



PHOENIX

CONSULTANTS & ASSOCIATES

Phoenix Consultants & Associates - is an engineering and consulting services provider especially skilled in translating business needs into technical system requirements that meet the objective. Our goal is to help companies enhance their competitiveness by thoroughly evaluating their business goals alongside their capabilities. Our primary value is the ability to improve the profitability, productivity, and effectiveness of your organization.

Who can benefit

Our clients include food, pharmaceutical, health care and consumer products producers who require customized engineering and consulting services. We have been involved in projects ranging from \$10K support projects to \$50 million capital projects.

Typical benefits of our services include:

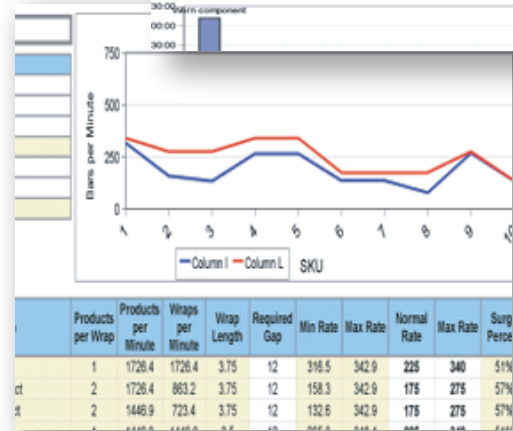
- * Increased system and project ROI
- * Reduced cost of goods
- * Systems and resources aligned with your business objective
- * Reduced inventory and WIP
- * Released stranded capacity and increased utilization of assets

We utilize principles of Lean and Six Sigma and are deeply skilled in:

- * front-end analysis and system requirements definition that help clients refine and de-risk their business case
- * project planning and implementation management
- * operational readiness and training coordination services that help clients with the challenges of new process and technology adoption
- * organization design and development

We help focus company resources on business objectives by assisting in identifying critical issues and results areas. We then structure plans to achieve your desired endpoints. We build on existing company strengths and enhance your ability to recognize new opportunities and solve problems.

Daily Production Summary			March 22, 2006	
Product	Widgets	Wraps/ min	Top Downtime Root Causes	
Line Speed	600	collations	Top 10	Total Stc
Total Production	23000	lbs.	Worm component	1
Total Waste	51		Glassine reel not tracking	1
Daily OEE	63.9%		Cleaning	1
Machine Efficiency	69.7%		cleaning	6
	(hh:mm:ss)	Collations	Collator Jam	4
Total Time	24:00:00	36000	Splice break	2
Internal Stoppages	(1:59:56)	(2993)	Marchinae stop	6
Operating Time	22:00:04	33062	Internal -- Operator	4
Internal DT	(5:58:42)	(6945)	Collation count sensor	7
Valuable Time	16:01:22	24034	Wear	1
MTBF	20:00		Dose Weight Summary	
MTR	10:24		Total Measurements	Grouped
Performance Summary by Source:			Samples > Control Limit	2
	Events	Total Time	Target Gross Weight (µg)	1570 mg
Internal	36	5:58:42	Specification Limits (+/- µg)	58.5 mg
External	8	0:26:26	Average Dose Weight	
Planned/ Other	2	1:33:30	Standard Deviation	
			Sigma Level (σ)	



We've achieved the following:

- \$3 million reduction in required capital
- System integration cost-savings of 60%
- 11.9% reduction in cost per unit output, and a 193.2% ROI
- 12.4% reduction in Manufacturing Added Costs, a 20.8% decrease in consumer complaints
- 15% improvement in efficiency and a 20% reduction in waste
- 28% mill waste reduction, 50% improvement in asset utilization