

Lean Champions – 2025 Annual Projects Summary

Continuous Improvement through 5S & Kaizen



Annual ceremony – January 2026, Pravets

www.lean.bg

Name of the plant

Team



Products: Aluminium rolled and extruded products.



Plant



Total area: 370 000 m²

Total number of employees: 1322

Scope of activities:

- Aluminium melting
- Casting
- Extrusion
- Rolling
- CNC Machining
- Anodizing
- Powder Coating

Customers:



Annual performance – KPI table



ALCOMET AD

Quarters 2025	5S				Kaizen projects					Voting score		Quarterly results 2025
	First audit result	Second audit result	Target	5S score %	KPI	Before	After	Target	Score %	Avg. score	Avg. score %	
Q1	22 %	43 %	45 %	96 %	Yield	58 %	65 %	65 %	100 %	4.1	61.4 %	85.7 %
Q2	43 %	88 %	90 %	98 %	Introduction of AM in 3 zones	0	3	3	100 %	1.83	61 %	86 %
Q3	43 %	88 %	80 %	100 %	Introduction of AM in 5 zones	3	8	5	100 %	1.71	57 %	85.7 %
Q4	45 %	79 %	80 %	99 %	Introduction of AM in 3 zones	8	11	3	100 %	---	---	---

Color indicator: above 90% | 80–90% | below 80%

Q1 Kaizen Project – Problem, Scope and Targets



Problem

Defining the problem:

Hard alloys of technological scrap generated during the production of profiles made from hard alloy (6082) and low production efficiency.



Project Scope

Define the scope of the problem :

The project involves our company's largest production press. The plan is to increase efficiency by optimizing the final dimensions of the profiles.



Target and result

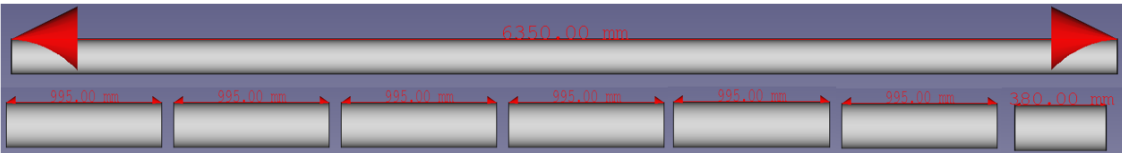
KPIs	Measurement unit	Baseline	Target	Result	Savings
Increasing yield.	%	58,0	65,80	65,45	Monthly: 36.375 € Yearly: 426.000 €
Period		2024	Jan-25	Mar-25	

Q1 Kaizen Project – Before & After

Before

Define the problem:

380mm scrap is being discarded because billet lengths are not optimized.



$995\text{mm} \times 6 = 5970\text{mm}$

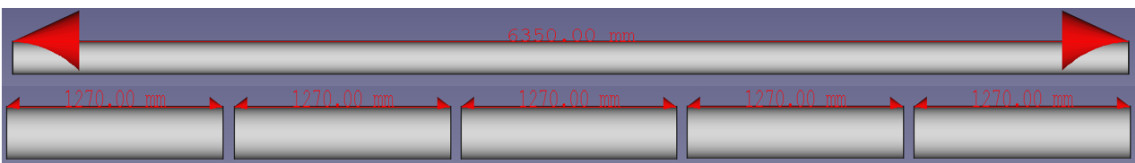
$6350\text{mm} - 5970\text{mm} = 380\text{mm (Scrap)}$



After

Define the improvement:

Billet lengths have been optimized and no scrap is being discarded.



$1270\text{mm} \times 5 = 6350\text{mm}$

$6350\text{mm} - 6350\text{mm} = 0\text{mm (Скрап)}$



Q2 Kaizen Project – Problem, Scope and Targets



Problem

Defining the problem:

During profile production, dents, scratches, etc. occur on the profiles as a result of the press equipment not being properly maintained. These profiles are scrapped due to manipulation.



Project Scope

Define the scope of the problem :

Reduce scrap caused by potential manipulation errors by performing regular maintenance on the printing production line.



Target and result

KPIs	Measurement unit	Baseline	Target	Result	Savings
Introduction of AM in 3 zones	Zone	0	3	3	7688 Euro
Reduction of scrap resulting from manipulation defects.	%	0,46	0,1	0,33	
Period		Q1	Mar-25	Q2	

Before

Define the problem:

The fan is dirty and inoperable.



After

Define the improvement:

The fan has been cleaned and is in working order.



Q2 Kaizen Project – Before & After

Before

Define the problem:

The die equipment is in a dangerous condition on the floor.



After

Define the improvement:

The mold equipment is on the stand and in good condition.



Q3 Kaizen Project – Problem, Scope and Targets



Problem

Defining the problem:

During profile production, dents, scratches, etc. occur on the profiles as a result of the press equipment not being properly maintained. These profiles are scrapped due to manipulation.



Project Scope

Define the scope of the problem :

Reduce scrap caused by potential manipulation errors by performing regular maintenance on the press production line.



Target and result

KPIs	Measurement unit	Baseline	Target	Result	Savings
Introduction of AM in 5 zones	Zone	3	5	8	314 Euro
Reduction of scrap resulting from manipulation defects.	%	0,33	0,1	0,32	
Period		Q2	Mar-25	Q3	

Q3 Kaizen Project – Before & After

Before

Define the problem:

Poor basic condition of the machine



After

Define the improvement:

The machine was cleaned and oil leaks were fixed.



Q4 Kaizen Project – Problem, Scope and Targets



Problem

Defining the problem:

During profile production, dents, scratches, etc. occur on the profiles as a result of the press equipment not being properly maintained. These profiles are scrapped due to manipulation.



Project Scope

Define the scope of the problem :

Reduce scrap caused by potential manipulation errors by performing regular maintenance on the press production line.



Target and result

KPIs	Measurement unit	Baseline	Target	Result	Savings
Introduction of AM in 3 zones	Zone	8	3	11	2501 Euro
Reduction of scrap resulting from manipulation defects.	%	0,32	0,1	0,25	
Period		Q3	Mar-25	Q4	

Q4 Kaizen Project – Before & After

Before

Define the problem: The area is dirty.



After

Define the improvement: The area has been cleared.



What we have learned from our kaizen projects

- By establishing a routine for daily 5S audits, we have ensured the sustainability of workplace organization and standards.
- Through the effective use of visual standards, a shared understanding of quality and discipline has been developed across the team.
- We have recognized that strong interdepartmental communication plays a critical role in improving collaboration and overall process efficiency.
- We observed that a clean and well-organized work environment has a positive impact on employee motivation, focus, and performance.

Summary of the main results and benefits of the year.

Tangible (quantitative):

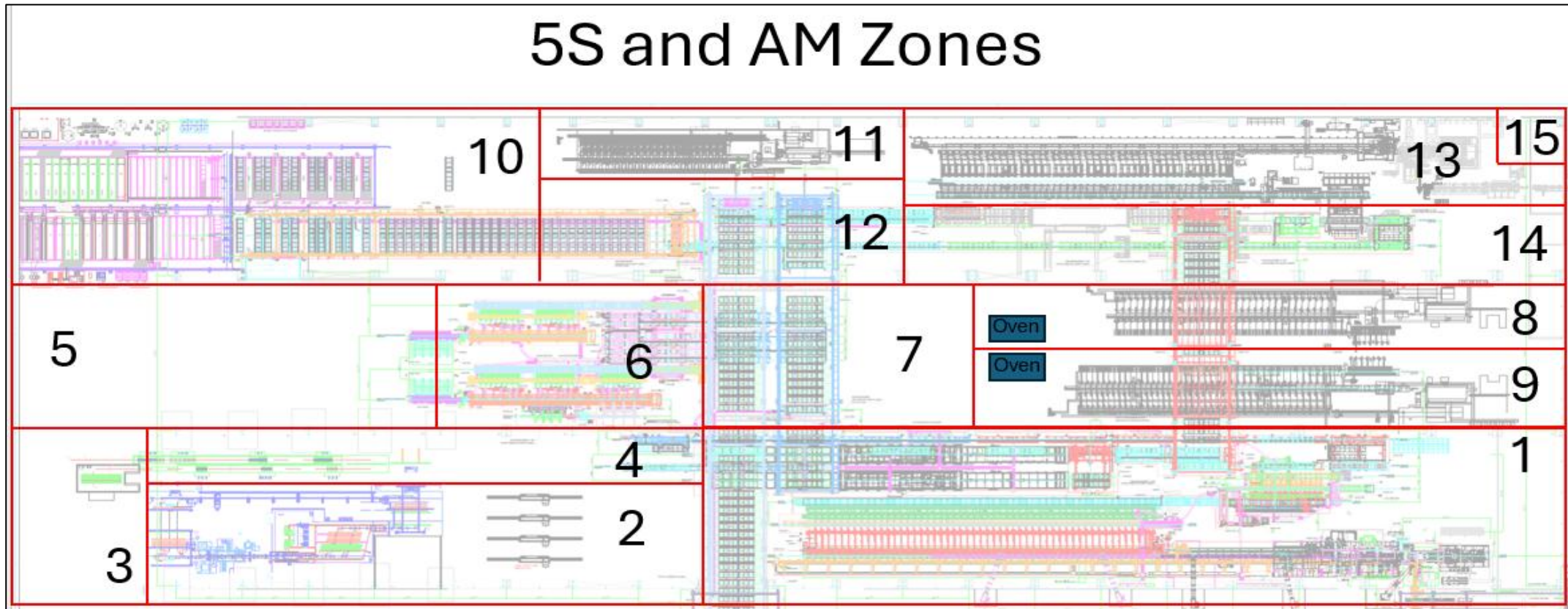
- 5S scores improved by +100%
- Monthly Saved 46.875 € and Yearly 436.500 € saved in total efficiency gains

Intangible (qualitative):

- Improved workplace organization
- Stronger problem-solving culture

Our long-term vision and commitment

- Expand autonomous maintenance to all Extrusion Shop
- Standardize 5S audits across departments
- Continue Kaizen training for all operators



Thank You



**We thank our management, colleagues,
and Lean Champions community for their
continued support and collaboration.**

