

ACCELERATED STABILITY TEST – R&D

[Redacted]	Accelerated Stability Test (AST)	GQ.FOR.ManPG.03
	Report	
	Higher Acid Sanding Blend Trial	Page: 4 / 6

APPENDIX (additional relevant data or information)

Results – Visual and Organoleptic evaluation - Summary		
Product ID + Packaging	Duration	Visual and Organoleptic evaluation
[Redacted]	7 days	OVERALL APPEARANCE <ul style="list-style-type: none"> Test samples wider than Control samples - Control samples look almost too skinny. Both Test CARON and Control CARON have similar sanding adhesion appearance and appear less sanded than the Ambient. OVERALL TEXTURE <ul style="list-style-type: none"> Control texture seems softer and more easily chewed than Test. The Control CARON was a different chew, like a gum drop. This difference is present in both Ambient and Incubated samples. OVERALL FLAVOUR <ul style="list-style-type: none"> Test CARON is both slighter than the Control CARON.
	14 days	OVERALL APPEARANCE <ul style="list-style-type: none"> Test samples are also not Variation not due to sanding. Slightly greater appearance Incubated Test sample vs Ambient. Although, the slight wetness experience with other Control CARON sample has a Control CARON sample. OVERALL TEXTURE <ul style="list-style-type: none"> The stickiness between pieces Incubated Test vs Incubated ambient samples). OVERALL FLAVOUR <ul style="list-style-type: none"> The flavor of the ambient is sour impact than the ambient the incubated test and control.
	21 days	OVERALL APPEARANCE <ul style="list-style-type: none"> There is less sanding on both which increases clumping. Sanding adhesion between samples. OVERALL TEXTURE <ul style="list-style-type: none"> Test CARON appears slighter CARON but not out of line samples from prior experience. Overall, texture was similar having a softer texture than control. OVERALL FLAVOR <ul style="list-style-type: none"> Test sample is slightly more less saturated.

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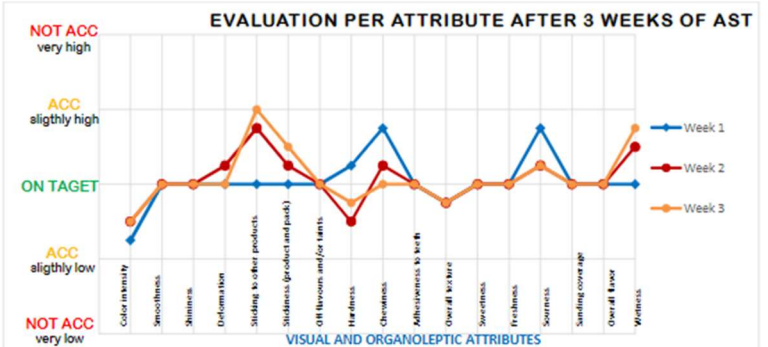
Date: 11/21/2022
 Project ID: 32022244
 Applicant: [Redacted]
 Manufacturing Location: USA - Erlanger

Product ID	[Redacted]
Test Sample (Brand, product name, flavour, recipe no, SAP code)	[Redacted]
Production date	Production Date: 10/2022 (Erlanger)
Product ID	[Redacted]
Control Sample (Brand, product name, flavour, recipe no, SAP code)	[Redacted]
Production date	Production Date: 2/2022 (Toluca)

Quality Evaluation – Final Summary and Conclusion:
 Main Difference: Greater sour impact from test samples, titratable acidity results show a 0.4-0.5% increase in acidity for the test samples in comparison to the control.
 Some differences seen between the two samples were determined to come from normal process variation, i.e.; thickness and width differences; hardness; color intensity of green, orange, and yellow stripes. Since the recipe change has been fully implemented at Erlanger, the control sample was pulled from Toluca, which may account for the greater variability between samples.

AST Conclusion: **Approved** (test samples are ok after AST) **Not approved**

Recommendation: Proceed with new sanding blend recipe.



SOP - Production Department

		Doc #:	
		Issue Date:	10/26/2021
		Revision Date:	8/24/2022
		Revision:	2
		Effective Date:	9/5/2022
		Page 1 of 10	
Document Owner:			
Document Approver:			

I. Purpose:

The purpose of this document is to provide detailed operating procedures for the [redacted]
Lines 1, 2, 3, 4, 5, 6.

II. Responsibilities:

Production Operators have the responsibility to perform these tasks.

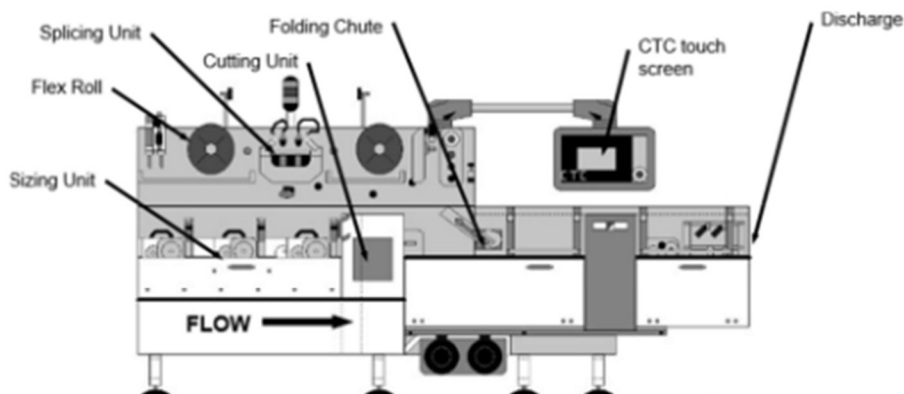
III. Overview:

Each Theegarten receives a continuous rope of product from a cooling tunnel. The rope is fed onto the speed control table and pulled through a metal detector.

The rope is shaped and formed in the sizing gears, then cut into bars at the cutting unit (Housing). The cut bars are then wrapped at the folding chute before being sealed, cut, and discharged as finished Airheads. At discharge, the Airheads may be sampled for weight and package quality.

Once the product wrapping material ("Flex") is loaded and threaded, it will be pulled continuously through the wrapping area. A production code is added as the flex unwinds. When the flex roll is used up, the splicer automatically cuts and splices the new roll onto the old.

The Touch Screen monitor features operating screens for monitoring and control of selected machine functions. Clear guard doors and covers create a safety barrier between the operator and machine motion, while still allowing machine activity to be monitored, via interlock controls that require the doors to be shut for operation, but are clear for visibility.



Classification: Internal

Training Documentation – Safety Department

	 SHER Training Document for Level 1&2 General Line	Doc #: Issue Date: Revision Date: Revision: Effective Date: Page 1
Document Owner:	Production Supervisor	
Document Approver:	Operations Manager	

HOW TO USE THIS DOCUMENT

I. Purpose

Level 3 Trainers are expected to help their Trainees stay safe and take responsibility for being proactive about helping identify problems that could become injuries, by educating them on our safety systems and safe working behaviors. The SHER Training Document is developed by SHER and the Training Team to standardize content and train SHER-based topics on the Line OJT, one-to-one on the Production floor.

II. Responsibilities

It is expected that you begin training on this documentation as soon as possible as we request that sign-off be completed within two weeks of start of new employment.

Each topic contains Rationale, Objectives and Talking Points for the Trainer.

Actions must be completed by Trainer plus Trainee as directed in your Value Stream area.

	 SHER Training Document for Level 1&2 General Line	Doc #: Issue Date: Revision Date: Revision: Effective Date: Page 1
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(3) A Near Miss

a. An event that did not result in an injury but that could have if the conditions were right. In other words, if coupled with an Unsafe Condition – lack of attention by others or self, or a physical danger like incorrectly stacked pallets or incorrectly followed LOTO procedures – a Near Miss can become an incident

(4) An Incident

a. When Unsafe Conditions and Unsafe Behaviors come together and injuries result

To explain this further, use the example of a machine guard:

1. A **Near Miss** is when the guarding is left off of a machine and you almost stick your hand in but then realize the machine is on and you stop yourself from doing that.
2. An **Incident** is when the guarding is left off of a machine and you stick your hand in without realizing the machine is on, and you get injured.
3. **Unsafe Behavior** is trying to get around the guarding to do something that you know you shouldn't be doing, and getting injured.
4. An **Unsafe Condition** is the guard being left off of a machine.

- Know the requirements of a SHER tracker submission.
- Understand the process of a SHER tracker submission.

Talking Points

- **What is a SHER tracker?**
 - we require all employees to submit Near Misses (at least once per year per person). A Near Miss is an incident that could have resulted in an injury or property damage but did not. They are important to call out because they can foreshadow future injuries or call out potential problems. All Near Misses need to be reported!
 -

Actions for Trainer

- Show the trainee how to submit a SHER tracker on

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	 SHER Training Document for Level 1&2 General Line	Doc #: Issue Date: Revision Date: Revision: Effective Date: Page 1
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**CLICKABLE LINKS/
LIVE ONLINE DOCUMENT**

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How to find Document Control	
To Fix a Document	

Classification: Internal

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	How to do this job																																																																								
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Classification: Internal

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TRAIN THE TRAINER

Assessment Refresh

Remember the “Addie” Learning Model?

- Analyze**
 - Conducting a needs analysis
 - Identifying the knowledge gap
 - Conducting an audience analysis
 - Developing learning objectives
- Design**
 - Identifying instructional design strategy
 - Selecting appropriate delivery method
 - Developing storyboards and media
 - Establishing an evaluation methodology
- Development**
 - Creating the prototype
 - Building training materials
 - Conducting a tabletop review
- Implementation**
 - Establishing schedule
 - Preparing training materials
 - Notifying and enrolling learners
 - Launching the course
- Evaluation**
 - Collecting evaluation data
 - Assessing project performance
 - Reporting results

Classification: Internal

COURSE B: Material Creation and Publishing

KAHOOT Slide

Let's Kahoot!

Take a break!

NEEDS ASSESSMENT Slide

Now we're going to talk about Needs Assessments.

When you are getting ready to train someone, you need to do a Needs Assessment, which determines what will be needed in order to do your best work as a Trainer.

TERMS Slide

In industry there are many terms. "Training Needs Assessment" means the same thing as "Training Requirements Analysis" means the same thing as "Gap Analysis. For us they all mean the same thing.

The problem is that managers often think, "I have a performance problem, so I need to train my team." But first you must determine if training is really the solution to the problem! Sometimes, the root cause might be inadequate equipment, understaffing, hiring problems ... something other than lack of training. By completing a training needs analysis, you can identify the performance gap and figure out if training is the right solution.

Classification: Internal

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COURSE B: Material Creation and Publishing

OBJECTIVES Slide

Updates on making it to the next level!

When you have completed today's training, you will understand some important processes, be able to tell others what they are and why they're important, and you will be able to perform a TNA – a Training Needs Assessment.

You will understand the differences between Training, Communication and Policies.

You will better understand the importance of content creation and you will also better understand the process.

AGENDA Slide

We are going to cover these topics:

Our mission as a team

Updates on what is happening with our efforts so far

We will review what we covered in Course A

Then we get into the meat of the matter and we will get you familiar with the Training Needs Assessment – a big part of your work as a Trainer.

Next is Content Creation. The impact of what you do as a Trainer reaches far beyond the Production floor. Your tracking and content creation reaches from the Training Department all the way to OSHA. So it has to be correct and it is far more than "just paperwork".

Next we will cover Publishing Materials. These are all of the documents that you need to have access to, and to use in your role.

Last will be the Training Calendar which you were introduced to in Course A. We will go a little deeper into its use.

Classification: Internal

PRESENTATIONS

2. VOCAL TURN-OFFS


- The Charlie Brown Factor
Droning issues
- Speaker is too slick or salesy
Overwhelm issues
- Speaker has vocal tics
Nails-on-a-chalkboard issues
- "Ground Control to Major Tom!"
Connectivity issues

How do I check for – and avoid - all of these problems?

TODAY'S FOCUS

Personal Presentation – Presentation Style & Emotion

- Explore the impact of presentation style.
- Learn tips you can use right now to engage your audience.
- Uncover your hidden strengths and weaknesses.



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BENEFITS OF INDIVIDUAL & GROUP DIAGNOSTICS & TRAININGS

- Go straight to the core of your webinar challenges.
- Increase your conversions.
- Reduce webinar creation time.
- Tighter and more effective webinars.
- Practice delivering your webinar with a troubleshooter on hand.
- Maximize the impact of your message.



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