RL PROCESS SYSTEMS IMPROVEMENT TEAM
CONTROL AND IMPROVEMENT
PLAN

3/17/92

No.	START DATE	PROBLEM	EVIDENCE	OBJECTIVE	TEAM MEMBERS	QC/SIT TEAM LEADER	PDCA TIME LINE
42	3	Some of the product which we ship to our customers may exceed the specification limits we have agreed to meet. ✓	Product solubles P-charts for predicted out of specification. P-Bar UCLp LI 0.56 2.76 LII 0.71 3.18 LIII 1.45 4.36	Reduce product solubles variation so that 1) predicted product out of spec for percent solubles is consistently < 1.0% (UCLp) and 2) within week standard deviation of solubles measurements is consistently < 1.0% sol. (UCLs).			
43	6/91 14	Park 500 does not, on average, pack out at target O.V. ✓	TQM diff. at QB vs. actual. (14.54 on avg. at M/C)	Modify QB set point to deliver, on average, product at target O.V. in Packing.	M. Johnson M. Tiller	C. Spellmeyer (SIT)	
44	11/91 6	Excessive sand in the stock to the headbox causes machine downtime and limits machine speed. Data?	-Sheet breaks caused by sand streaks. -Sand build up in headbox, SBW tank, couch pit. -SBW cleaner pluggage.	Reduce LI machine downtime due to sand occurrances by 95%.	J. Lusk L. Pullano S. Shakeri H. Waltman	D. C. Saunders (SIT) R. K. Garg (TL)	4/92 7/92 9/92 10/92 Plan Do Check Act
45	11/91 10	Current product yield of 86.5 is below desired level of 87.0% which affects cost of RL. ✓	Yield 3/91 - 5/91 87.4 Yield 9/91 - 11/91 85.6	Increase yield to 87.0%.	M. Abel R. Lemaire S. Clarke L. Pullano C. Barlow M. Mills	M. T. Johnson (TL) (H Thomas (SIT)	12/13 12/17 3/31 Plan Do Check Act
46	1/92 5	FS bacteria counts are OOC high on all Lines and thick size volume has increased on LII, resulting in possible subjective concerns and solids build up in LII. ✓	TQM's - FS bacteria daily x charts - bacteria run charts on thick size dumped.	Reduce FS bacteria counts to in control levels and reduce thick size dumped to Jun-Dec 91 level.	B. Shope T. J. Webb J. Lodge	B. Young (SIT) K. Hayes (TL)	1/28 1/28 2/4 3/4 Plan Do Check Act
47	2/92	Confusion about equipment measures, causing non-conformance to equipment values.	-Differences between LI/II and III SPC sys. -Equip. measures not current. -Measures "outside" SPC system.	Improve level of understanding 250% and reduce variation by 56% by TQFA measure.	K. Hayes A. Tudor D. Budd D. Ganoe	B. Young (SIT)	2/19 3/2 3/17 4/15 6/30 Plan Do Check Act

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No.	START DATE	PROBLEM	EVIDENCE	OBJECTIVE	TEAM MEMBERS	QC/SIT TEAM LEADER	PDCA TIME LINE
9	9/89 [8]	Product is sometimes poorly distributed within hogsheads. -ND-	Customer coordinator observations. Customer reporting. Packing personnel observation.	Implement a statistical control method for controlling product distribution within containers. Packing I/II/III.	M. Smith K. Hayes C. Young	B. Bailey (SIT) T. J. Webb (TL)	
28a	4/90	We frequently shut the RL process down to change doctor blades.		Install a continuous doctor blade (7,900 lbs per day).	S. Clarke P. Dudley V. Loving	D. Clark (SIT) R. Garg (TL)	Line I 7/91 Engn. 5/92 Check 6/92 Act 7/92 Line II 4/92 Engn. 5/92 Check 7/92 Act Line III - Complete -
30	4/90	OV measurement system is manually operated and operates on an obsolete DEC computer; inst. measurement error.	Time required to capture data from floor is high; parts for computer are unobtainable; OV is critical parameter.	Clarify business requirements for OV control system, including product audit; prepare 650; obtain ASG approval.	M. Tiller E. Bass T. Long R. Garg M. Smith F. McFee	D. Westra (SIT) J. Campbell (TL)	3/6/92 Check 6/1 Act 1/1/93
37	2/91 [2]	KST, VST, usage deviations are unacceptable.	TQM p. 84-86, 164-166 CL not close to zero.	Bring CL to within +.1%, then change TQM to "0" CL	D. Budd M. Tiller J. Ciliberto ~~F. Duncan~~	J. R. Young (SIT/TL)	1/7/92 Plan 2/11 Do 3/6 Check 9/1 Act
39	3/91 [11]	Excessive pads in export product at BoZ causes processing problems (excessive primary cutter downtime, repair costs, and manpower usage). ?	-Customer complaints from BoZ and Bremen about downtime, machine and manpower costs. -1.7 to 9.5% pads in product at BoZ, Jan - Mar '91.	To maintain export pad levels at BoZ at or below 0.5%.	C. Young M. Tiller L. Pullano	D. Saunders (SIT) H. Waltman (TL)	4/91 Plan 2/92 Do 7/92 Check 8/92 Act
41	5/91 [1]	There is no agreed upon method for controlling refining & fiber size between shifts on Lines I or II.	a) no methods or procedures exist to support control of refining. b) TQM's for CSF parameters demonstrate many levels & wide variation weekly.	Define and establish a control strategy to effectively control refining on each Line.	A. Tudor J. Evans J. Hensley L. Fox W. Hayes B. Estes H. Waltman	D. Barfield (SIT/TL)	

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