



## MINUTES

**Operations Committee Meeting** April 16, 2010 at Purdy's Chocolates

We are grateful to Jim and Gary and Purdy's Chocolates for hosting this meeting of our group.

1. MOVED/SECONDED TO APPROVE MINUTES OF MEETING OF February 19, 2010 WERE APPROVED AS PRESENTED.
2. Topic: *Automation: Measuring Productivity Directly from Equipment* – Bill Sandhu i2i  
Automation – Bill supplies automation hardware and software. He has been customizing off the shelf products since 1985.
  - Value of real time measurement – can compare against internal and external benchmarks and measure the true cost of your products and services.
  - Automated measurement also gives immediate and objective feedback on employee performance.
  - Data collection is best at machine level and collection can be by employee, team, machine, production line, department or plant
  - Date required for productivity measurement – **What:** product name & quantity; **When:** Time – exact (direct measurement) range (indirect measurement); **Where:** location/origin of product – machine/line name; **Who:** Employee/ team name; **Quantity/Accuracy:** employee input – keyboard, push buttons or from machine CPU/PLC, existing or new sensors ie. PLC, barcode scanners, vision systems, colour, proximity, ultrasound etc.; photo eyes; scales; Carton coders/label printers/ applicators
  - Real time view gives you actual production start time, stop time, and pause times.
  - Cost analysis can be broken into job cost or SKU cost.
  - Equipment analysis –can measure output v. capacity; machine downtime ie. breakdowns or changeovers; bottlenecks.
  - PLC sensors and barcode scanners are data wealthy and under utilized in plants.
  - Quality data can be linked to productivity data using vision systems and can be linked to incentive-based pay systems.
  - Photo eyes – can be used for more than they are now.
  - Scales – RS 232 capture data – use the scale to control the production line.
  - Dashboard with information in real time – can be in 15 min. increments, can show total production & by workstation, including machine pause time.
3. Roundtable –
  - questions about what qualifies for SR & ED credits – Suzanne Mayhew from MNP talked about the requirements;
  - Is anyone measuring greenhouse gases in answer to Walmart enquiries?
  - Donna talked about the Challenge approach taken in Fraser Valley Operations Cluster – processor to pose a problem to the group.



# BC Food Processors

## A S S O C I A T I O N

- A processor raised the problem he has with locally licensed processors selling into his restaurant market. He would like a standard system of licensing. His main concern is food safety and the damage a problem would do to the entire sector.
  - Water discharge – are all municipalities charging for discharge?
4. Future Topics
- Donna to circulate list of topics on the BCFPA Operations page <http://www.bcfpa.ca/group/bcfpa-operations-committee>.
  - Talk to SUCCESS about their job fairs and employee training in Cantonese.
  - Kristin Spanza would like to have an informal meeting of plant managers ie. Saturday breakfast to discuss topics of interest – please contact [KristenS@sun-rich.com](mailto:KristenS@sun-rich.com) if you are interested..
5. **Future meeting topics** – please let me know what is of interest:
- Waste management
  - Cost analysis – cost of
  - Enterprise software SAP
  - Resource planning
  - Purchasing practices - qualifying a supplier
  - Automation.
  - Becoming export ready; continuous improvement, sanitation, reducing your environmental footprint (Wisent?), impact of HST on production.
- Members are encouraged to submit topics to Donna at [donna.brendon@bcfpa.ca](mailto:donna.brendon@bcfpa.ca).
6. **Advocacy Committee update** – tabled to next meeting
7. **Next Meeting –May 28, 2010** – Topic and location: TBA