

AS 9100 QUALITY



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Special points of interest:

- Personnel News
- Shakespeare's Sister has hit single

THE SHAKESPEAREAN ISSUE

“The quality of CPE is not only trained,
It droppeth as the gentle man from London
From a place near Hampstead Heath:

It is twice blest;
It blesseth him that giveth and him that taketh.”



And now we goteth our AS 9100 approval, we're going out to get totally piss-ed.

However, achievement of the standard is not the end but merely the start of a process of continuous improvement. The analysis of problems down to root cause and all the possible resulting implications, is still an area which requires improvement. As the bard said “ The fault, dear Brutus, is not in our stars, But in ourselves, that we are underlings”. It's not fate that drives our decisions but our conditioning. How often do we hear “we know about that problem” or “if you think this ones bad you should see this other problem”. We are often conditioned to live with problems rather than fix them or even report them. Living with a problem has it's attractions, or we wouldn't do it. You don't have to bother anyone else. You don't have to explain the problem. You don't have to wait for a solution. On the other hand you are living with a ticking device. The first time you forget the manual work-around that gets past the problem.....Bang!



When we do identify a problem we still have trouble getting down to root cause, the item that when fixed will prevent any reoccurrence of the problem. In the unlikely event that we get this far we need to take the final step and examine the implications of the problem. Does it have any impact on other similar components; or fixtures; or machine tools, or employee of the company? Do we follow up and implement the fix company wide and not just the item where the fault was found?

To make it easier to report and fix problems we are going to incorporate problem reporting and opportunities for improvement into our production control system. It will become possible to log a problem at any clocking on station when logging on or off a works order, or if the problem is not part related at any terminal.

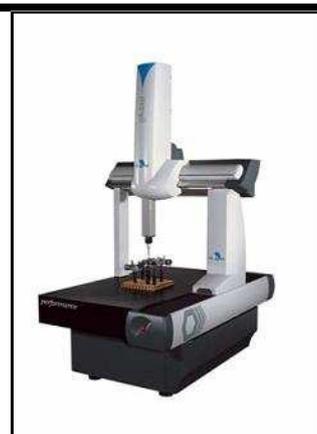
we goteth our AS9100 approval

Apart from receiving our AS9100 rev B certification the other good news at this time is the continuing growth in sales. After some very difficult years following 9/11 the past year has seen 15% growth in sales. On the down side a large element of our growth is artificial, down to the increased purchase of material as is evident by looking around the factory, which consumes cash & does not help our bottom line. It is thus vital that we rapidly turn this material around as quickly as possible, whilst maintaining quality.

NEW GLOBAL PERFORMANCE 12.22.10 CMM ALMOST INSTALLED

At the beginning of June our new CMM was delivered. Unfortunately the transport personnel should have taken more care and the resulting damage has caused delays. An investigation into the whole affair resulted in the unexpected realisation that we required still more CMM capacity. We have placed an

order for another 12.22.10 which should be delivered within a month. The new CMM will be located in the temperature controlled room currently occupied by our Ferranti CMM which will be broken down and remade into a granite factory sign placed at the entrance to the factory.



NEW FORKLIFT TRUCK CLEANS UP

The addition of a new forklift truck to service the CNC turning section has helped to improve housekeeping as well as speeding up movements.



The new truck incorporates many improvements but the most important is probably the design changes that allow for a lower centre of gravity.

As in the high speed CNC horizontal milling section this vehicle is kept solely in the factory to prevent it picking up dirt and cuttings from outside, thus keeping the factory it services cleaner. This is our fifth Toyota electric forklift, & all have proven robust, effective and quiet. Can't ask for more.

4 CLASS D FIRE EXTINGUISHERS INSTALLED

Employees who machine titanium and aluminium components should be aware that they present a class D fire risk and as such in the unlikely event that such a fire broke out the most effective way to fight these fires is with a Specialist Powder Fire Extinguisher. One of these units is located in both of the CNC milling sections and both of the CNC turning sections. The units are equipped with very low velocity applicators and are effective against all metal fires.



PERSONNEL NEWS

Congratulations to Carolann on the birth of her baby boy "Tyler" who weighed in at 6lb 13oz. Mother and son doing well.

Congratulations to Paula McInarlin who was promoted to our front office administrative team in May. Formerly, Paula worked in our canteen,



where her hard work and good nature shone through. After testing it be-

came obvious that Paula had hidden talents which we should be exploiting. After nearly 2 months it's obvious we made the right decision.

Welcome to Michael McLean, who replaces Paula.

Welcome to Stuart Frame, who started in CNC Lathes

Welcome to Damien McLaughlin who joined our IT department as a technician on the 05/06/06.....a day early.



Welcome to Adam Clark, our newest project engineer.



Welcome back to Gary Cuthbert who left for the bright lights, sex, drugs and rock & roll. But enough of Castle.



Sex, drugs and rock & roll.

Bill Shakespeare

"Tomorrow, and tomorrow, and tomorrow, creeps in this petty pace from day to day, to the last syllable of recorded time, and all our yesterdays have lighted fools, the way to dusty death. Out, out, brief candle! Life's but a walking shadow, a poor player, that struts and frets his hour upon the stage, and then is heard no more: it is a tale told by an idiot, full of sound and fury, signifying nothing."

Short version
"Life sucks!"

2D OR NOT 2D THAT IS THE QUESTION

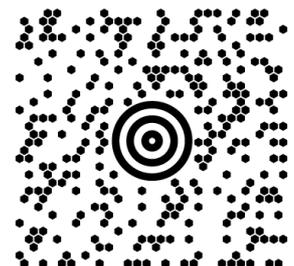
WHETHER IT IS NOBLER IN THE MIND TO SUFFER THE SLINGS AND ARROWS OF OUTRAGEOUS FORTUNE OR TO TAKE ARMS AGAINST A SEA OF TROUBLES, AND BY OPPOSING END THEM...

Eighteen months ago we examined 2D barcodes as a method of tool tracking.

Currently, hunt the tool is a favourite game in the workshop, but any method of tool location has to be pretty much automatic with as little manual intervention as possible if the cost/benefit equation is to make any sense. The original tests on the Mori Hi-Tech machining centres were pretty positive but issues regarding installa-

tion and robustness prevented the project from progressing. In the interim fresh concerns regarding the technology have come to light, however the company we dealt with have been back in touch and say that there have been major software and hardware advances in this area. Also part of the system requirement is for a PC at every machine tool, which is a large investment but this is now going to be

implemented to allow local interrogation of drawings and 3D models. The addition of these extra workstations is now practical due to the vast increase in capacity of our new servers. As a result of all this we are investigating 2D bar coding again. Apart from tracking tools it should now be possible to check tool locations and orientation against the tooling lists automatically and guard against incorrect location of a tool holder.



CONTINUOUS IMPROVEMENT

Our progress towards 14001 is proving more difficult than originally envisaged. Whilst the manual has been satisfactorily completed there are elements in the standard that are proving difficult to attain without the building of new facilities. We are currently in discussion (over the past 18 months) with the council regarding issues surrounding our new building. Progress is glacial but steady. Don't hold your breath.

Eye care tests on the 25th of May for the quality department uncovered no undue problems.



Our new lorry is here. Sam the driver says it's much better than the old one. Not



hard considering the old one is a burnt out wreck.

The first Mori Seiki Duracenter 5 has proven such a success that another has been ordered. The speed and accuracy of the Duracentre machines allows for the

elimination of subsequent grinding and jig boring operations.

From April to Jun the Company recorded over 850 man hours of training.

Every quarter there are many detail improvements to the production system. This quarter the part turnover analysis has been improved and now indicates the time it takes us to turn around a works order. The operations time graph now allows you to exclude training time in case it distorts performance. A source of errors in the WIP valuation has been identified and measures put in place to minimise its impact.

HEALTH AND SAFETY

The next meeting of the Health & Safety Committee is set for the 16th August.

The installation of "dead mans handles" continues apace with only the Max Mullers to complete

Smoke alarms were fitted in all the toilets to comply with

new smoking regulations.

The side door to the 241 building beside the canteen presents a security risk if it is left open. To avoid this an alarm has been fitted (which doubles up as a door bell)

The department of Transport and Ken Livingstone have decided that horseless car-

riages are the work of the Devil and so the congestion charge will go up and the area covered extended to just below Manchester.

A spokesperson for the department said "we are confident this will reduce travel times"

Castle MD says "good" and orders a Porsche.

Bill Shakespeare

"Alas, poor Yorick! : I knew him, Horatio: a fellow of infinite jest, of most excellent fancy..... Where are your gibes now? Your gambols? Your songs? Your flashes of merriment....."



Castle Version
"Life sucks & then you die"

NEW TECHNOLOGY

The new computer servers have been installed. All teething problems with the exception of the backup system have been successfully resolved. Some of the improvements in performance have been spectacular. The roll out of new client workstations and PC's continues apace. Issues regarding 64 bit device drivers, particularly for printers continues to be a problem.

The new telephone system went live on the 12th of June. As with the computer system there have been some minor teething troubles, but by and large the system is working well. Every phone has the ability to speed dial our suppliers and customers 24^{hrs} a day 7 days a week. Many users are still getting used to the new functions but the general consensus is that the new phones represent a major advance.

A trial system to introduce probing measurement on to the machining centres has been ordered. This software / hardware solution should allow for quick offline programming of inspection and measurement on the machine tools. It will also enable conditional machining which depends on the outcome of measurements. If the first system is a success the system will be rolled out to every machine.

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See us on the web at
castleprecision.com

AS9100 is our future.



COMPUTING STAFF INCREASE BY 100%

Castle has doubled the number of people working in our IT department. We now employ two people. Our new IT guy Damian denies rumours of any connection to the Da Vinci Code despite the fact that Douglas was heard to say that Damian's coming would be the holy grail. Other folk say that what Douglas actually said was that if he could just get some *&^% peace and quiet that would be the holy grail.

Damian will take on the role of technical support, taking care of the servers, users PCs and printers, and also long term redesign of our web site, at which point this publication will be available on the web.

The new servers are capable of a massive speed improvement over the old system given some minor modifications to improve performance. Logging on at factory data collection terminal utilising finger recognition now takes five mille seconds instead of five seconds. If five seconds does not sound like much then consider that since 4th September 2002 more than one million transactions have been recorded, which had they had the saving, translates into thirty five working weeks. The new finger recognition units have registered more than twelve thousand transactions in around the first three weeks or approximately four thousand per week equating to 5 1/2 hours per week.

More Powerful than the NASDAQ



New Servers up and Running

NEW APPRENTICES

Apprentices are like fine



wines. Some years you get a vintage crop but you never know for sure until years later when they mature. This

years intake looks promising however it is really up to the supervision to ensure that all the apprentices get the training and attention that they need to develop into the next generation of capable, skilled & dedicated people. It is not just the future of the company that is at stake but also the promise the company makes to turn these young men into excellent engineers. In addition to our

normal technician intake it has been decided to start a craft apprentice scheme with a view to developing kids with more practical aptitudes. This new apprentice scheme will not require attendance at college but will utilise the best parts of our NVQ training to impart the highest practically developed skills. Our goal must be to also make craft apprentices into top tradesmen.

THE LAST TESTIMONIALS

Selex in recognition of our outstanding service said thank you by inviting our first year apprentices for a tour of their facility in Edinburgh. They manufacture radar and laser units of astounding performance in clean room conditions to extremely fine tolerances. Managers there expressed their gratitude to all at Castle for both quality & delivery achievements.

ADD YOUR CAPTION HERE



Pilsbury Dough Boys Make Finer Flour

We received the picture below as a token of thanks from British Energy for our engineering work on shafts during the R2 2006 outage



Oh I do like to be beside the sea side

