Current State Map
Casting/Forging
Currently 800/day Build
(Machining 3 shifts, Assy 2 shifts)

Weekly schedule for planner emails to all departments/manufacturing

Schedule and develop Build Schedule for week

Finished bank to protect customer. Week 1 & 2 fixed, outside that it is a forecast

Electronic loading of PAS weekly

PLANNER

Block Mod 4 - 525/day - Planned - August 2013 Implementation - Not Installed

JPH = 29.5 Gross Rate
FTQ = 97%
Uptime = 50%
Inventory = 1371 pcs

Block Mod 5 - 525/day

System Fill = 150 pcs
2.0l WIP = 939 pcs
2.5l WIP = 282 pcs

Block Mod 6 - 525/day

System Fill = 150 pcs
2.0l WIP = 18 pcs
2.5l WIP = 576 pcs

Head Mod 1 - 525/day

System Fill = 100 pcs
2.0l WIP = 63 pcs
2.5l WIP = 16 pcs

Head Mod 2 - 525/day

System Fill = 106 pcs
2.0l WIP = 40 pcs
2.5l WIP = 648 pcs

Head Mod 3 - 525/day Planned - August 2013 Implementation - Not Installed

JPH = 29.5 Gross Rate
FTQ = 95.8%
Uptime = 50%
Inventory = 794 pcs

Head Mod 4 - 525/day

System Fill = 100 pcs
2.0l WIP = 6 pcs
2.5l WIP = 24 pcs

Head Mod 5 - 525/day

System Fill = 106 pcs
2.0l WIP = 40 pcs
2.5l WIP = 648 pcs

Head Mod 6 - 525/day

System Fill = 100 pcs
2.0l WIP = 63 pcs
2.5l WIP = 16 pcs

Inventory = 0 pcs

Inventory = 179 pcs

Head Sub-Assembly - 1575/day

JPH = 75
FTQ = 96%
Uptime = 58%
Inventory = 744 pcs

Loop 1 Assembly - 1575/day

JPH = 75
FTQ = 94%
Uptime = 58%
Inventory = 100 pcs

Loop 2 Assembly - 1575/day

JPH = 75
FTQ = 94%
Uptime = 58%
Inventory = 70 pcs

X Assembly - 20% Pentration (350/day) February 2013 Running

JPH = 25 (Planned)
FTQ =
Uptime / OEE
Inventory = 0 pcs

X.0L 572 pcs
X.0L 324 pcs
X.0L 816 pcs
X.5L 685 pcs
X.5L 283 pcs
X.5L 336 pcs
X.5L 276 pcs
X.5L 286 pcs
X.5L 408 pcs
X.5L 458 pcs
X.5L 548 pcs

Finished bank to protect customer. Week 1 & 2 fixed, outside that it is a forecast

Weekly schedule for planner emails to all departments/manufacturing

Electronic loading of PAS weekly