

# *Line Utilization Program - 16 Learnings*

1. A lot of base hits add up to great results.
2. The data doesn't do anything unless you drive action.
3. Take the time to define our processes & then roll out.
4. Strong, active & visible executive leadership makes all the difference in change management.
5. Take the time to make sure changes take hold. Soak time is needed.
6. Need targets to go "red" 10% of the time to improve.
7. Data integrity eliminates arguments.
8. Real savings only happen if we sell more....so we must update ERP to make our increase capacity visible to planners.
9. It is more valuable to benchmark OEE against yourself.
10. Automated data collection doesn't make sense everywhere. In those locations, just use manual data capture.
11. Measure downtime at the bottleneck(s). The bottlenecks can move.
12. Commit to the 5 whys.
13. Must track scheduled downtime too, to get the full picture.
14. To sustain results, we must work at it and keep it visible to the organization as a whole.
15. Root Cause Analyses Quality is foundational
16. Audits are critical and training must be in place to address gaps.