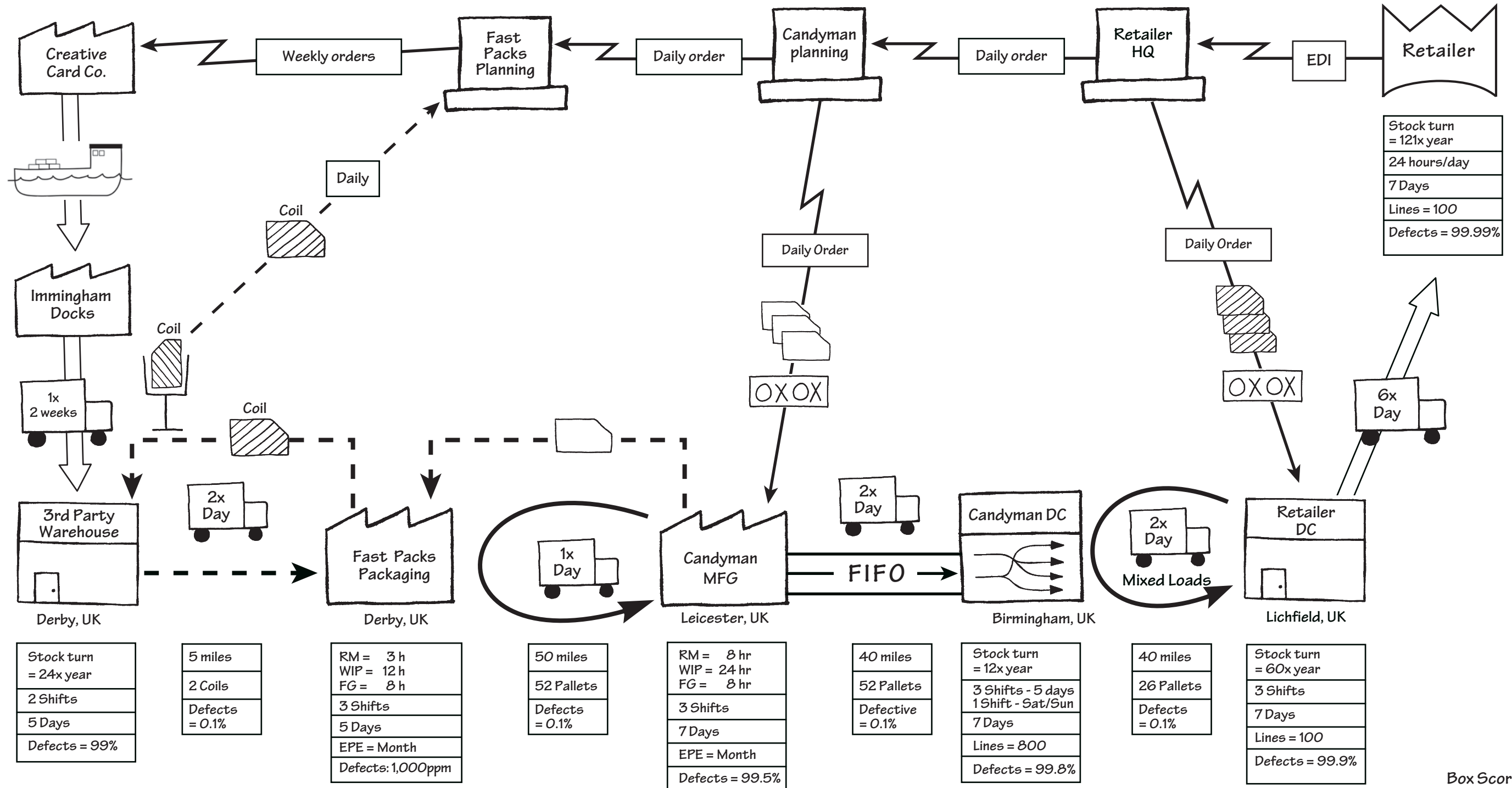




# Candy Bar — Future State



Stock turn = 121x year
24 hours/day
7 Days
Lines = 100
Defects = 99.99%

Stock turn = 24x year
2 Shifts
5 Days
Defects = 99%

5 miles
2 Coils
Defects = 0.1%

RM = 3 h
WIP = 12 h
FG = 8 h
3 Shifts
5 Days
EPE = Month
Defects: 1,000ppm

50 miles
52 Pallets
Defects = 0.1%

RM = 8 hr
WIP = 24 hr
FG = 8 hr
3 Shifts
7 Days
EPE = Month
Defects = 99.5%

40 miles
52 Pallets
Defective = 0.1%

Stock turn = 12x year
3 Shifts - 5 days
1 Shift - Sat/Sun
7 Days
Lines = 800
Defects = 99.8%

40 miles
26 Pallets
Defects = 0.1%

Stock turn = 60x year
3 Shifts
7 Days
Lines = 100
Defects = 99.9%

P/T	30 min.		(5 min.)		(40 min.)		30 min.		20 min.	20 min.	Box Score
L/T	10 days	0.25 hour	7 days	1 hour	7 days	1 hour	30 days	1 hour	6 days	3 days	P/T = 100 min (45 min)
%C/A	99% (10,000ppm)	99.9% (1,000ppm)	99.9% (1,000ppm)	99.9% (1,000ppm)	99.5% (5,000ppm)	99.9% (1,000ppm)	99.8% (2,000ppm)	99.9% (1,000ppm)	99.9% (1,000ppm)	99.99% (100ppm)	L/T = 63 days
Steps	4	1	6 (4)	1	9 (7)	1	4	1	4	4	Steps = 35 (11)