

MPC Industries – Team Presentation



MPC Industries

Irvine CA

A premier grinding and polishing company serving the international aerospace, medical and various other industries whose customers demand high precision, quality products.

MPC is ISO 9001:2000 and AS9100 Certified, MPC provides first quality flat sheet and plate precision grinding and flat sheet and formed parts polishing on time – every time.



MPC Industries

“MPC’s Lean Journey Continues”

November 17, 2011
Mario Robles, CEO

MPC Company Overview

About MPC Industries

- ☒ Flat sheet polishing
- ☒ Formed Parts polishing
- ☒ Grinding, Sheet & Plate

Backed by over **50 years experience** and unique combination of resources.

Time proven competitive advantages, 50,000 Sq. Ft. facility in **Irvine, California**

Strategic partner in support of customer strategic and **supply chain goals**.

MPC

Flat Sheet Polishing



Formed Parts



Sheet/Plate



Customers



Driving Forces in Aerospace



Shortest Lead-
Time



Lowest
Cost



Highest
Quality

“What is Driving the MPC Shopfloor?”

“What gets measured, gets done”



The highest Quality (Measured by Customer)

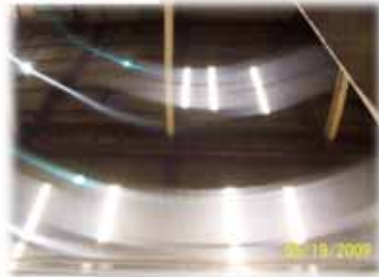


The shortest Lead-Time (Measured in Hours)



The lowest Cost (Measured in Profit)

How We Did It, Flat Sheet Polish



After Kaizen events,



We used **measures** that have true **value**

- Sq. Ft. polished per hour (we want to trend up)
- Labor hours per 100 Sq. Ft. (we want to trend down)

How We Did It, Formed Parts Polish



Standardized work time for each individual part

- Streamlined planning and scheduling
- Targets for qualifying operators
- Reduced output variation and overtime

How We Did It, Grinding



- ☒ We have **added 2 additional grinders**
- ☒ Third Grinder will **add width capacity of up to 80"**
- ☒ Measures That Matter
 - Cubic inches removed per hour
 - Daily tracking of Change – Over Time

Why Grinding?



To reduce weight



Custom Thickness



Custom finish (smooth, semi-smooth, rough, textured, etc)



Repair / Re-furbish



Custom preparation for a special process

Next Generation of Process Owners




Selection Criteria for Next Generation of Process Owners

Accountable	Determined	Innovative	ProActive	Collaborative	Customer Focused	Positive Thinking	Smart	Willing to Communicate	Deals Well with Stress	Works at fast pace
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Training Curriculum

- 1. VSM I: Principles, concepts and application**
2. VSM II: Sustainment and management of VSM
- 3. Process mapping and flow charting**
- 4. Using Communication Board as a Tool**
- 5. Kaizen I: Principles, concepts and application**
- 6. Kaizen II: Kaizen event Participant**
7. Kaizen III: Kaizen event Leader
8. Process Owner Capstone: Putting it all together






Planning the Event

-  Goal: Develop a Current State Map and Future State map for FY '12
-  Assemble a Cross Functional Team that includes the New Process Owners.
-  Create Value Added “Inputs” for the development of the FY '12 Strategic Plan.

The Team



The Team

-  MPC Process Owners
-  Director of Quality and Logistics
-  Newly Hired Facilities Manager
-  Engineering
-  Richard Lazarro, Sikorsky Team Member

Dream Team!

What we Did



Trained




Separated into three teams

With stopwatches drawn and pens ready the teams attacked their value streams!

What Really Happened

**“Involve me and you get my
Commitment, No involvement, No
commitment.”**

 Great opportunity to involve most of the production employees.

 Challenged the three teams to ask two questions:

10 Improvement & 5 Safety , suggestions per team.



Ask any employee encountered during the VSM event:

“What could make your job better?”

“What could make it safer?”

GIT - R - DONE!!!



Use Three Reals

- Real Person
- Real Place
- Real Machine

AH - HA Moments



Ed Lara, Over 20 Years Experience



Jeff Hurtig, 6 Days

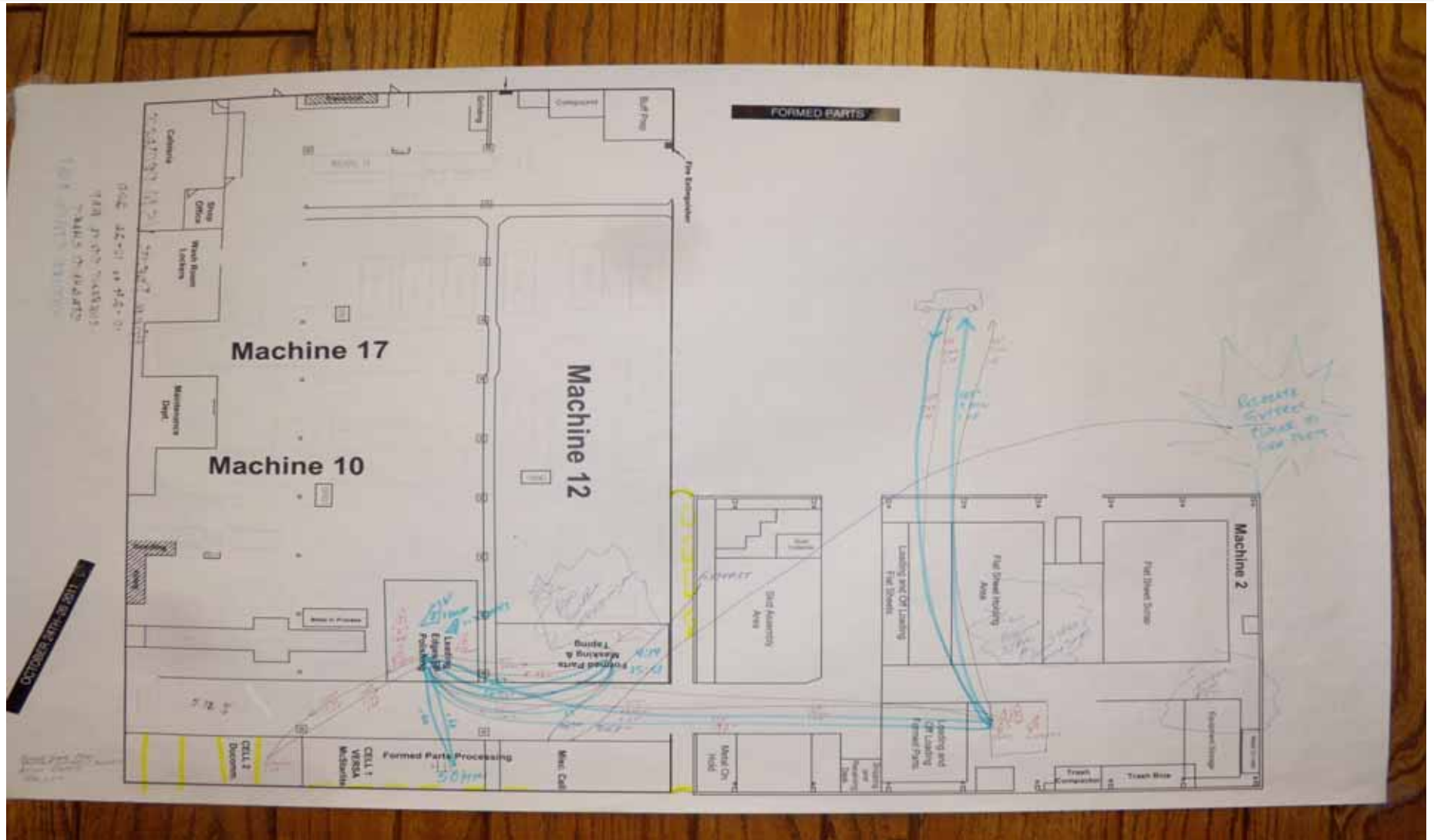


Jose Chavez Jr., Bridge the Generation Gap, (Wasn't Born when Ed Started at MPC!)

Ed Lara



Spaghetti Diagram




Jose Chavez



Involvement : Gets - R - Done

 Opportunities of Out of Sight, Out of Mind operations.




 Sweet Suggestions.....

 Tremendous knowledge that the Operators have of their jobs and their contribution to the Value Stream

Jeff



Way Cool!

-  Got to see theories turn into action.
-  Learned so much in such a short time that Jump Started my knowledge of MPC
-  Got Involved and Committed at the Start, especially knowing that our efforts were key ingredients to the next year's strategic plan.

Deliverables

- ❏ Current State VSM
- ❏ Completed “Spaghetti” layout
- ❏ **Future State Map** Identifying the potential value of the Changes being proposed.
 - **14** Major Kaizen Events to be Prioritized and Scheduled
 - **18** Improvement Suggestions
 - **13** Safety Suggestions
 - **Potential Annual Savings** in excess of **\$250,000**

World Class Quality

ISO 9001 and AS9100 Certification



“The pursuit of world class management procedures and business practices”

Lean Enterprise System & Continuous Improvement



“The pursuit of the Highest Quality, Lowest cost and Shortest Lead-Time”

Measurable Results

Results	Before (Baseline)	After (12 month avg.)
On-time Delivery	92%	96%
Lead Time	Flat sheet and formed part polish deliver to F.G. Inventory Grinding: From 5-7 days to 48 hour expedite service	
Quality (ppm)	4874	255
Cost	24% Reduction , this year from last year	
Sales \$ per Employee	24% Increase	
Output in Flat Sheet	55% increase (fy2010 vs.. fy2011) No additional machinery or manpower	
Changeover (Grinding Dept.)	53% reduction (from 53min. avg. to 25min. Avg.)	

MPC and SEA Members

World Class Partnership and Collaboration



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