

Going Green

February 3, 2009

What Impacted 2008 Results

1. 30 of 30 RTP upgrades were installed
2. 21 of 30 units were rebuilt
3. 5 of 5 folders were rebuilt

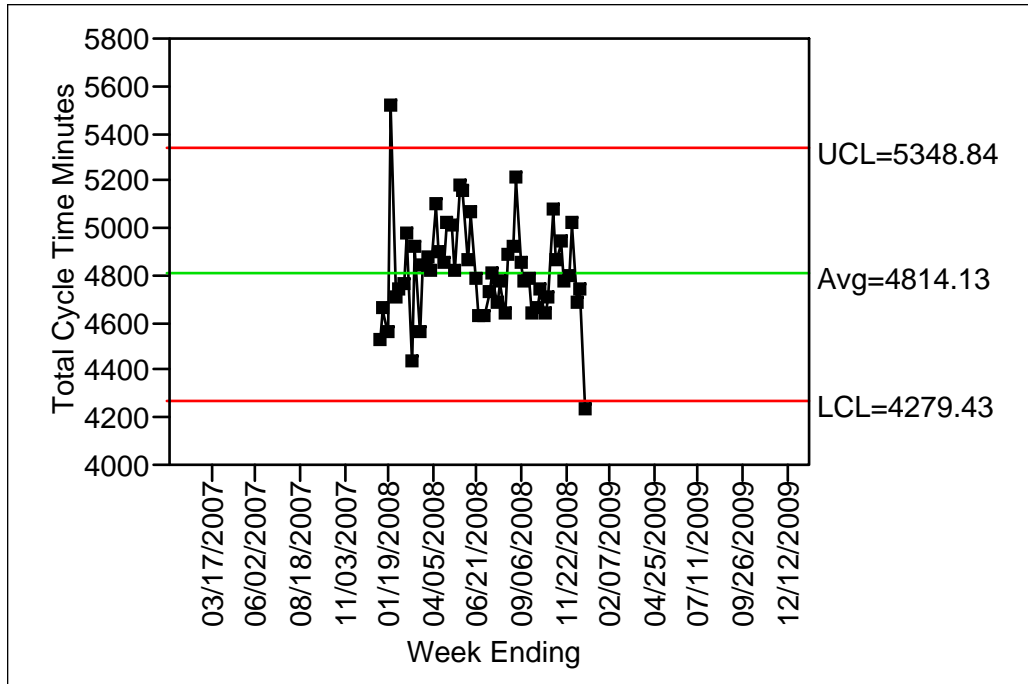
4. New lockups were installed
5. New dampening system was installed
6. New auto registration systems were installed

7. Talent was redistributed throughout the department

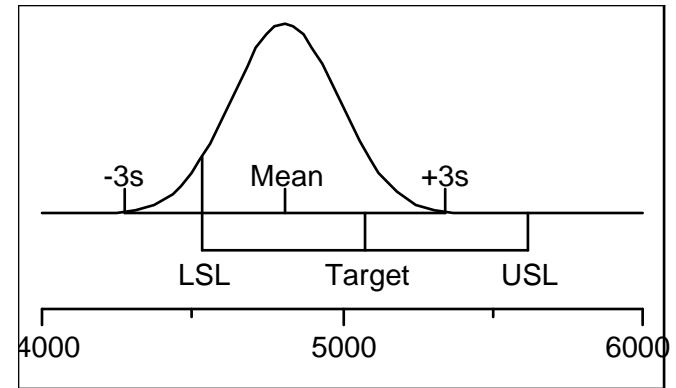
IMPACT

- Time
- Paper

Individual Measurement of Total Cycle Time Minutes

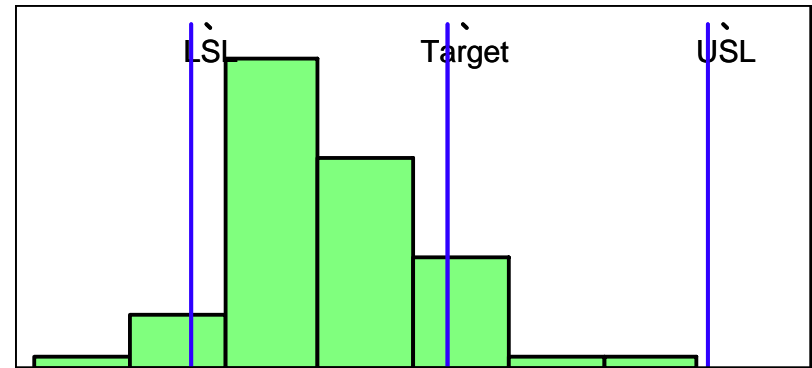


Control Chart, Sigma = 178.236



Capability Analysis

Specification	Value	Portion	% Actual
Lower Spec Limit	4535	Below LSL	5.7692
Upper Spec Limit	5625	Above USL	0.0000
Spec Target	5080	Total Outside	5.7692



80% of all products beat their cycle time goal

2008 CYCLE TIME RESULTS

Product	Weekly Goal (Mins.)	Weekly Actual (Mins.)	Yearly Press Hours Saved
Monday DB	136	124.94	(19.17)
Monday VP	141	127.96	(22.60)
Monday Link	103	91.74	(8.63)
Tuesday DB	130	118.62	(19.73)
Tuesday VP	138	133.17	(8.37)
Tuesday Link	99	89.86	(7.62)
Farm Fresh Suff	28	37.08	7.57
Farm Fresh FS	133	119.80	(11.00)
Rotovue	27	27.23	0.10
Flavor	277	295.88	16.37
HRSW	314	295.44	(16.08)
Wednesday DB	132	131.48	(0.90)
Wednesday VP	139	142.98	6.90
Wednesday Link	102	91.98	(8.52)
Beacons	129	124.94	(3.52)
Globe	101	97.46	(3.07)
Compass	62	59.71	(1.98)
Suff. Sun	33	36.81	3.30
Flagship A/C	84	74.26	(8.12)
Flagship B	70	70.52	0.43
Total	5809	5467.44	(399.82)

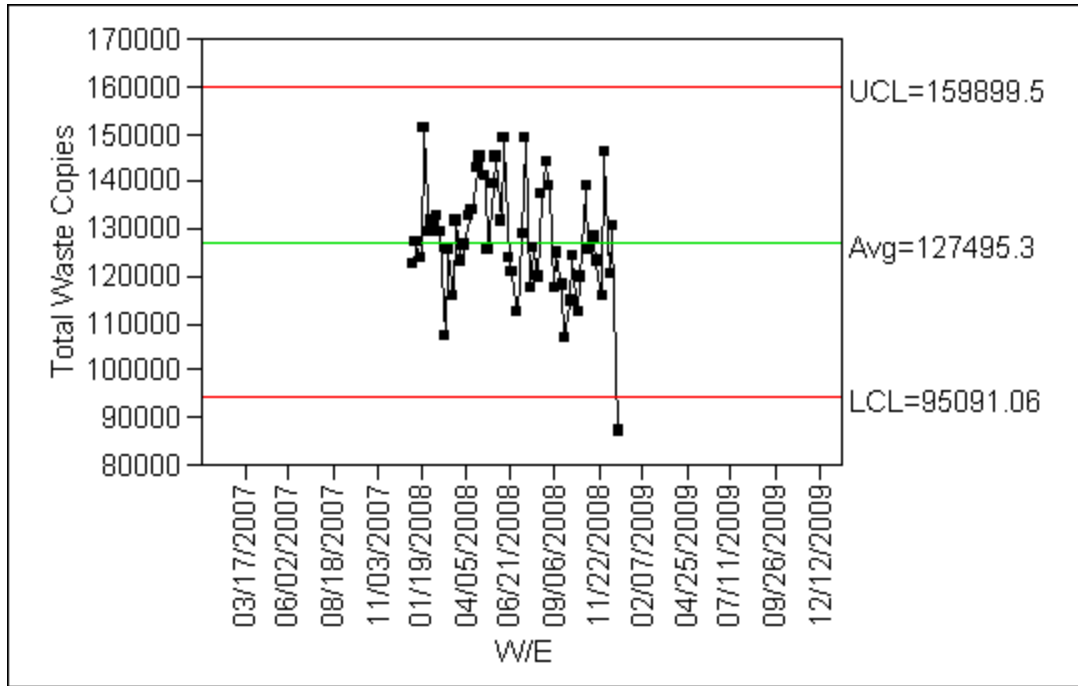
~~Going~~ Green

Saving

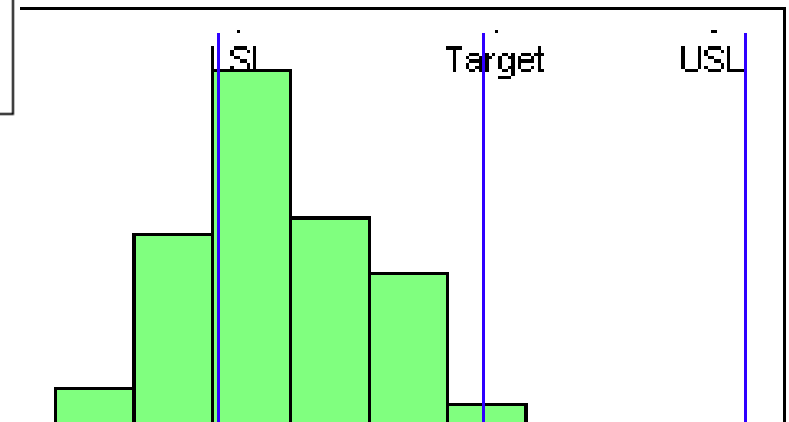
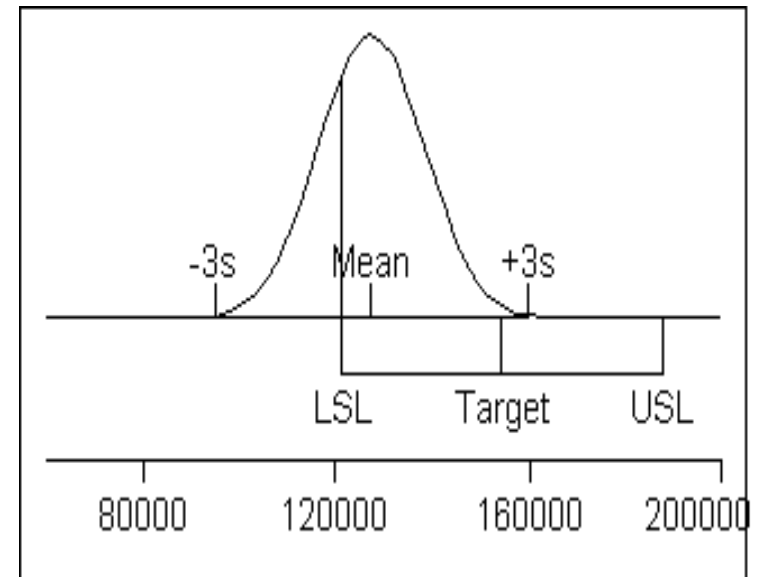
Salaries	\$180,240
Overtime	\$ 78,240
Packaging	\$ 16,000
Uniforms	\$ 5,475
Chemicals	\$ 20,204
Electricity	\$????
Water	\$????

Total	\$300,159
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Individual Measurement of Total Waste Copies



Control Chart, Sigma = 10801.4



Capability Analysis

<u>Specification</u>	<u>Value</u>	<u>Portion</u>	<u>% Actual</u>
Lower Spec Limit	121270	Below LSL	28.8462
Upper Spec Limit	187798	Above USL	0.0000
Spec Target	154534	Total Outside	28.8462

**17.50% reduction in printed waste copies.
96 % of all products beat their printed waste goals.**

2008 PRINTED WASTE RESULTS

Product	Weekly Goal (Copies)	Weekly Actual (Copies)	Yearly Copies Saved
Monday DB	4,425	4,008	(21,692)
Monday VP	5,856	4,807	(54,526)
Monday Link	2,128	1,645	(22,225)
Tuesday DB	3,702	3,002	(36,416)
Tuesday VP	6,178	5,483	(36,142)
Tuesday Link	1,670	1,306	(18,191)
Farm Fresh Suff	1,222	1,219	(126)
Farm Fresh FS	5,320	2,490	(141,493)
Rotovue	2,686	2,029	(17,070)
Flavor	5,762	5,226	(27,855)
HRSW	9,998	7,475	(131,195)
Wednesday DB	3,991	3,356	(32,407)
Wednesday VP	6,001	5,430	(29,695)
Wednesday Link	2,023	1,413	(31,086)
Beacons	4,715	4,278	(22,728)
Globe	2,862	2,116	(38,809)
Compass	1,539	1,460	(4,113)
Suff. Sun	1,366	1,331	(1,830)
Flagship A/C	5,423	3,959	(73,217)
Flagship B	2,235	2,009	(11,279)
Total	173166	140117	(1,683,588)

Paper savings about \$150,000

1.68 million fewer copies to recycle

We are not finished yet!

Period 1 Measure	2008	2009	Variance	Variance %
Reliability % (Metro Mains)	90.62	95.66	5.04	5.56
Cycle Time Minutes	19251	18591	(660)	(3.43)
Printed Waste Copies	524528	447458	(77070)	(14.69)
Printed Waste %	2.7950	2.5900	(0.21)	(7.33)
Paster Make Ready %	0.4525	0.3625	(0.09)	(19.89)
Left on Core %	0.5175	0.3500	(0.17)	(32.37)
Total Pressroom Waste %	3.7650	3.3025	(0.46)	(12.28)