

Results Metrics

for **Sample Improvement Event**

Revised: 5-13 Author: Audrey

Process Design Objectives	Measures							
	Start	Unit of Measure	Projected	± Change	30 Days	± Change	60 Days	± Change
% Complete and Accurate	84%	% MGR	85%	10%	87%	3%	87%	100%
Process Time	413	seconds	38	78%	207	50%	31	77%
Lead Time	7	days	7	50%	14	50%	1	50%
Flow Space Used	1200	sq feet	300	75%	550	54%	750	79%
Travel Distance - feet	144	feet/mile	1	1%	10	54%	20	8%
Waste/Defects - percent	30	pieces	1	8%	15	45%	2	6%
Number of workers required	2	workers	1	50%	1.5	25%	1	50%
Cost per unit								
Worked Work in Process Inventory								
TS (Std)								
Safety accidents per month								
Number of process steps								
Value Add Steps								
Delta Down % (desired change is down)	20%		100	50%	300	50%		
Delta Up % (desired change is up)	10%		200	100%	50	50%		
Delta Zero % (requires human judgment)	10%		200	100	50	50		
Delta Only % (requires human judgment)	10%		200	100	50	50		

Subjectively measured: 4 = better of 5 possible

Anticipated: It is expected that involving employees in improving their own work will improve morale.

Observed: Employee morale seems to have definitely improved.

Cycle Time Observations

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Fast Limit: 45 Seconds

Target: 32 Seconds

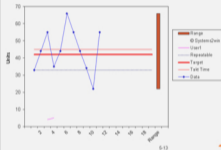
Lower: 2 Observations

Highpoints: 13 Seconds

Variation: +37%

User: P001 (click row if not used, or copy for more user feedback)

Cycle Time Run Chart for Assembly



Comments