



U.S. Mint's Lean Transformation Program for Coin Manufacturing

CH2M HILL is providing a continuous series of task-order-based assignments to help the U.S. Mint achieve Lean transformation of coin manufacturing operations at the four U.S. Mints (Philadelphia, Denver, San Francisco, and West Point). This is a critical component of the overall U.S. Mint Total Productive Manufacturing Strategy and Integrated Supply Chain Management programs.

Lean Manufacturing

Client
U.S. Mint

Location
Philadelphia, Denver, San Francisco, and West Point

Project Completion
Ongoing

CH2M HILL
Program Management
Lean Manufacturing Analyses
Process Modeling

Project Highlights

Using our unique interactive workshop process, conducted LM training and Lean Supply Chain Logistics training for hourly work force at all four U.S. Mints, Headquarters staff in Washington, D.C., key suppliers, and representatives of the Federal Reserve Bank.

Accomplished lean process design by applying Lean Manufacturing tools and techniques to the overall coin manufacturing operations, as well as detailed cellular designs for individual processes and work centers.

Our services include Lean manufacturing process cellular design, facilities and equipment assessments, design for building modifications, process modeling, operations cost estimates, manpower and organizational planning, capital cost estimating, master planning, financial modeling, and the development of specifications for manufacturing equipment and automated material handling systems. Using our unique interactive workshop process, we also conducted Lean manufacturing and Lean supply chain logistics training for the hourly work force at all four U.S. Mints; the U.S. Mint

Headquarters in Washington, D.C.; key suppliers to the U.S. Mint; and representatives of the U.S. Mint's primary customer for circulating coins, the Federal Reserve Bank. Lean process design was accomplished by applying Lean manufacturing tools and techniques to the overall coin manufacturing operations, as well as detailed cellular designs for individual processes and work centers such as Die Production and Coin Stamping operations. CH2M HILL is continuing to supply Lean manufacturing, facilities assessment and engineering design services on a negotiated Task Order basis as the U.S. Mint continues its evolution to Total Productive Manufacturing.

CH2M HILL's planning, scheduling, and coordination of a phased implementation approach is allowing this transition to take place without disruption to 7-day-per-week, 3-shift-per-day production at the four facilities. This rigorous production schedule is necessary to meet the Federal Reserve Bank's requirement for 20 billion circulating coins per year. This project has resulted in reductions in waste, energy, and manpower, while providing process efficiency improvements.

The United States Mint has a strategic goal of becoming a world-class manufacturing organization through the implementation of Total Productive Manufacturing (TPM) concepts. With expert guidance and assistance from the CH2M HILL staff, I am very satisfied with the progress we have made to date.

Bradford E. Cooper
Associate Director of
Manufacturing
U.S. Mint