Developing Lean Leaders at all Levels: A Practical Guide

Chapter 3 Figures

Standardized Work Sheet								
Job Name		Part Name:		TAL:	sı	P Stock:		
Group		Part#:		G/L:	Ta	akt Time: 76 Sec		
#	Work Elements	Work	Walk Time					
7	Pick up bracket Å	n						
2	Load in fixture	6	2					
3	Pick up bracket B	9	2			\neg		
4	Load in fixture	5	3		Fixt	ure		
5	Pick up side support	1	3	Brace Stiffene	10)2	4 11 Bra	A B cket Bracket	
6	Load in fixture	3	-1	9		6	1)3	
7	Pick up stiffener	1	111		الم	_		
8	Load in fixture	8	2		(5			
9	Pick up brace	1	2		Sig			
10	Load in fixture	5	3					
11	Start Robot cycle	1	3 1					
				Standard In-Process Stock	Quality Check Safe	4.		
	Total	33	23			Page	or	

Figure 3-1. The Standard Work Sheet

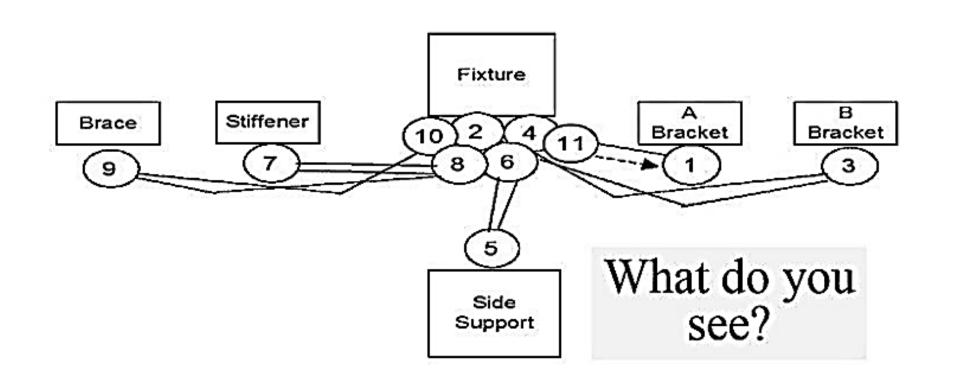


Figure 3-2. Work Flow Steps

Standard Work Instruction

Department	Operation Name:	Revision Date:
L. Z.		Prepared by:
No.	Major Steps	Key Points
F 1		
1		
2		
3		
4		
5		

Figure 3-3. Standard Work Document for Non-Cyclical Work

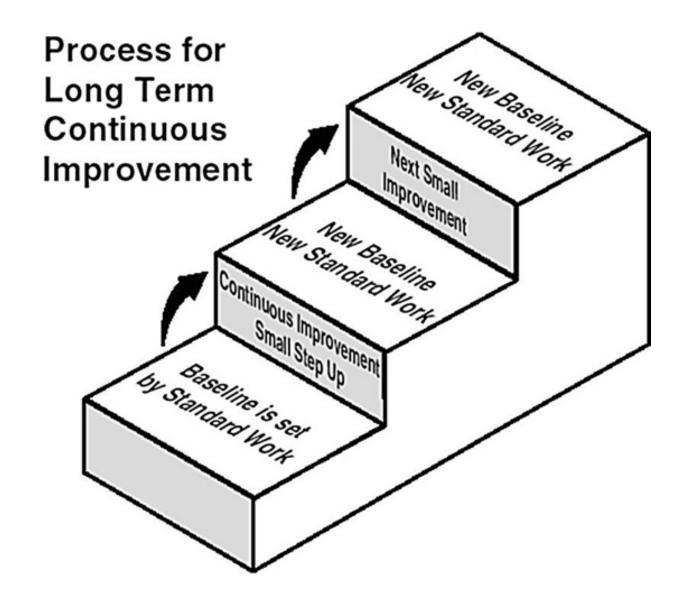


Figure 3-4. The Process for Long Term Continuous Improvement

Go and see

Visualize production

To reveal problems and react quickly

And solve them one by one

To increase the standard and challenge

Source: Michael Balle

Figure 3-5. Visualize Actual vs Standard to solve problems one by one

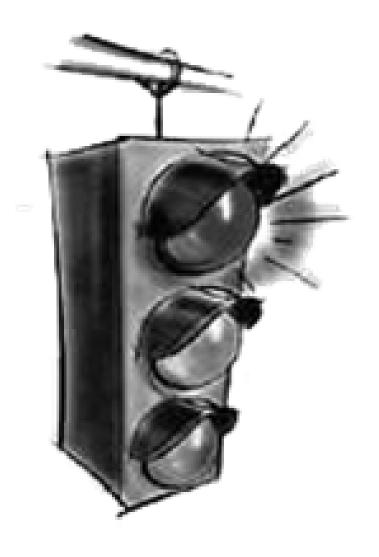


Figure 3-6. The Traffic Light



Figure 3-7. The Office Workplace without 5S



Figure 3-8. The Office Workplace with 5S



Figure 3-9. The Menlo Environment

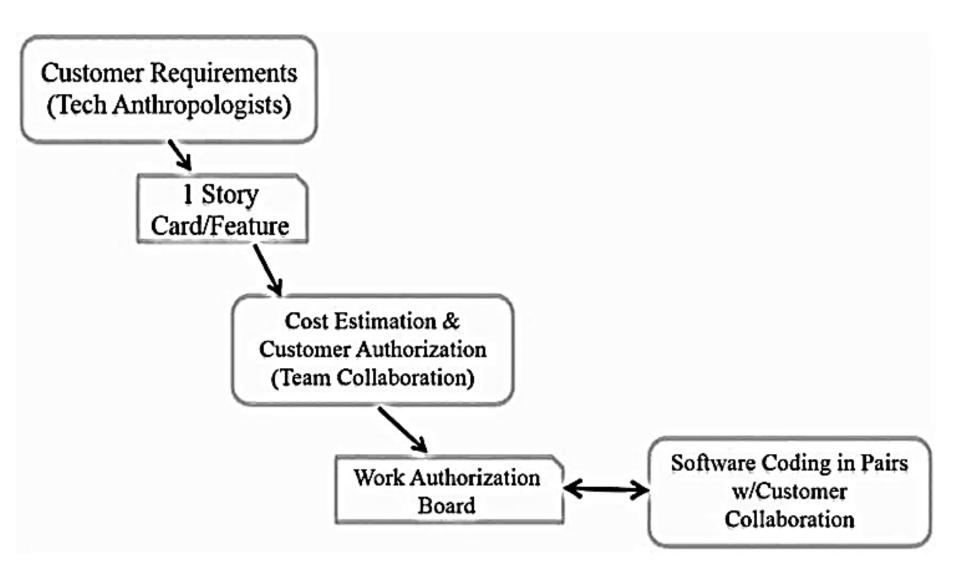


Figure 3-10. The Technical Anthropologist



Figure 3-11. Estimating the time needed for each story card



Figure 3-12. The Visual Work Task Board



Figure 3-13. Teamwork – Coding in Pairs