

This indicates that, during the follow-up meeting where we analyzed the video, these segments were critiqued together

P/N 026DC104 Flow Comments

Type of activity

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00:00 – 00:30

Move raw material to receiving inspection

- Observed conveyance waste

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00:30 – 01:09

Perform receiving inspection of raw material

- Observed waste associated with waiting for inspectors to perform inspection
- Observed inventory waste
- Observed motion waste for inspectors to convey the necessary gages from QA to receiving inspection area and back

Suggestion

- As the material handler unloads the raw material at the shipping and receiving dock, he pulls a sample of the raw material, marks which box the samples is pulled from, tags the boxes, places the boxes onto the storage racks, and conveys pulled samples to QA for receiving inspection

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01:09 – 01:32

Move inspected raw material to storage

- Observed conveyance waste

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01:32 – 02:25

Storage of raw material

- Observed excess inventory of raw material
- Observed 5S failure with hoppers, A3 containers, and misc containers stored in front of racks which limits accessibility

Suggestion

- Need written instructions and training of material handlers on the use of the storage areas

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02:25 – 03:25

Move individual containers of raw material to staging area

- Observed conveyance waste
- During the conveyance of raw material to the staging area, it was observed that some PR associates were underutilized
- Observed 5S failure with raw material on floor (in front of horizontal boring mill)

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03:25 – 04:25

Staging of raw material

- Observed excess inventory (both raw material and WIP)
- Observed overproduction; with regard to sawed slugs, they were produced before they were needed
- Observed 5S failure for lack of organization

Suggestion



04:25 – 04:40

- Eliminate all staging of raw material
- Move raw material from staging to first operation
 - Observed conveyance waste



04:40 – 05:14

- Perform operation #10
 - Observed overproduction
 - Observed defective products near workstation



05:14 -06:30

- Move WIP from op. #10 to op. #20
 - Observed conveyance waste
 - Observed 5S failure with broom and dust pan



06:30 – 07:00

Perform operation #20

07:00 – 07:54

- Move WIP to QA for inspection
 - Observed conveyance waste

07:54 – 10:00

- Inspection
 - Observed 5S failure with items along wall

10:00 – 10:37

- Move inspected parts to shipping
 - Observed conveyance waste
 - Observed 5S failure with coolant barrels

10:37 – 10:40

- Staging of WIP at shipping
 - Observed waiting of WIP for shipping

10:40 – 10:48

Shipping to outside vendor

10:48 – 12:39

- Receive WIP from outside vendor and move to receiving inspection
 - Observed conveyance waste

12:39 – 15:21

Perform receiving inspection

Suggestion

- Perform receiving inspection during first piece inspection at operation #50

15:21 – 15:55

- Move parts from QA to operation #50
 - Observed conveyance waste

15:55 – 17:14

- Perform operations #50 and #60
 - Observed defective parts in red pans

- 17:14 – 17:28 Move parts to QA for final inspection
- Observed conveyance waste
- 17:28 – 18:20 Perform final inspection
- 18:20 – 19:00 Move parts to finished goods inventory
- Observed conveyance waste
- 19:00 – 19:27 Finished goods inventory
- Observed excess inventory