

Industry Case Study – Leading Service Provider

Short Run / Manual Insertion – Jobs of less than 150 pieces

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As is Process & Challenges

Cost & Labor Challenges

- <15% of total volume
- > 40% of Labor costs
- High Per Pc. Labor costs
- Difficult to resource for peak periods

Quality

- Quality and Integrity issues are rare, but painful
- Quality verification requires Secondary processes
- Process not Integrated to Enterprise Piece Tracking Systems

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Project Requirements

High Level

- Labor Reduction of 50%
- 100% Piece Integrity
- Low operator skill level
- ROI / Payback < 1.5 yrs.
- Must run all jobs “As-Is”

Key Measurement & Goals

- Avg. job size 36 pcs.
- Throughput Target > 375/hr.
- Job Change-over < 3min
- Stops / Job < 1.0
- Uptime > 95%

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System & Process Design

Key Success Factors

- Process and Product implemented together
- Focused on reducing time between jobs
- All job materials kitted prior to delivery to cell
- Operators selected with good time management skills
- “Workflow Pressure” /many jobs in cell
- Operators select “like” jobs to reduce setup
- Next job prepared while system is running
- System design focused on automated setup

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Quality Improvement

Achieved

- 100% Integrity - No errors
- Each Piece verified and Tracked by Customer’s enterprise tracking system

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Operational & Financial Results

Performance Vs. Goal

- Exceeded all metrics
- Throughput 140% faster - 528 Vs. 375/hr.
- Job Change-over 23% faster - 2.3 Min Vs. 3 Min
- Stops per job 62% fewer 0.38 Vs. 1.0
- Labor reduction 30% better 67% vs. 50%
- Payback / ROI 30% faster 1.1 yrs. Vs. 1.5 years