

Give the press area a clear reset

Extrusion press and die-change preparation

Oily access areas, mixed die-change equipment and poorly separated offcuts obscure the press area's ready condition. Focus the first trial on the staging and access zone.



PROPOSED CONCEPT / A-GRADE TARGET, NOT AN ACHIEVED SCORE

SAMPLE START

31.6%

Grade D

PROPOSED TARGET

90.8%

A-grade target

EVIDENCE COVERAGE

76%

19 of 25 criteria

Visible press surroundings, die-change staging and storage boundaries. The press operating envelope, temperature, hydraulic systems and lifting methods stay under existing competent controls.

Sample inspection notes supply the numbers. Generated scenes illustrate the arrangement. A starts at 90% of observed criteria; unknown Sustain evidence stays unscored.

See the change. Keep the same workplace.

The proposed arrangement keeps the machinery and viewpoint. It is a discussion image.

ILLUSTRATIVE STARTING CONDITION



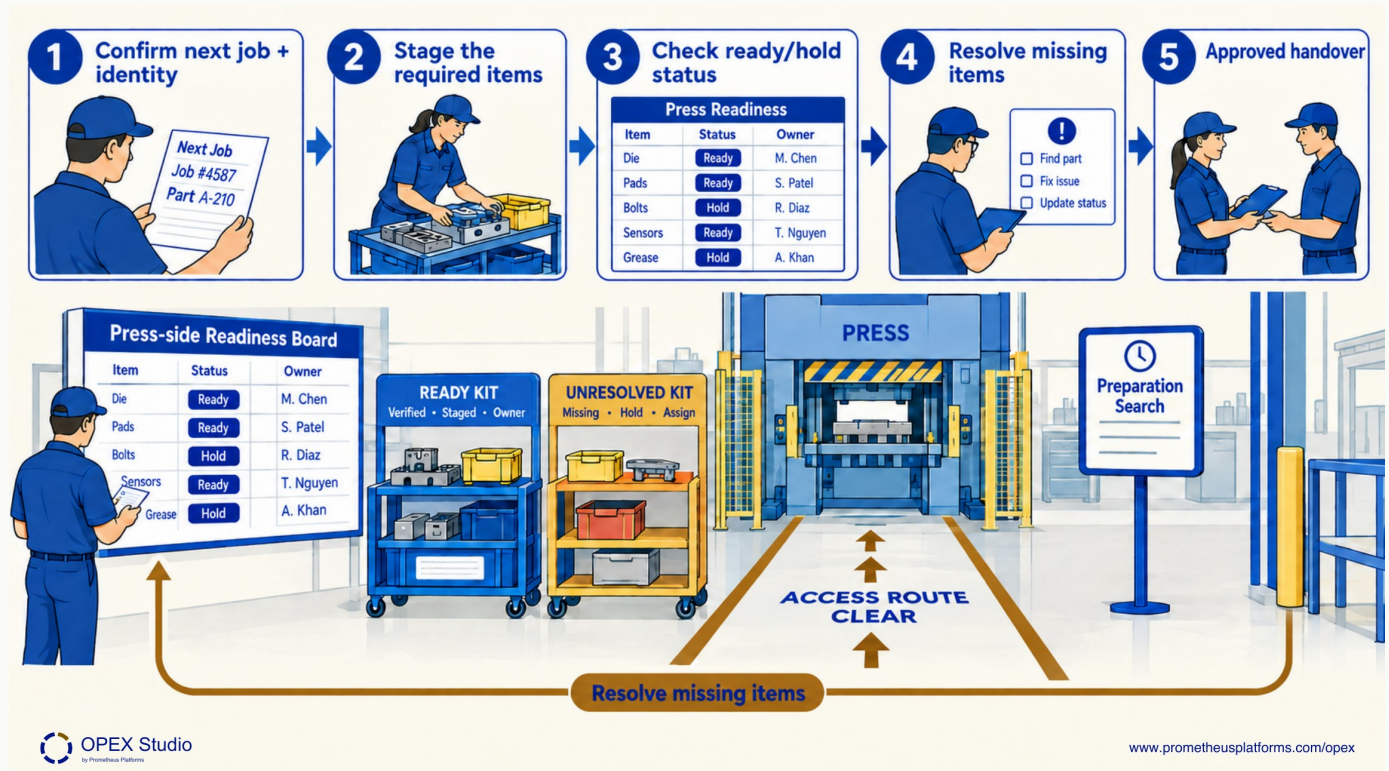
PROPOSED CONCEPT / A-GRADE TARGET



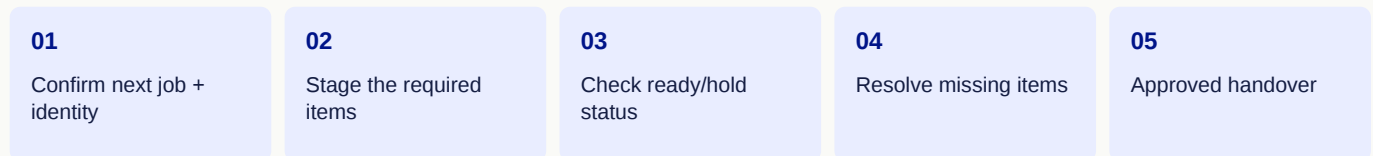
Neither scene verifies guarding, technical suitability, sustained practice or an earned result. Use actual inspection and recheck evidence before accepting any improvement.

Separate searching from a ready change kit

Give the press area a clear reset



GENERATED TEACHING ILLUSTRATION / FICTIONAL WORKPLACE



Retained preparation-search sample: 10 observations, median 9 minutes; proposed goal 4 minutes. It measures approved-list opening to verified-item readiness in the authorized staging area.

The existing measure is preparation search: ten observations, 9-minute median, 4-minute goal. Make required die-change equipment and identities visible before the authorized handover. Record missing or unverified items and assign a response. The organization trial does not change press settings or prove a faster technical changeover. Keep the boundary between external preparation and work requiring a controlled machine state explicit.

TRY IT / DISCUSS

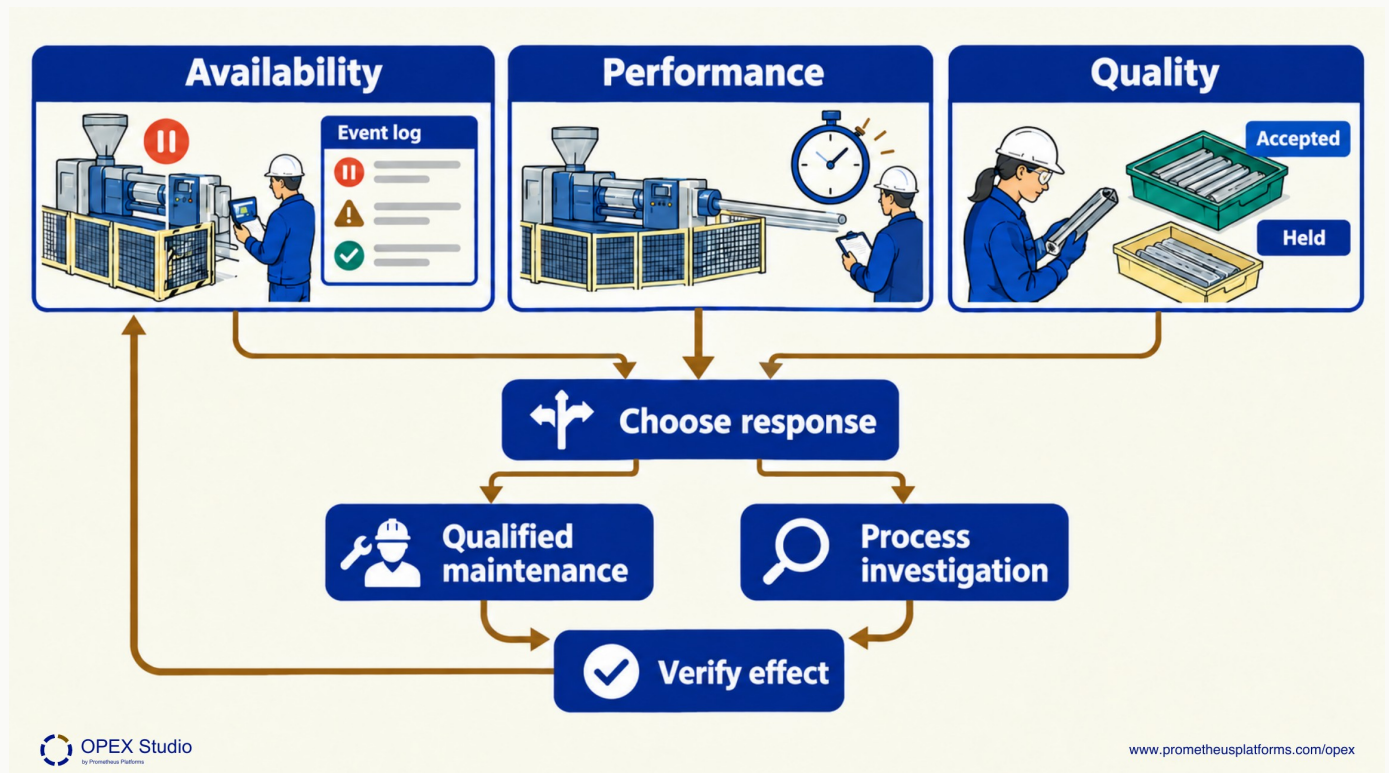
Does meeting the 4-minute search goal prove a 4-minute changeover?

Check your reasoning: No. Search is only one component; technical changeover has a different start/finish and controls.

METHOD SOURCES / F01: Total Productive Maintenance | F03: Asset Condition Management: A Framework for Smart,... | F04: OEE Implementation Guide | F15: Research Suggests Significant Benefits to Investing... | F18: Quality Glossary: Overall Equipment Effectiveness

Read equipment losses without hiding them

Give the press area a clear reset



GENERATED TEACHING ILLUSTRATION / FICTIONAL WORKPLACE

450 min

Planned

360 min

Running

300 min

Ideal-equivalent

285 min

Good-equivalent

NEW FICTIONAL EXERCISE: $A\ 80\% \times P\ 83.33\% \times Q\ 95\% = OEE\ 63.33\%$

New fictional OEE exercise: 450 planned production minutes, 360 running minutes, ideal cycle 0.5 minutes/unit, 600 total units and 570 first-pass good units. Equivalent-time waterfall: $450 > 360 > 300 > 285$ minutes. Losses: 90 downtime, 60 speed and 15 quality minutes. These are time equivalents, not three independent stopwatch readings.

OEE combines availability, performance and quality within a declared boundary. In the new teaching exercise, $A=360/450$, $P=(600 \times 0.5)/360$ and $Q=570/600$; $OEE=63.33\%$. This is not the press case's measured OEE. Inspect the loss components before choosing a response. A high OEE alone does not prove customer flow, safety or equipment health, and changing the denominator does not remove a loss.

TRY IT / DISCUSS

If the team removes planned downtime from the denominator after the event, is that improvement?

Check your reasoning: No. Definitions must remain consistent; investigate the underlying loss and report boundary changes transparently.

METHOD SOURCES / F01: Total Productive Maintenance | F03: Asset Condition Management: A Framework for Smart... | F04: OEE Implementation Guide | F15: Research Suggests Significant Benefits to Investing... | F18: Quality Glossary: Overall Equipment Effectiveness

Six standards. One clear next step.

The baseline is an authored inspection exercise. Target levels are proposed for the same criteria.

Category	Start	Target	Observed	Coverage
Sort	35%	75%	5/5	100%
Set in order	31.3%	87.5%	4/4	100%
Shine	25%	100%	4/4	100%
Standardize	33.3%	100%	3/4	75%
Sustain	Unknown	Unknown	0/3	0%
Safety	33.3%	100%	3/5	60%

Start: 24 / 76 = 31.6%. Target: 69 / 76 = 90.8%. Unknown criteria remain outside both scores.

Priority work and accountable owners

Due	Action / sample owner	What must be checked
Day 7	Define the ready area Rosa / Press lead	Agree the service boundary, die states and authorized work conditions.
Day 14	Restore staging space Noah / Maintenance lead	Noah records the residue-source investigation, authorized correction and real recurrence check; verify the storage arrangement too.
Day 21	Practice the reset Leila / Shift trainer	Both shifts demonstrate the ready-state check and missing-item response.
Day 30	Check the next changes Arun / Quality lead	Repeat ten comparable preparation observations without weakening press controls.

Correct the source, then check the condition

Noah / Maintenance lead / day 14: Investigate the lubricant or hydraulic residue source within approved maintenance controls; verify the correction after an authorized return to service.

- Heat, stored energy, lifting and hydraulic work require the site's competent authorization; a layout picture changes none of those controls.
- Keep dies and handling attachments traceable and within their approved storage arrangements.
- A dry-looking floor does not establish that a leak source or recurring contamination is resolved.

The physical condition.

Criterion by criterion.

All notes are authored examples. Levels describe the sample starting condition; targets require later verification.

Existing production criterion	Sample inspection note	Start / target
Required materials production-01	Billet support items and material awaiting a decision share one staging position.	1/4 3/4
Tool selection production-02	The common die-change tools are present, with surplus items mixed in.	2/4 3/4
Inactive equipment production-03	An unused handling attachment occupies active staging space.	1/4 3/4
Scrap separation production-04	Extrusion offcuts extend beyond their sample holding boundary.	1/4 3/4
Working surface production-05	The change-preparation surface is usable but congested.	2/4 3/4
Tool locations production-06	Die-change hand tools return to several different places.	1/4 3/4
Material locations production-07	Ready and awaiting-review dies do not have distinct visible locations.	1/4 3/4
Travel paths production-08	Stored items narrow the marked service approach.	1/4 4/4
Work sequence production-09	The staging sequence is partly clear but requires backtracking.	2/4 4/4
Floor condition production-10	The sample notes record oily residue at a service-side walking position.	0/4 4/4
Equipment exterior production-11	A greasy exterior patch makes a new leak difficult to notice.	1/4 4/4
Waste containers production-12	The offcut bin is nearly full and loose pieces surround its base.	1/4 4/4
Cleaning access production-13	Cleaning equipment is available, but its return position needs improvement.	2/4 4/4

Review state: pending. An unknown is not a zero. Keep the original rubric definition and record what was accepted, changed, rejected or still needs an on-site check.

Standards, routine and safety.

Keep unknowns visible.

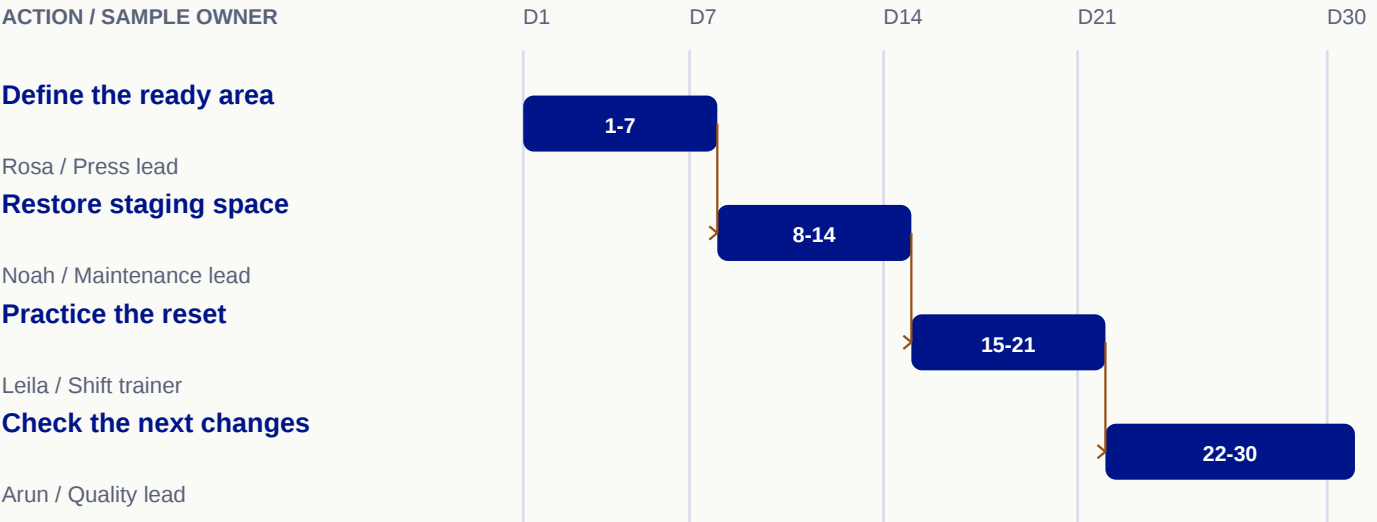
All notes are authored examples. Levels describe the sample starting condition; targets require later verification.

Existing production criterion	Sample inspection note	Start / target
Location labels production-14	Die-rack identification is incomplete in the sample register.	1/4 4/4
Visual instructions production-15	A visible local instruction exists but its placement can improve.	2/4 4/4
Condition reference production-16	The arrangement reference does not cover the overflow position.	1/4 4/4
Inspection prompts production-17	No usable inspection-prompt evidence is supplied.	Unknown Unknown
Recorded checks production-18	No repeated check record is supplied.	Unknown Unknown
Issue follow-through production-19	No retained issue-response history is supplied.	Unknown Unknown
Ownership cues production-20	The recorded owner of the reset is not supplied.	Unknown Unknown
Emergency route production-21	The sample walk identifies storage narrowing an emergency approach.	1/4 4/4
Guarding visibility production-22	Press guarding and interlocks require authorized verification.	Unknown Unknown
Trip exposure production-23	A service hose and loose offcuts obstruct part of the walking route.	1/4 4/4
Emergency equipment access production-24	Emergency-device access is not established by the sample notes.	Unknown Unknown
Hazardous material containment production-25	Closed lubricant containers are present; their holding arrangement needs review.	2/4 4/4

Review state: pending. An unknown is not a zero. Keep the original rubric definition and record what was accepted, changed, rejected or still needs an on-site check.

Thirty days. Owners, checks and follow-through.

A fictional sample team and proposed operating-day sequence. Each phase depends on the previous check.

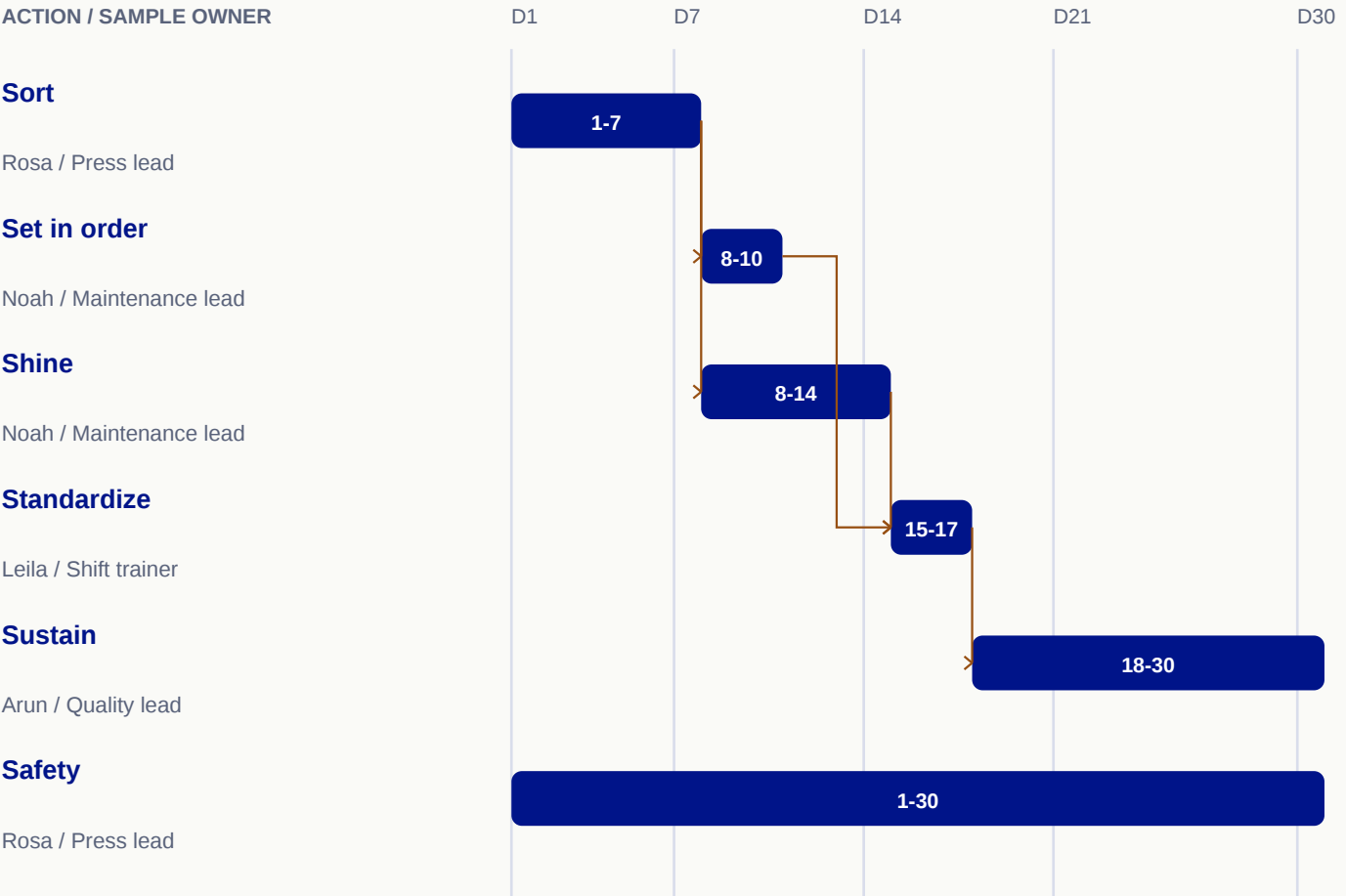


Day	Decision / owner	Evidence to bring
1	Agree scope and local controls Rosa / Press lead	Heat, stored energy, lifting and hydraulic work require the site's competent authorization; a layout picture changes none of those controls.
3	Record the starting condition Rosa / Press lead	Retain the item register, sample observations and full timing definition.
7	Accept one bounded trial Rosa / Press lead	Agree the service boundary, die states and authorized work conditions.
10	Check the proposed arrangement Noah / Maintenance lead	Ask a second practitioner to demonstrate the correct selection and return route.
14	Keep, adapt or reverse the trial Noah / Maintenance lead	Noah records the residue-source investigation, authorized correction and real recurrence check; verify the storage arrangement too.
21	Review both shifts and exceptions Leila / Shift trainer	Both shifts demonstrate the ready-state check and missing-item response.
25	Collect the complete recheck Arun / Quality lead	Repeat ten comparable preparation observations without weakening press controls.
30	Decide and assign the next review Arun / Quality lead	Compare actual results with the target; retain unresolved work and set a day-60 review.

Choose actual dates around approved access, operating shifts and required technical checks. A failed trial can return to an earlier phase.

Six S. One shared timeline.

Proposed project completion: operating day 30. Each workstream has a named owner; Safety remains active throughout.



Arrows show the checks that must finish before the next dependent action starts. Sort is followed by arrangement and correction of recurring problems; both feed the agreed standard.

Day 30: review, decide and assign the next step

Review the measured project result, all six workstreams and unresolved actions before deciding to retain, revise or extend the trial.

Required local controls are checked before the trial and remain active throughout.

Repeated checks provide evidence for review; the schedule does not establish a Sustain score.

Fictional sample team. Relative operating days; set real dates with the responsible team. A due date is a planned check, not evidence of completion.

What each S will deliver.

Proposed actions and acceptance evidence. All results remain unmeasured until the team completes its checks.

S / owner / timing	Action to complete	Evidence for acceptance
Sort Rosa / Press lead Days 1-7	Separate usable stock Identify usable billets, profile stock and offcuts with the press lead; route uncertain material through the existing disposition process.	Every retained bundle has a known identity and use; rejected material cannot return to the press feed.
Set in order Noah / Maintenance lead Days 8-10	Clarify staging positions Trial supported billet and profile positions outside the original press, guard and runout operating envelope.	The next changeover finds the required stock while existing equipment access remains clear.
Shine Noah / Maintenance lead Days 8-14	Investigate press-area residue Maintenance investigates hydraulic oil and grease recurrence, performs approved correction and records follow-up checks.	The cause and correction are recorded with a recurrence check during comparable operation.
Standardize Leila / Shift trainer Days 15-17	Agree the press-area reset Document the accepted staging, replenishment and handover checks with the press and shift leads.	A second shift demonstrates the same reset and knows how to report an abnormal condition.
Sustain Arun / Quality lead Days 18-30	Review consecutive changes Track material readiness, missed resets and recurring residue across the proposed month.	The day 30 review uses comparable changes and open-action evidence before retaining the arrangement.
Safety Rosa / Press lead Days 1-30	Review heat and equipment access The competent press lead reviews approved guards, hot-material handling, stock support and access before any change.	No staged material or new marking compromises the established operating controls.

The receiving owner checks the evidence before closing an action. Record a failed check, the next response and a revised review date; do not mark the whole project complete because the area looks better.

Check the real change. Keep what works.

The concept starts the conversation. The recheck decides whether the work improved.

Process measure	Sample start	Proposed goal	Actual recheck
Preparation search time	9 minutes	4 minutes	Not measured

Median of 10 authored sample observations. Start with the approved change-preparation list; finish when required verified items are ready in the authorized staging area.

Also protect: Required checks, die identification and authorized handling remain complete.

Bring evidence to the day-30 decision

1. Retain an actual later source image from the same area and a comparable viewpoint.
2. Review every criterion against its original definition; record what is still unknown.
3. Repeat the full 10-observation timing sample using the same start/end rules.
4. Required checks, die identification and authorized handling remain complete.
5. Review repeated checks, misses and issue response separately from the visible-condition score.
6. Adopt, adapt or stop based on actual evidence; retain the first report and create a new revision.

Keep the improvement working

Routine	Sample owner	Response
Each-shift reset	Leila / Shift trainer	Record a missed check or recurring concern and assign the next action.
Comparable process sample	Arun / Quality lead	Review the complete sample and any quality or workload tradeoff.
Day-60 review	Rosa / Press lead	Confirm continued use, unresolved work and the next improvement cycle.

Original OPEX production rubric opex-6s-2026-09-v1. The A threshold is 90%; this is a conditional visible-condition target, not an organization rating or safety certificate. Fictional people, authored sample notes and generated scenes; no achieved result is claimed.