



®
PHARMAVITE

Case Study

Pharmavite

Discovering Target Rates & Prioritizing Losses

PARSEC™



Nutraceutical Industry

The global leader in vitamins and supplements, Pharmavite needed a system that would allow them to keep up with growing demand, and give insight into their operations.

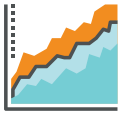
Utilized TrakSYS™ Features & Functions



Performance Management



Maintenance Management



Historian



Manufacturing Intelligence



OEE




Messaging and Notification



ERP Integration





Pharmavite needed more capacity from their existing assets and infrastructure to meet market demand, they turned to TrakSYS™.

Company Overview

California-based nutraceutical company, Pharmavite is a global leader and producer of dietary supplements and vitamins for all stages of life, with their brand Nature Made which includes a large array of vitamins, probiotics, sleep support, prenatal, and mood support to name a few¹.

Through innovation in products and marketing, Pharmavite has become a leader in the global dietary supplement and vitamin market. Pharmavite's commitment to quality and safety is backed by their dedication to science-based products for utmost customer health benefits and satisfaction.

With over 120 products available, Pharmavite is a leader in the American supplement market, and has some of the highest recommended supplement lines by pharmacists. With a large range of products, coupled with complex manufacturing and packaging processes, Pharmavite had a need to streamline operations to meet the growing customer demand. Continuing their innovation beyond products and marketing, manufacturing needed a real-time, dynamic solution to make larger gains in the areas of lean manufacturing and continuous improvement.

“We committed to increasing OEE and achieved our goal, which resulted in an estimated savings of \$421,000. Quality also improved from 99 to 99.6%. TrakSYS™ helped refine theoretical production rate standards, which in turn helped to improve visibility to capacity, facilitating better planning and ultimately improved schedule attainment.”

Lean Program Manager

TrakSYS™ Solution Approach

The TrakSYS™ based solution, designed and delivered by Parsec, not only had to provide real-time information with trusted accuracy, it also had to deliver the needed functionality to facilitate Pharmavite's asset utilization and expansion without new infrastructure. Pharmavite set out to investigate line event data capturing solutions and selected TrakSYS™ because of its design flexibility and breadth, the ability to grow into the system, Parsec's support model, company size, focus and accessibility, and total cost of ownership.

Challenges:

- Pharmavite was using MS Word & ERP entry forms to track uptime performance, then moved to an Excel based OEE tracking. However these solutions were not real-time nor capable of capturing detailed downtime information. This system was challenging to utilize correctly, and results were not maintained.
- The Excel based system established Key Performance Indicator (KPI) goals, but was time consuming to maintain and often resulted in miscalculations and extended time in verifying results.
- Production had a difficult time keeping up with market demand.
- Paper-based system was time consuming and drove bad behavior.

Goals

- Extract more capacity for growth from existing assets and infrastructure.
- Enable end-to-end root cause analysis on yield, quality, and other loss metrics (e.g. minor stops, manual stops, and maintenance)
- Improve reliability and predictability of both inventory and equipment service.
- Enhance operator engagement, and provide better understanding of financial standards, target rates, production losses and team performance.
- Better allocation of human capital and physical resources.
- Improve standard accuracy in planning and cost.
- Empower the workforce and build a more cohesive, goal-centered team.



TrakSYS™ Solutions Architecture

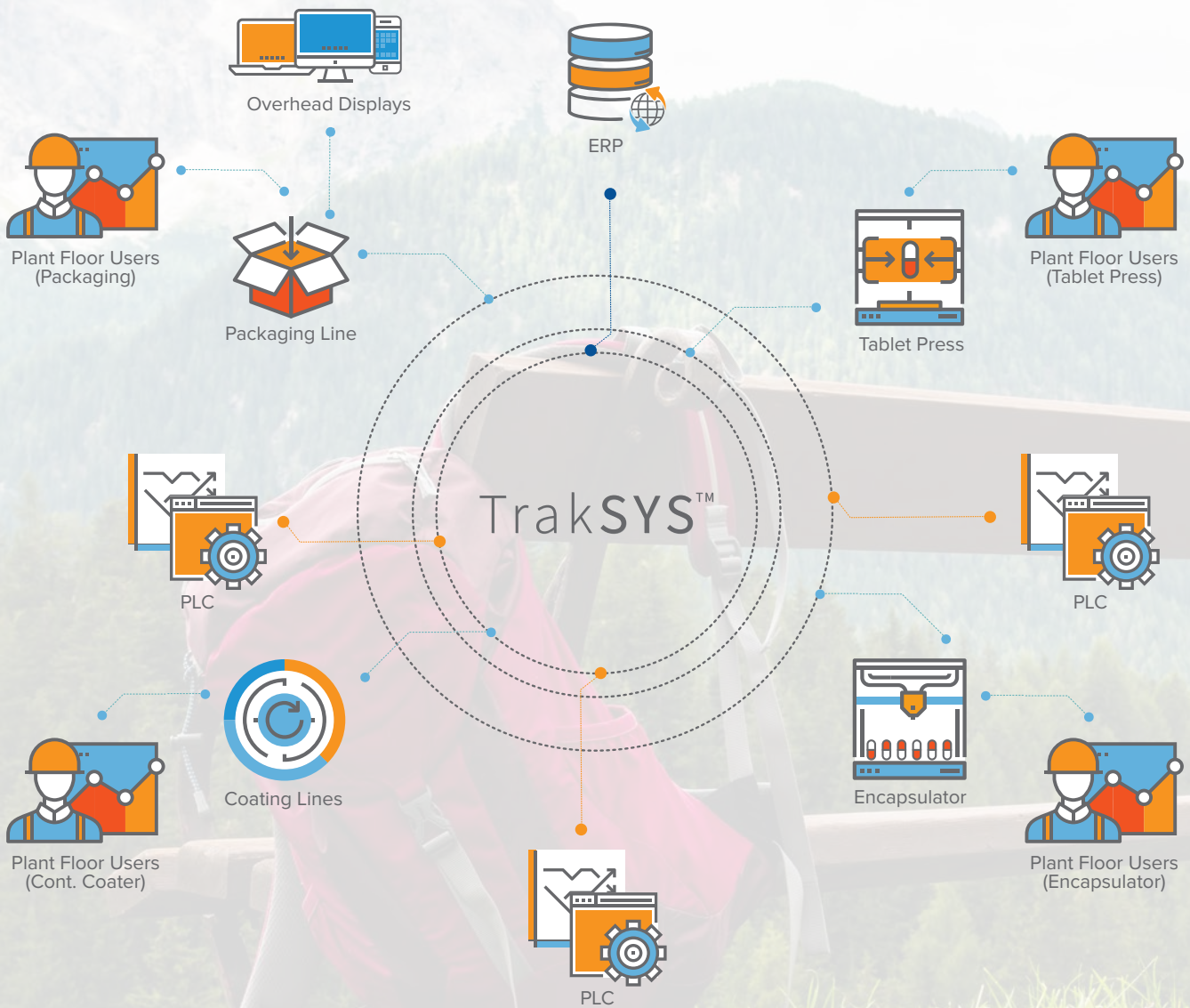
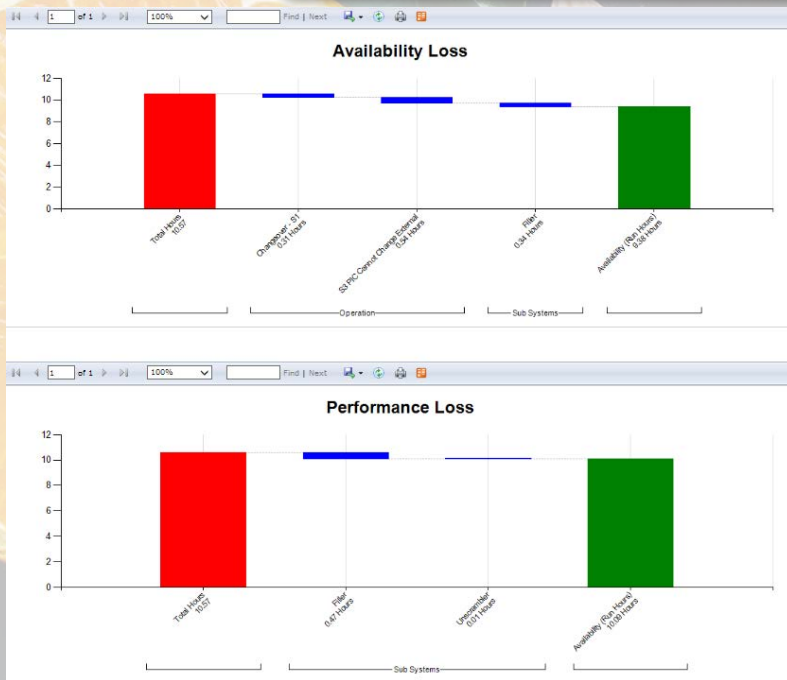
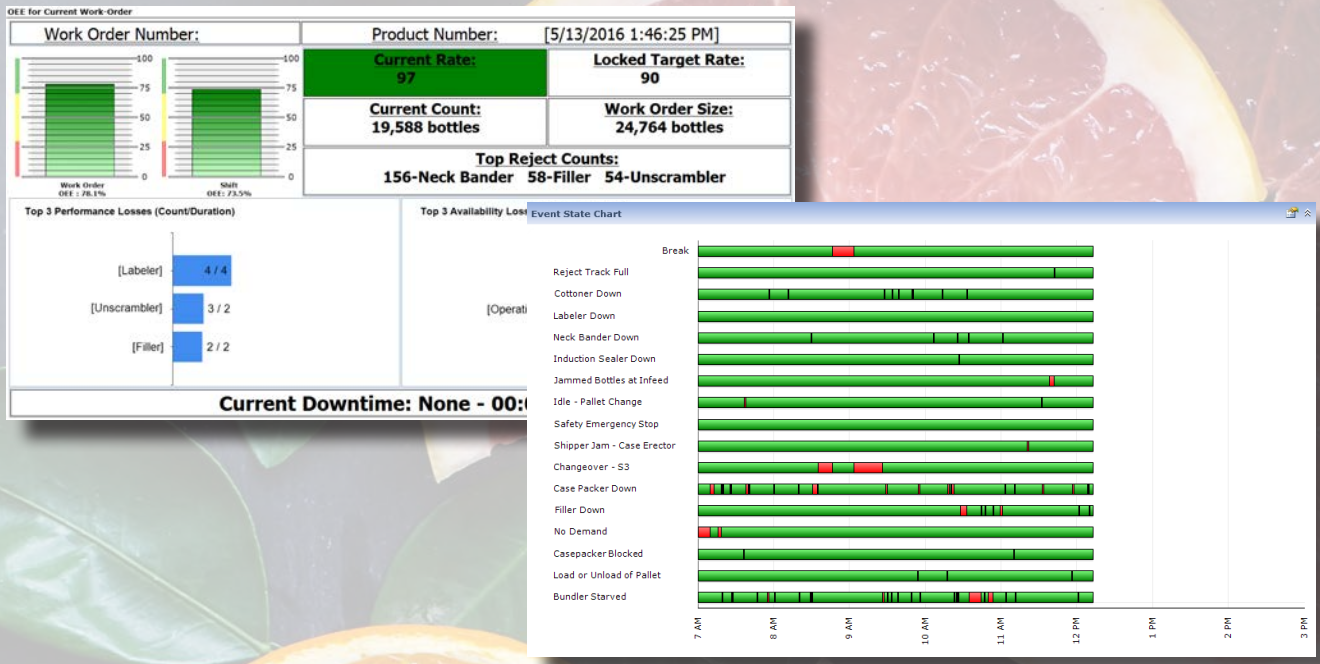


Figure 1 - Pharmavite TrakSYS™ Architecture

TrakSYS™ Architecture Summary

Pharmavite compared several manufacturing solutions and eventually selected TrakSYS™ because of its; flexible design, ability to scale and grow within the solution, breadth of functionality, dedicated support team, and low total cost of ownership. Pharmavite’s TrakSYS™ solution was connected with their ERP and expanded across many lines with PLC integration.



Informing and Empowering

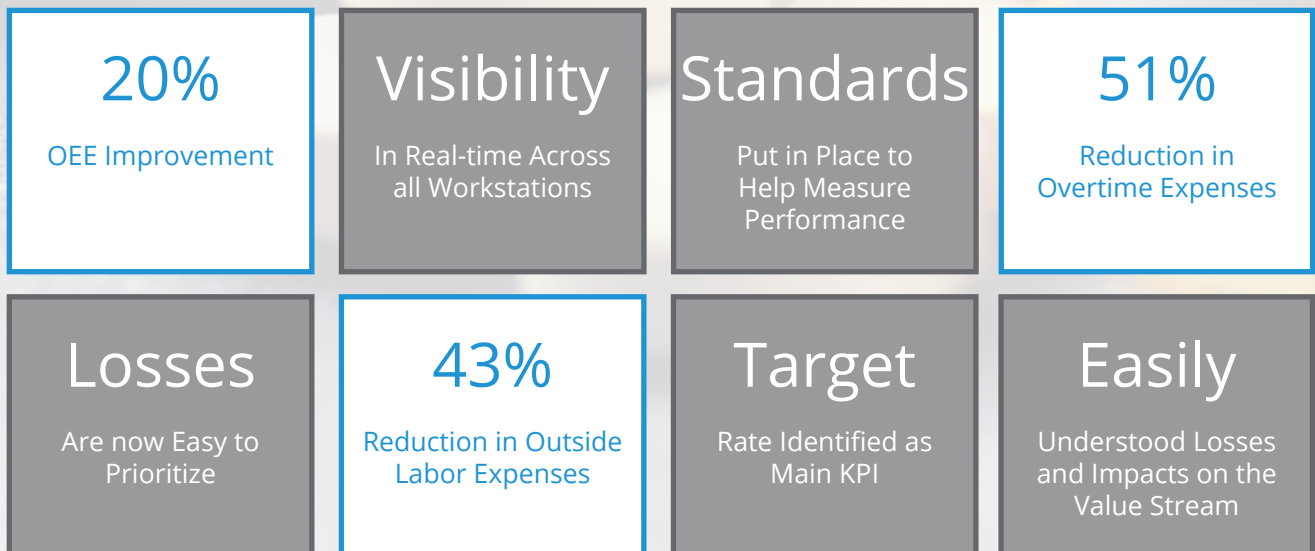
The screenshots above show examples of the Pharmavite web browser User Interfaces, used to engage the plant team in real-time continuous improvement.

Achieving the target rate during runtime is a top priority. The solution helps to focus on the throughput goal. Creating capacity from existing assets improves margin and return on invested capital while deferring new capital expenditures.

With end-to-end root cause analysis data readily available, Pharmavite was able to improve OEE by 20 percent.

TrakSYS™ Solutions Results

The following results and related benefits for Pharmavite were realized through collaborative engagement and the effective use of the TrakSYS™-based solution:



TrakSYS™ Solutions Results Expanded

- Improved operator visibility and engagement
- 20% increase in OEE
- 51% reduction in overtime expenses
- Greater capacity understanding
- 43% reduction in outside labor expense
- Ideal target rate identified and other standard KPIs
- 9% improvement in schedule adherence
- Accurate prioritization on losses

TrakSYS™ Solutions Summary

- Pharmavite launched a pilot on two lines at its top packaging site. The focus was on OEE, downtime, rejects, and other key performance metrics. 55" overhead display screens above each packaging line provided real-time visibility, and operator interaction was facilitated using entry screens at each workstation.
- Best practices were used to minimize implementation time and maximize cost savings, not only in the pilot, but in such a way as to later facilitate the rollout of the solution to other lines in packaging as well as manufacturing. In a phased approach, the solution was expanded to multiple sites using a standardized deployment methodology.
- The system improved operator engagement, and provided better understanding of financial standards, target rates, production losses and team performance.
- Challenges such as understanding real-time production rates were overcome in a short amount of time. This led to a more concerted effort to reduce speed losses and other contributors to reductions in OEE. Real-time production data and objective historical information have allowed Pharmavite to find extra capacity in existing assets, improve margin, and returns on invested capital.





About Parsec

Parsec is the developer of TrakSYS™, a proven operations management software application and solution platform designed to significantly improve manufacturing processes. Parsec is committed to providing best-in-class products and solutions to our worldwide community of clients to assist them in optimizing their manufacturing operations. There are thousands of TrakSYS™ licenses in use around the globe in a wide variety of Industries.

TrakSYS™ helps manufacturers to maximize asset utilization and efficiency, increase capacity with no new capital equipment, reduce production costs, decrease lead time, and improve profitability. For more information about Parsec and TrakSYS™, please visit the corporate website at www.parsec-corp.com.

Sources

1. Pharmavite LLC. (n.d.). Retrieved December 16, 2015, from http://www.pharmavite.com/OurBrands/OB_nm.asp
2. Pharmavite LLC. (n.d.). Retrieved December 16, 2015, from http://www.pharmavite.com/OurCompany/OC_main.asp

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