



LEAN SixSigma Tools For Short Runs

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Introduction

➔ Lean Tools

➔ Seven Types of Waste

➔ Tool Application

➔ Summary

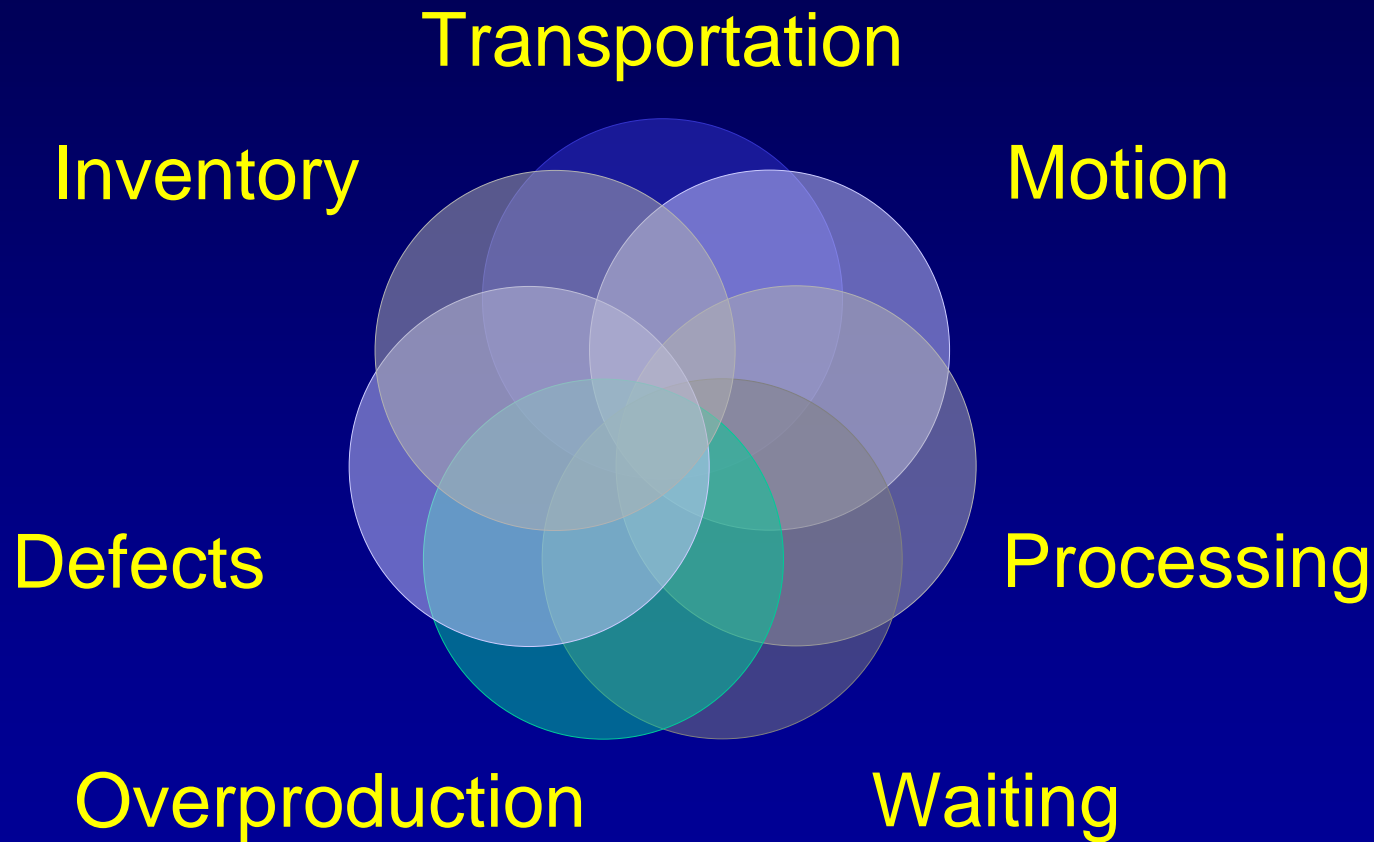
Key Lean Manufacturing Tools

Voice of the Customer	Understand VA vs. NVA from eyes of customer.
Value Stream Mapping	Map flow of customer order Material and information
Process Observations	Go to Shop Floor and see, record actual data.
Current State Map	The as is process. Highlight opportunities.

Key Lean Manufacturing Tools

Kaizen	Good Improvement Doing not going to do! Engaging people
SMED	Maximizing process efficiencies in changeovers.
Future State Map	What the process can be if waste is eliminated.

Seven Types of Waste



Think about these Questions

Is there really a need for quicker change outs ?

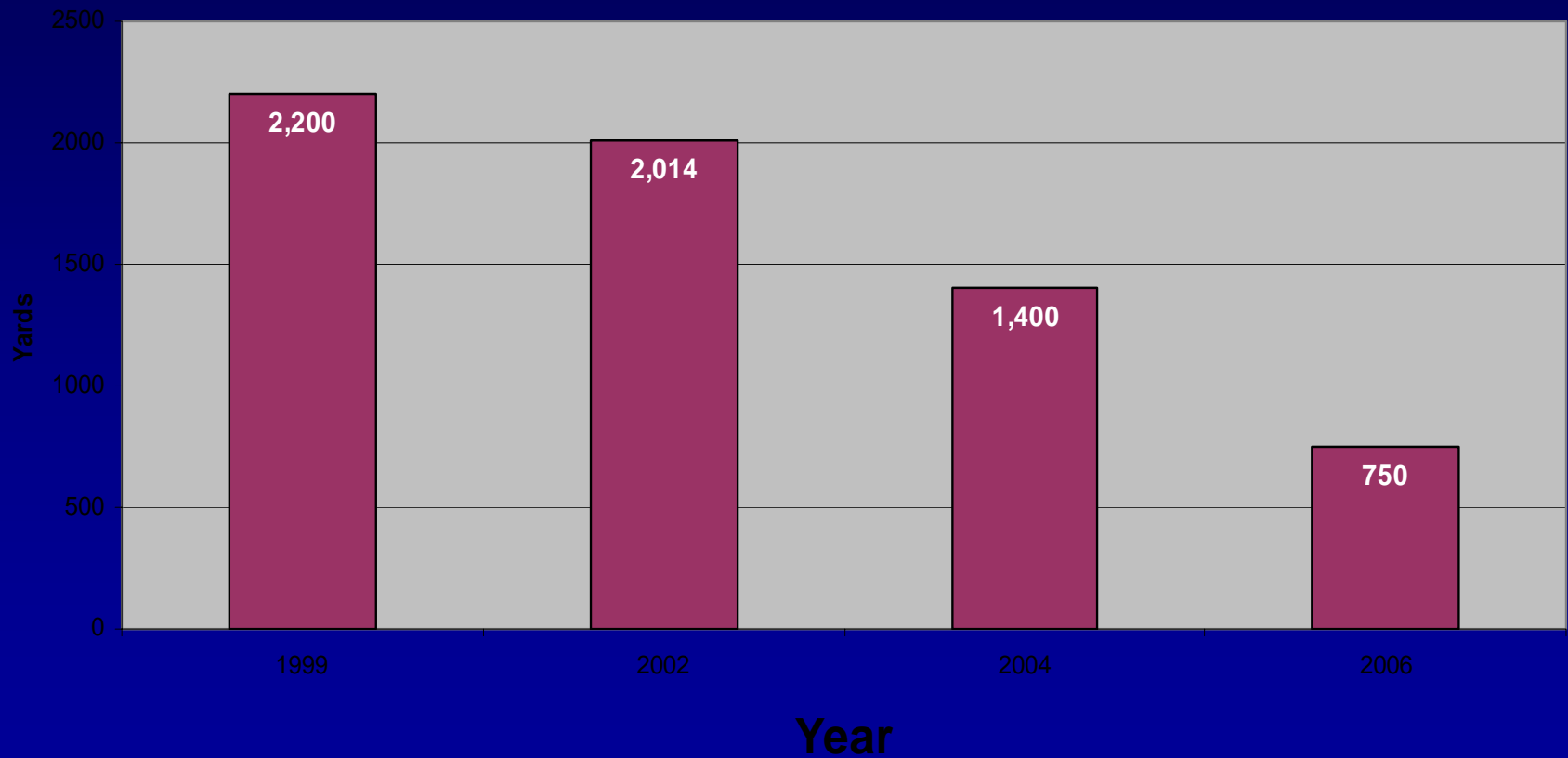
Should we be concerned about waste of time ?

Is streamlining our processes needed ?



One
Industry's
Answer

Wallcovering Average Order Size 1999 - 2006



Attacking Short Runs Using Kaizen

Action

Lean Tools

Establish Goals	Kaizen Charter
Map Current State	Post it notes Process experts
Walk Current State	“Go to the Floor” Process Observations Video Taping

Attacking Short Runs Using Kaizen

Identify Undesirable Effects “UDEs”	Affix all UDEs to Current state Map
Root Cause Analysis	Five Whys Cause & effect
Correctly depict the Problems	Problem Statements The problem is.....

Attacking Short Runs Using Kaizen

Create solutions	Solutions Specification
Map Future State	Team, Post it notes
Test Solutions	FMEA
Go Do!	Put improvement in Place quickly.

Summary

- Voice of customer is key
- The tools are simple
- Trust the process

Thank You