Sunshine Fruit Juices employs 100 people in its Queensland factory and supplies juice to large supermarket chains in Asia and North America. Customers have recently complained that the product has been damaged and bottles have been wrongly labelled. An increase in industrial disputes has also occurred due to a number of recent workplace accidents and demands from employees for higher wages. Employed by Sunshine Fruit Juices to prepare a report for management on the issue outlined above. In the report recommend strategies for human resources and operations that the firm could implement to improve its business performance. A factory manager: Monitoring, scheduling, sequencing, operation. Production process is being reviewed and the correct sequence for an operations process - Facilitates - Control - waste, material - design - product. In turn - services - improvement, human resources - planning - customers. An Australian employee wage increase every year, cost of living wage increase minimum employment standard.