HOW MANY SAFETY HAZARDS OR VIOLATIONS CAN YOU FIND?

[Put a number or "X" Beside Each Hazard or Violation]
Find The Hazard And / Or Violation

How Many Safety Hazards or Violations Can You Find?

1. Ladder blocking door
2. Man working beneath ladder
3. No GFCI on drill cord
4. No safety glasses using drill
5. Working off ladder & not holding onto ladder
6. Ladder doesn’t extend 3 ft past roof edge
7. Ladder not tied off, no one holding ladder
8. Ladder not a proper angle to building
9. Bucket on roof a fall hazard
10. Ditch not barricaded off, no warning signs, etc.
11. Labels on some drums hidden from view
12. Drums stacked too high
13. Drums leaking dangerous material, i.e. flammable
14. Man smoking near chemical spill of flammable material
15. Drums stored outside with no secondary containment
16. No tool pouch for man on ladder
17. No trench box in ditch to prevent cave in
18. Drill cord a trip hazard
19. Loose wood w/nails
20. Roofing nails on ground
21. Crane boom too close to power lines
22. Damaged drums
23. No spotter for bulldozer operator
24. Man riding load with crane
25. Ladder not firmy secured at base
26. Damaged ladder
“Integrating Continuous Improvement Into Safety Management Systems and Voluntary Protection Programs”
- **SAFETY:** Building Evacuation Exits

- **PURPOSE:** Integrating CI into Safety Mgmt Systems and VPP Processes

- **AGENDA:** HSE Mgt Plan, PDCA, RCCA, and Employee Involvement

- **CODE OF CONDUCT:**
  - Standard professional behavior
  - Cell phones off / on vibrate

- **EXPECTATIONS:**
  - Informal & interactive; one “take away” from session

- **ROLES/RESPONSIBILITIES:** Ask questions and give feedback
# Honeywell (Greer, SC) - Site Overview

## Application

<table>
<thead>
<tr>
<th>Application</th>
<th>AGT 1500 M1A1 Tank</th>
<th>ALF / 507 BAE146</th>
<th>HTF 7000</th>
<th>LT101/LTS101 BK117</th>
<th>T53 Lt Helo</th>
<th>T55 Chinook</th>
<th>HTS 900 Lt Helo</th>
<th>TFE 731 Lt Helo</th>
<th>APU 131-9 APU</th>
<th>T 800</th>
</tr>
</thead>
<tbody>
<tr>
<td>Turbine Blades</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
<td>X</td>
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<td>X</td>
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</tbody>
</table>

AGT 1500  
T55 - 714  
HTF 7000  
TFE - 731  
APU - 131
HSEMS & The Honeywell Operating System

Knowledge Sharing

Leadership Std Work

5S

Process Flow

Tier Meetings

Rapid Problem Solving

Waste Observation

Visual Management

HSEMS

Environment

Safety

Health

Industrial Hygiene

Product Stewardship

Loss Prevention

Leadership

Std Work

5S

Tier Meetings

Waste Observation

Visual Management

Product Stewardship

Loss Prevention

HSEMS

Environment

Safety

Health

Industrial Hygiene
Safety Management Plan

Question:
What Is a “Safety Management Plan”?

Safety Management Systems Begins With A Safety Mgmt Plan
## HSE Targets & Objectives

<table>
<thead>
<tr>
<th>HSE Targets &amp; Objectives</th>
<th>Goal</th>
<th>Jan</th>
<th>Feb</th>
<th>Mar</th>
</tr>
</thead>
<tbody>
<tr>
<td>TCIR</td>
<td>≤ 1.2</td>
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<tr>
<td>LWDCIR</td>
<td>≤ 0.50</td>
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<tr>
<td>Corrective Action Closure</td>
<td>95%</td>
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<tr>
<td>Energy Reduction</td>
<td>3.5%</td>
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<tr>
<td>Monthly Safety Training</td>
<td>95%</td>
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<tr>
<td>Environmental Excursions</td>
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<tr>
<td>Behavior Observation Index Score</td>
<td>95%</td>
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<tr>
<td>Environmental Recycling</td>
<td>1 Project</td>
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<tr>
<td>Hazardous Waste Reduction</td>
<td>10%</td>
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<tr>
<td>Safety CI’s / Kaizens</td>
<td>2 / Month</td>
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<tr>
<td>Leadership Safety Audits</td>
<td>8 / Month</td>
<td></td>
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</tr>
</tbody>
</table>

**Safety Management Plan**
### 2013 HSE Management Plan & Compliance Calendar

<table>
<thead>
<tr>
<th>HSE Meetings</th>
<th>Goal</th>
<th>Jan</th>
<th>Feb</th>
<th>Mar</th>
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</thead>
<tbody>
<tr>
<td>Behavior Observation Steering Com</td>
<td>Quarterly</td>
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<tr>
<td>Emergency Procedures Committee</td>
<td>Quarterly</td>
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<tr>
<td>Ergonomics Committee</td>
<td>Monthly</td>
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<tr>
<td>Star Points Safety Committee</td>
<td>Monthly</td>
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<tr>
<td>Hazardous Waste Reduction Team</td>
<td>Monthly</td>
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<tr>
<td>Confined Space Rescue Team</td>
<td>Quarterly</td>
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<tr>
<td>Machine Risk Assessment Team</td>
<td>Monthly</td>
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<tr>
<td>Noise Reduction Team</td>
<td>Monthly</td>
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<tr>
<td>HSEMS Steering Committee</td>
<td>Monthly</td>
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<tr>
<td>First Aid Responder Team</td>
<td>Monthly</td>
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</table>
## 2013 HSE Management Plan & Compliance Calendar

<table>
<thead>
<tr>
<th>HSE Program Reviews</th>
<th>Goal</th>
<th>Jan</th>
<th>Feb</th>
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<tbody>
<tr>
<td>Confined Space Program Review</td>
<td>3/30/2013</td>
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<tr>
<td>Contractor Safety Program Review</td>
<td>3/30/2013</td>
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<td>Cranes and Hoist Program Review</td>
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<td>Hazard Communication Program Review</td>
<td>4/30/2013</td>
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<tr>
<td>Hearing Cons Program Review</td>
<td>5/30/2013</td>
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<td>Hot Work Program Review</td>
<td>5/30/2013</td>
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<td>Incident Investigation Program Review</td>
<td>6/30/2013</td>
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<tr>
<td>Line Breaking Program Review</td>
<td>6/30/2013</td>
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<tr>
<td>Lockout / Tagout Program Review</td>
<td>7/30/2013</td>
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<td>PPE Program Review</td>
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### Safety Management Plan
## 2013 HSE Management Plan & Compliance Calendar

<table>
<thead>
<tr>
<th>HSE Audits, Drills, Inspections</th>
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<th>Jan</th>
<th>Feb</th>
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<tr>
<td>5S / Housekeeping Audits</td>
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<td>Combustion Safeguard Audits</td>
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<td>Confined Space Field Observation Audit</td>
<td>Quarterly</td>
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<td>Confined Space Rescue Drill</td>
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<tr>
<td>Fire Drills (Each Shift)</td>
<td>Annual</td>
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<tr>
<td>Fire Systems Inspections</td>
<td>Annual</td>
<td></td>
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<tr>
<td>Hoist &amp; Crane Inspections</td>
<td>Monthly</td>
<td></td>
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<tr>
<td>Ladder Inspections</td>
<td>Semi-annual</td>
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<td>Live Electrical Safety Audit</td>
<td>Quarterly</td>
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<td>Portable Fire Extinguisher Inspections</td>
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<td>Portable Power &amp; Hand Tool Inspections</td>
<td>Semi-annual</td>
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<td>Tornado Drills (Each Shift)</td>
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</table>
# HSEMS MGMT PLAN – TRAINING

## 2013 HSE Management Plan & Compliance Calendar

<table>
<thead>
<tr>
<th>Training Category</th>
<th>Goal</th>
<th>Jan</th>
<th>Feb</th>
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<tr>
<td>Bloodborne Pathogens</td>
<td>Annual</td>
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<td>Confined Space Entry</td>
<td>Annual</td>
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<tr>
<td>Electrical Safety / Arc Flash</td>
<td>Annual</td>
<td></td>
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<tr>
<td>Emergency Procedures</td>
<td>Annual</td>
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<tr>
<td>Ergonomics</td>
<td>Every 3 Yrs</td>
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<tr>
<td>Fall Protection</td>
<td>Every 2 Yrs</td>
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<td>Hazard Communications</td>
<td>Annual</td>
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<tr>
<td>Hearing Conservation</td>
<td>Annual</td>
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<tr>
<td>Line Breaking</td>
<td>Annual</td>
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<tr>
<td>Incident Investigation</td>
<td>Every 3 Yrs</td>
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<tr>
<td>Confined Space Entry</td>
<td>Annual</td>
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<td>Electrical Safety / Arc Flash</td>
<td>Annual</td>
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</table>
# Safety Management Plan

## 2013 HSE Management Plan & Compliance Calendar

<table>
<thead>
<tr>
<th>HSE Reports</th>
<th>Goal</th>
<th>Jan</th>
<th>Feb</th>
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<tr>
<td>Air Permit Report</td>
<td>Quarterly</td>
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<td>Discharge Monitoring Report (DMR)</td>
<td>Monthly</td>
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<tr>
<td>EPCRA Tier II Report</td>
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<tr>
<td>Hazardous Waste Quarterly Report</td>
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<td>OSHA 300A Log</td>
<td>Annual (Feb 1)</td>
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<td>VPP Annual Self Assessment Report</td>
<td>Annual (Feb. 15)</td>
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<td>Waste Minimization Report</td>
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<td>Process Waste Report (Non-Haz)</td>
<td>Quarterly</td>
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<tr>
<td>HSE Metrics in Database</td>
<td>Monthly</td>
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**Honeywell Confidential. Use or disclosure of information on this page is subject to the restrictions on the title page.**
<table>
<thead>
<tr>
<th>HSE Permits</th>
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<tr>
<td>Industrial Wastewater Discharge Permit</td>
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<td>DOT Hazardous Waste Registration</td>
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<td>VPPPA Annual Membership</td>
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<td>Infectious Waste Generation Registration</td>
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<td>Air Permit Fee</td>
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<td>Radiological Permit Fee</td>
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<td>Storm Water Permit Fee</td>
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<td>EPCRA Hazardous Chemicals</td>
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</table>
# HSE Monthly Calendar

## FEBRUARY 2013

### Notes:

**Safety Training:**
- [ ] Tier II (Due March 1)
- [ ] SCBA Instr.
- [ ] Spill Response Kit Instr.
- [ ] Confined Space Field Audit (JM)
- [ ] Fatigability Test (FAT Call - Medical (KW))
- [ ] Fire Equipment
- [ ] Hearing Testing / Extinguisher
- [ ] Contractor Safety Mtg

### Significant Upcoming Events:

- [ ] Part 80/90A Log (BM/KJ)
- [ ] SAT - Profile (MG)
- [ ] AED Inspection (KW)
- [ ] Portable Worksite Entry (BMJ/K/GM)
- [ ] NPP Benchmarking (BM)
- [ ] MOC Review (MG)
- [ ] Fire Extinguisher - O
- [ ] A/Met Plan Mtg (ALL)
- [ ] Contractor Safety Mtg
- [ ] Fatigability Test (FAT Call - Medical (KW))
- [ ] Fire Extinguisher - O
- [ ] A/Met Plan Mtg (ALL)
- [ ] Contractor Safety Mtg

### Events:

- [ ] Tier II (Due March 1)
- [ ] SCBA Instr.
- [ ] Spill Response Kit Instr.
- [ ] Confined Space Field Audit (JM)
- [ ] Fatigability Test (FAT Call - Medical (KW))
- [ ] Fire Equipment
- [ ] Hearing Testing / Extinguisher
Questions
P.D.C.A.
Plan, Do, Check, Act
PDCA Process (Plan, Do, Check, Act)

1.0  PLAN

1.1  Identify Priorities, Areas for Improvement:

- Accidents
- Near Misses
- Hazardous Waste Generation
- Environmental Excursions
- At Risk Behaviors
1.0 PLAN

1.2 Gather Data:

- Accident Reports
- Near Misses Reports
- Hazardous Waste Data, Manifests
- Behavior Observation Audits
PDCA Process (Plan, Do, Check, Act)

1.0 PLAN

1.3 Graph Data:

- Simple Trend Chart
- Pareto Charts
1.0 PLAN (Plan, Do, Check, Act)

1.1 Priority or Area of Improvement – Accidents

1.2 Gather Data – Accident Reports

1.3 Graph The Data – Trend Chart
1.3 Graph Data –

- PARETO

INCIDENTS BY "TYPE"
Rolling 12 Months

- Repetitive Motion: 10
- Struck Against: 5
- Laceration: 3
- Slip, Trip, Fall: 3
- Lifting: 2
PDCA Process (Plan, Do, Check, Act)

1.0 PLAN

1.4 Graph Data –

- TREND

Repetitive Motion Injuries
(12 Months Rolling)
PDCA Process (Plan, Do, Check, Act)

1.0 PLAN

1.4 Analyze Data –

- PARETO

Repetitive Motion Injuries
(12 Months Rolling)

Repetitive Motion By Job Task
(12 Months Rolling)
PDCA Process (Plan, Do, Check, Act)

2.0 DO

2.1 Analyze Data and Create RAIL

- Problem (5-Why, Fishbone, Is / Is Not)
- Action
- Who
- When

2.2 Implement Actions

<table>
<thead>
<tr>
<th>Problem</th>
<th>Action</th>
<th>Who</th>
<th>When</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vibration of pencil grinders</td>
<td>Trial new style grinder</td>
<td>John Doe</td>
<td>3/30/2013</td>
</tr>
</tbody>
</table>
### PDCA Process (Plan, Do, Check, Act)

#### 3.0 CHECK

#### 3.1 Monitor Results

#### 3.2 Did The Action Improve Results

- **If “No”, Re-analyze the “Do”**
- **If “Yes”, Move to “Act”**

<table>
<thead>
<tr>
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</tr>
</tbody>
</table>
PDCA Process (Plan, Do, Check, Act)

4.0 ACT

4.1 Revise Procedures, JSA’s, etc.

4.2 Employee Training

4.3 Management of Change

4.4 Monitor Results

Repetitive Motion Injuries
(12 Months Rolling)
PDCA Process (Plan, Do, Check, Act)

**Incidents**
Rolling 12 Months

**Repetitive Motion Injuries**
(12 Months Rolling)

**Repetitive Motion Injuries**

**INCIDENTS BY "TYPE"**
Rolling 12 Months

**Repetitive Motion By Job Task**
(12 Months Rolling)

<table>
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</tr>
</tbody>
</table>
Questions
ROOT CAUSE CORRECTIVE ACTION (RCCA)

RCCA – Putting Corrective Actions In Place To Prevent Recurrence
Getting to The Root Cause

• Symptoms are what we see.

• Remove only the symptoms, the problem can still re-occur

• To make sure problem does not come back, get to the root cause(s)
RCCA – Root Cause Corrective Action

- Use The 5-Why Process To Get To Root Cause
- Ask The Question “Why?” As Many As 5 Times
5 Why Analysis

Let’s Go Thru an Example
Incident – ANKLE SPRAIN

Employee Sprained Ankle

Slipped On Oil On Floor

Oil Leaking From Forklift

Forklift Operator Did Not Know Lift Was Leaking

Operator Didn’t Inspect Forklift At Beginning Of Shift

Operator Had Not Been Trained To Complete Inspection

To Check Logic Of Your Root Cause???

Reverse The Order Using The Word ‘THEREFORE’
Questions
Integrating Continuous Improvement in Voluntary Protection Programs (VPP)
A, B, C’s of Safety

Think About the A, B, C’s of Safety:

A – Attitude (Positive)

B – Behavior (Safe)

C – Commitment (To Safety Processes)
Voluntary Protection Program (VPP)

Question: “Should Safety Be A Number 1 Priority?”

Answer Is “No” - Safety Should Never Be A #1 Priority

Why?

Priorities Change By The Minute

Safety Must Be A “Value That’s Never Compromised”
Voluntary Protection Program (VPP)

- VPP Helps A Site Promote This Culture Change

- Three Keys To Improving Safety At Any Plant Whether A VPP or Non-VPP Site?

- Your Thoughts?

1. Effective Safety Management Systems
2. Leadership Commitment
3. Employee Involvement
Continuous Improvement Suggestions (CI’s)

Integrating Continuous Improvement Into VPP
Continuous Improvement Suggestions (CI’s)

***Once approved by the Supervisor, WFS of the initiating shift of the CI should pass the CI to the other WFS. The other WFS should review the CI with the operator of the station on their shift within 2 business days and initial if approved. If operator or WFS declines the idea, please note reason on back of CI form and note any counter suggestions. As long as 2 out of the 3 shifts (or 4 shifts) agree then the CI is approved to be implemented. If feedback is not received within the two business days, then it is assumed that it is approved.

Reason for declining the suggestion:

Counter Suggestion:

List Team Members that contributed to the CI:

Rev. O Add instructions to Initial in Approved or Declined box to indicate who a person could contact if necessary.

Rev. N Review Block is designed to track if and when the CI has been assigned to a person(s) to process and/or reviewed during Tier meeting(s) (knowledge sharing). Doing = when CI has been approved and is in process. Done = when CI has been approved and completed.

<table>
<thead>
<tr>
<th>Assigned to:</th>
<th>Date:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Reviews / Shift</td>
<td>3rd</td>
</tr>
<tr>
<td>Doing</td>
<td></td>
</tr>
<tr>
<td>Done</td>
<td></td>
</tr>
</tbody>
</table>
Continuous Improvement Suggestions (CI’s)

<table>
<thead>
<tr>
<th>‘Before’ Description</th>
<th>‘To Be’ Description</th>
<th>Status</th>
</tr>
</thead>
<tbody>
<tr>
<td>Have to use box wrench and rubber hammer to tighten nut on machine fixture.</td>
<td>Replace hammer and large wrench with battery powered impact wrench.</td>
<td></td>
</tr>
</tbody>
</table>

- Forms of Waste: Defects (Scrap / Rework); Over-production, Transportation, Waiting, Excessive Inventory, Motion, Over-processing

- Safety / HSE / Energy Savings, Quality, Delivery, Inventory, Cost, 5S, HOS: (Circle all that apply and explain impact / effect)

(Provide as many details of saving as you can: e.g. # pcs of scrap, # hours of rework, # more pcs produced, etc.)
Integrating Continuous Improvement In VPP Through Visual Management

We apologize for not having an image to display.

Please check back soon!
VPP & Visual Management
# VPP & Visual Management

## Tier 4 HSE Metrics - 2013

**Owner:** Bill Menees, Updated Daily

### February

<table>
<thead>
<tr>
<th>Day</th>
<th>TCIR Goal ≤ 1.21</th>
<th>HSEPI Goal ≥ 1.75</th>
</tr>
</thead>
<tbody>
<tr>
<td>Monday</td>
<td>0</td>
<td>2.0</td>
</tr>
<tr>
<td>Tuesday</td>
<td>0</td>
<td>8</td>
</tr>
<tr>
<td>Wednesday</td>
<td>32%</td>
<td>86</td>
</tr>
<tr>
<td>Thursday</td>
<td>1</td>
<td>27</td>
</tr>
<tr>
<td>Friday</td>
<td>78</td>
<td>98.5</td>
</tr>
</tbody>
</table>

**Critical HSE Calendar Events:**

- Go Incidents
- First Aid Responder
- OSHA Recordable Incident
- Environmental Exposure
- Near Miss 30 Days

**Daily HSE Foto Lesson**

**HSE Alert**
# VPP & Visual Management

![OEM INCIDENT TRACKER](image)

**Greer Tier 4 - OEM Safety: Injury Chart 2013**  
Owner: Bill Menees, Updated: As Incident Occurs

<table>
<thead>
<tr>
<th>EMPLOYEE (EE, ME, or CE)</th>
<th>INCIDENT NO</th>
<th>DATE OF INJURY</th>
<th>DATE REPORTER</th>
<th>DEPT / CONTRACT CO.</th>
<th>SHFT</th>
<th>INJURY DESCRIPTION</th>
<th>INJURY TYPE</th>
<th>INCIDENT REPORT</th>
<th>NPS</th>
<th>EVENT TRACKING NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>EE</td>
<td>13-01</td>
<td>1-14-2013</td>
<td>1-15-2013</td>
<td>Blades</td>
<td>1st</td>
<td>Fall from steps, browser to window</td>
<td>1st</td>
<td>1-15-13 1-16-13 1-17-13</td>
<td>97251</td>
<td></td>
</tr>
<tr>
<td>EE</td>
<td>13-02</td>
<td>1-16-2013</td>
<td>1-16-2013</td>
<td>Spec Pne</td>
<td>1st</td>
<td>Contact with object, contusion to leg</td>
<td>1st</td>
<td>1-16-13 1-18-13 1-19-13</td>
<td>97251</td>
<td></td>
</tr>
<tr>
<td>EE</td>
<td>13-03</td>
<td>1-17-2013</td>
<td>1-17-2013</td>
<td>Spec Pne</td>
<td>1st</td>
<td>Debris in eye</td>
<td>1st</td>
<td>1-19-13 1-21-13 1-22-13</td>
<td>317518</td>
<td></td>
</tr>
</tbody>
</table>

**ACCIDENT PROFILE**

*Right*

*Left*
# Daily HSE FOTO Lessons

**FOTO:**

**FOcused TOpic**

<table>
<thead>
<tr>
<th>Date</th>
<th>HSE FOTO (Focused Topic) Lesson</th>
<th>Picture(s)</th>
</tr>
</thead>
</table>
| **Mon., Jan 21** | **5S – A FUNDAMENTAL HOS BUILDING BLOCK:**  
1. **Sort** – Work area is sorted and un-needed items removed.  
2. **Store** – Needed items area clearly marked and stored; storage areas are clearly marked & quantities controlled.  
3. **Shine** – Work area & equipment are cleaned per a defined schedule; 5S elements (tape, labels, shadow boards, visuals, etc.) are maintained per visible schedule.  
4. **Standardize** – 5S is managed visually; standards are in place for tooling, visuals, material replenishment, etc.  
5. **Sustain** – 5S checklists, audits, RAILS are part of the standardized work.  
  - **Take Away/Action Item:** By following the 5S training and striving to continuously improve, our work area will become more productive and efficient, and a safer place to work. | ![5S](image1) |
| **Tues., Jan 22** | **CUTTING PLASTIC CABLE WRAPS WITH CORRECT TOOL:**  
- Recently the OEM site had a laceration injury requiring 12 stitches when a contractor used a personal pocket knife to cut a plastic cable wrap.  
- Knives of any sort are not the correct tool to cut plastic cable wraps and **should never be used**. Knives include pocket knives, utility knives, X-acto knives, etc.  
- The correct tool for cutting plastic cable wraps include wire nippers or wire cutters.  
  - **Take Away/Action Item:** Always remember when performing a task, to use the **CORRECT** tool for that task. It's also important to keep your eyes on the line of sight of your work. | ![Correct Tool](image2) |