Gain of 1,5 weeks on the leadtime for the impacted MO.	meet the leadtime taken into account for the allocation date		1. Number of MO to be rescheduled due to surface defects during forging. (owner: M.El Hadri)
Finishing Area	Quantity	Improve the cutting process with control, improvement of intermediary cutting operations + optimization of the cutting process (customer: Otto Fuchs)	W38	PJT (MQP)	Done	Ensure the quantity to be delivered. (Otto Fuchs)	No partial deliveries No need to allocate additional ingots	next deliveries of 250, 250 Beta, 133 Beta, 150 beta	1. Number of multiples per item (owner: P.Jacquet)
All	Leadtime	Reduce internal non quality and eliminate additionnal leadtime for reparation	W50	MSR (MQP)	In Progress	Impact of the non-conformities to be assessed: one week for the impacted MO.	meet the leadtime taken into account to determine the allocation date		1. Number of non conformities, pareto
		<i>Heating and Cracks workshop</i>							
		<i>Forging training</i>							
		<i>Forging tools management</i>							
		<i>Control of Key process with Braincube software</i>							
		<i>Reduction of the number of recutting due to lab non-conformities</i>							
Press area	Leadtime	Reduce equipment failures				1. Respect of the forging press schedule.	meet the leadtime taken into account to determine the allocation date		1. number of failures on the forging press area (hours lost due to failures) 2. Forging Press OEE (availability rate)
		<i>Maintenance technician dedicated to press reliability</i>	W44	PTH (MAI)	Done				
		<i>Reinforce the maintenance shifts</i>	W37	PTH (MAI)	Done				
		<i>Reinforce synergies and task force with Les Ancizes Maintenance team experts</i>	W40	PTH (MAI)	Done				
		<i>Invest a second furnace car</i>	W08/18	BDT (PROD)	In progress (W09)				
All	Leadtime	Improve the management of slow movers	W45	FHZ (SC)	In Progress	Less standard deviation on the leadtime. Meet the leadtime for all MO	meet the leadtime taken into account to determine the allocation date		1. Number of Slow Movers per machine.
Lab	Leadtime	Improve the leadtime (specific actions with lab VSM : cutting,...)	W5/18	FHZ (SC)/LCL (MQP)					
All	Leadtime	Produce billets for stocks	W10/18	FHZ (SC)		Protect the customer from any exceptionnal event			1. Level of stock per item

Key process work center to manage strongly

- Grinding machine return product system incident:

In place containment by using subcontractor.

Plan for high equipment intervention CW52.

- Forging press
- Manipulators
- Tooling inductor heater.
- Loading machine as single mean, need to recover asap & implement strong backup solution
- Furnaces
- Cutting machine
- Peeling machine subcontracting PM done W50.

2018: Important to grow up on equipment's OOE and deploy TPM & predictive maintenance