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Key success factors Investment in bottle hopper-The new hopper and conveyor would quite dramatically change the first few steps in line 1. The hopper would be mounted so that the bottom opening was directly in front of the bottle loaders. This orientation would allow the bottle loaders simply to grab the bottles from the shelf in front of them and set them on the filler line. Because the loaders would simply be repeatedly lifting two bottles at time and placing them on the line, with no more lifting, turning or loading boxes, this could easily load three or even four times as many bottles per minute.

Skid unloaders will save more time- The new method would allow skid unloaders more than enough time to keep up with the demand. Once the workers dump the empty bottles into the lower hopper; a conveyor would carry the bottle up into the top hopper where the bottle loaders could easily grab from the bottom of the pile.

Reduction of the need for direct contract labour-The new system will reduce the need for some of the direct labour on each line 1 shift leading to massive savings of up to \$ 9. 50 per hour.

Stand by mechanics-DII had set-up mechanics on hand at all times, thus skilled workers circulated the plant ensuring smooth running of equipments. When packaging equipment broke down, the line was shut down and a set-up mechanic and the line technician made the necessary repairs and adjustments to get the equipment operating again as soon as possible. With the new system this expense will no longer be incurred, which will lead to savings of up to \$23 of labour expense.

Work Cited

<https://www.iveycases.com/ProductView.aspx?id=26190&CM=true&HID=149>