

## Food Safety Kaizen Sheet

Britannia Industries Ltd

### Kaizen Title: Biscuit Packet Seal Integrity Improvement

Project Start and Finish Dates:  
01-12-20 & 20-12-20

Plant Name & Location:  
Perundurai Plant, Erode

Category (Tick as applicable): Reactive

Proactive

✓ Innovative

**Problem Statement with Status:** Continuous leak in biscuit packet which results in 11.3% Production Hold

**Implementation Area:** Good Day Packing Machine

**Improvement Target:** 6.38% DQI Hold

#### Causes of the problem:

1. High impression on Packets due to V Groove
2. Temperature Variation due to Low end sealing heater capacity
3. Jaw Misalignment
4. Biscuits sticking on the Jaw due to SS

**Root Cause: Weak Jaw Design**

#### Possible Countermeasures to eliminate Root cause:

1. C groove type Jaw
2. Teflon Coated on Jaw
3. End Sealing Heater Capacity increased to 400 Voltage

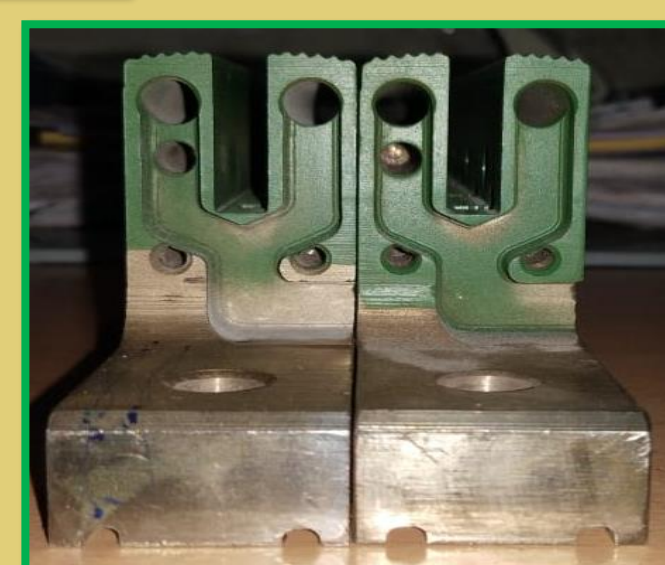
#### Final Countermeasure:

“Hand wash station interlocked with sliding door and voice command with visual display”

#### Problem Before Counter Measure



#### After Counter Measure



#### Benefits/ Results after Implementation:

##### i. Qualitative:

Safety (S) - Jaw Cleaning Frequency reduced  
Quality (Q) - Rework Reduced

##### ii. Quantitative: Production Hold reduced to 3%

Quality (Q) - Leakage was reduced from 6.6% to 3%  
Cost (C) – Laminate waste reduced from 7.6% to 2.81%

##### iii. Standardization of countermeasures:

**What:** Item code for Teflon Jaw

**When:** 30-12-20

**Who:** Saravanan (Engg. Store Officer)

**Others:** Training to Operators & Technicians

#### Scope & Future plan where this improvement can be implemented:

- Horizontal replication to 30 machines of Perundurai Plant
- Share with other factories for implementation

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#### TEAM MEMBERS



**Munesh Baranidharan**



**Suresh Babu**



**Ram Ondiveer**



**Poornima Dhamodharn**