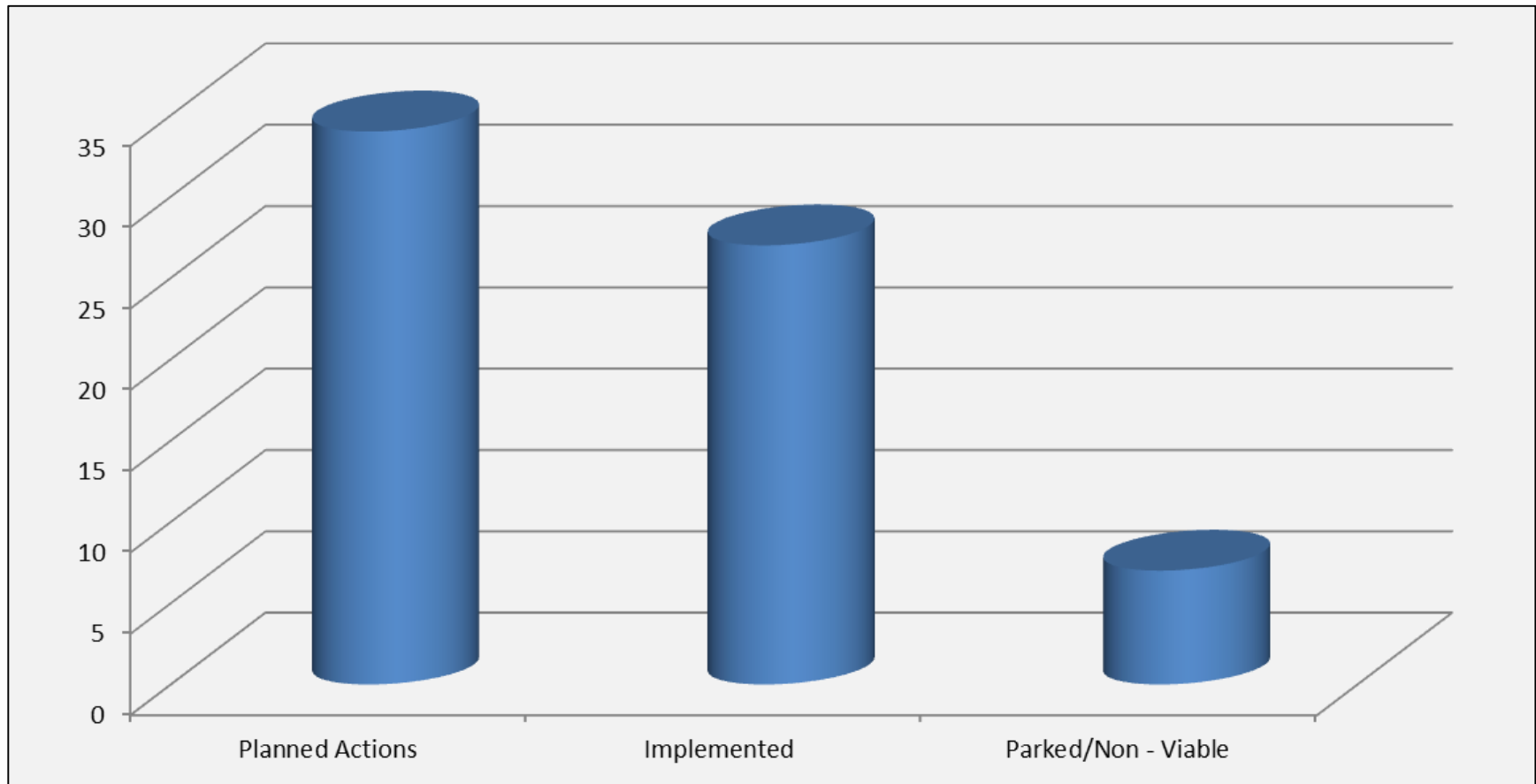




Receiving Warehouse Transformation

Overall Performance

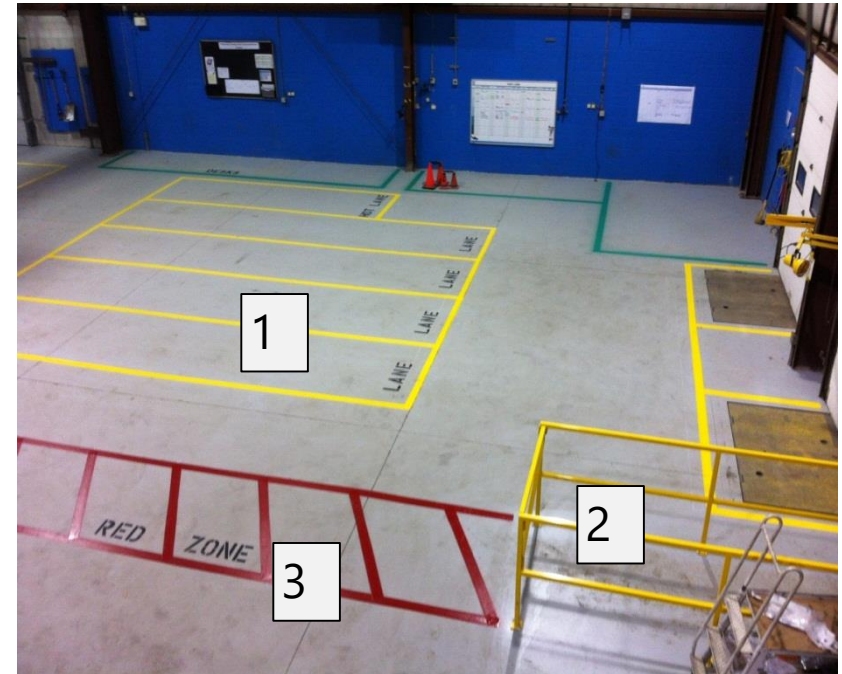
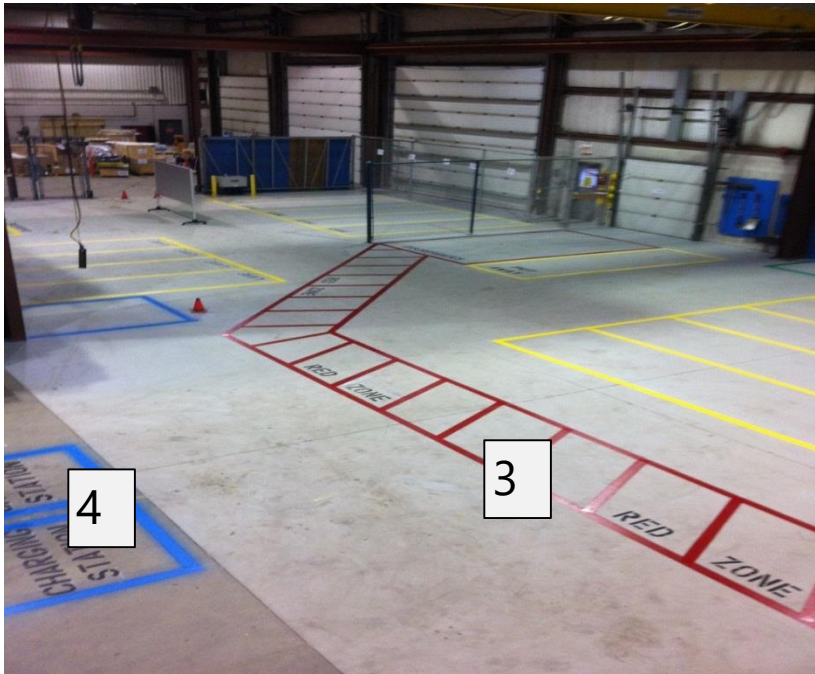


Outputs

Before:



Who knows what goes where???



- 1. Numbered Staging Lanes:** Allows for a robust First In – First Out Process (FIFO)
- 2. Carrier Pen:** Limits the movement of Carriers within the Department
- 3. Red Zone:** Limits the pedestrian activity within Receiving Area.
- 4. Set in place:** Charging stations for forklifts (PMHV) Area.

“A Place For Everything and Everything In Its Place”



1. **PMHV Recharging Station** – Dedicated Space for specific activity
2. **Dock Lamps** – Increases Visibility and Safety when servicing trailers

“A Place For Everything and Everything In Its Place”

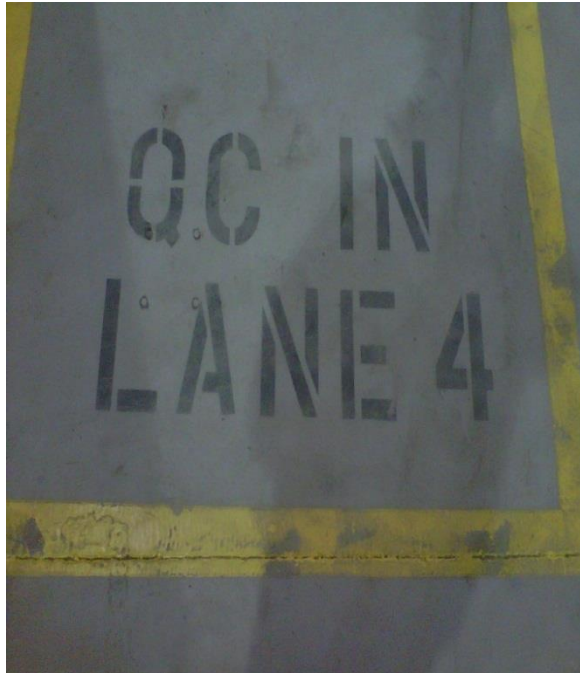


In-Station Process Control



Visual Factory

"A Place For Everything and Everything In Its Place"



In-Station Process Control



Visual Factory



Built In Quality

"A Place For Everything and Everything In Its Place"



“A Place For Everything and Everything In Its Place”

Visual Management:

Q.C. QUARANTINE PARTS STATUS																					
PART #	QTY	STATUS	DATE	REASON	APPROVED	COMMENTS	PART #	QTY	STATUS	DATE	REASON	APPROVED	COMMENTS	PART #	QTY	STATUS	DATE	REASON	APPROVED	COMMENTS	
138509	1100008	3	QC	SAARU 11/21/10			142426	16131	2	QC	2cc 11-21			142881	3081	6	QC	2cc 11-21			
136462	720686	1	QC	2cc 11-22			137029	7960-1	5	QC	2cc 11-21			142881	8934	8	QC	2cc 11-21			
141154	4917	2	QC	VAEID 11-20-12			142881	2580	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
158543	830094	3	QC	JMAN 11/21			142881	19025	6	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
136462	720475	3	QC	2cc 11-22			142881	19025	6	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
143476	623	3	QC	2cc 11-22			142881	19025	6	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
138543	5008046	2	QC	SAARU 11/21/10			124576	6549	6	QC	MATT 10-22			142881	5017	5	QC	2cc 11-21			
136456	720686	2	QC	2cc 11-22			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
140955	8528	4	QC	2cc 11-22			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
140953	8528	1	QC	2cc 11-22			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
140786	8528	1	QC	2cc 11-22			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
142475	14700	1	QC	2cc 11-21			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
141100	14369	2	QC	2cc 11-21			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
142835	3446	2	QC	MATT 11/21/10			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
140957	8528	1	QC	2cc 11-22			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
141100	810359	8	QC	2cc 11-21			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
141100	6863	2	QC	2cc 11-21			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
141154	6921	1	QC	VAEID 11-20-12			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
142236	1945	4	QC	VAEID 11-20-12			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			
142881	1380021	2	QC	2cc 11-21			142881	14252	1	QC	2cc 11-21			142881	5017	5	QC	2cc 11-21			

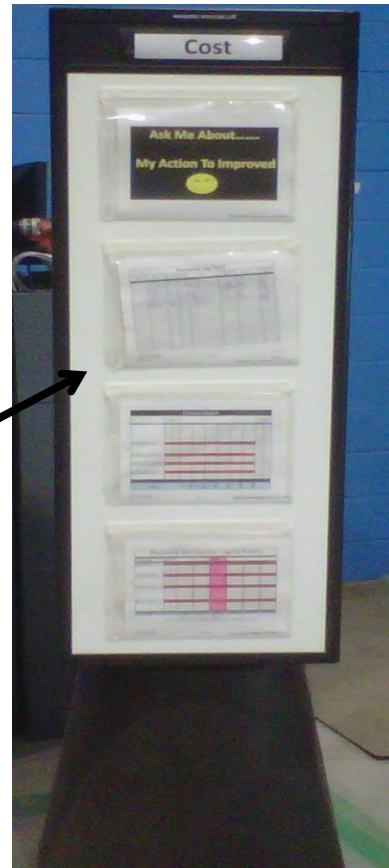
Visual Management allows for anyone to see quickly the status of an area and supports the work done by the teams. When things are made visual they become part of the overall flow as opposed to hidden in the traffic.

Visual Management:



- 1. Departmental Training Center:** A central place for all Departmental and Plant Specific control documents and information is presented.
- 2. Document Station:** Documents can be kept and easily referenced.
 - (Ex. Procedures, Single Point Lessons and Work Instructions.)

Visual Management:



Departmental Information
Metric Reporting

Employee Daily
Performance Tracking

Opportunity: Employees did not have a vehicle to track/capture departmental issues or Performance

Improvement: Two Carousels are prominently displaced to add substance to the morning huddle

Visual Management:

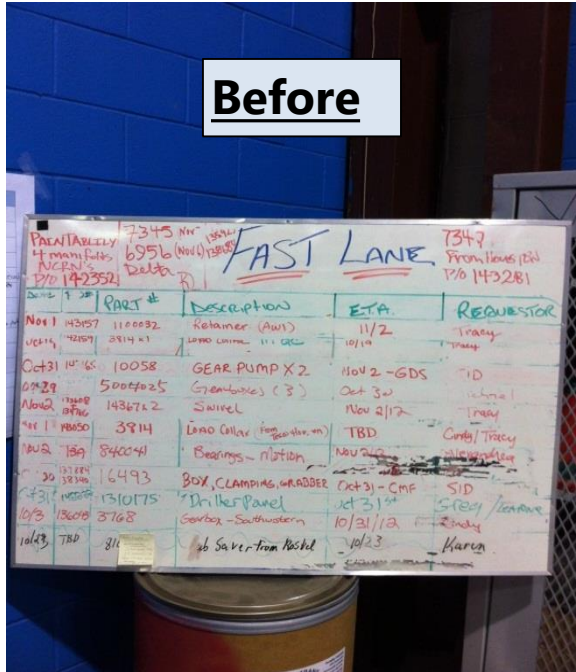


Opportunity: Parts unidentified in various stages of process. No tractability of aging parts

Part Identification and Tractability: Examples of "In Station Process Control and Built In Quality"

Visual Management:

Before



The Plan

Fast Lane																
#	Receiving	Time/Date in	Verified by	Q/C	Time/Date in	Verified by	Receiving	Time/Date in	Verified by	Planning	Time/Date in	Verified by	Warehouse	Time/Date in	Verified by	R2W Time
1																
2																
3																
4																
5	T	8/13/12		T	8/13/12		T	8/13/12		T	8/13/12		T	8/13/12		
6																
7																
8																
9	S			S			S			S			S			
10																
11	V			V			V			V			V			
12																
13	S			S			S			S			S			
14																
15	T			T			T			T			T			
16																
17	E			E			E			E			E			
18																
19	M			M			M			M			M			
20																
21																
22																
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28																
29																
30																

After



Fast Lane Process

The Opportunity: TMF had no formal process to physically track arrived Hot Parts and measure throughput.

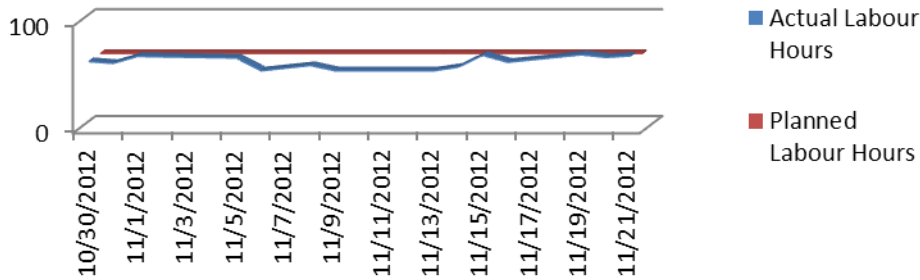
The Improvement: A formal process was created through the collaborative effort by Receiving, Quality, Purchasing, Continuous Improvement and Planning Teams. TMF now has a **Standard** in place to manage and measure Hot Part performance.

Data:

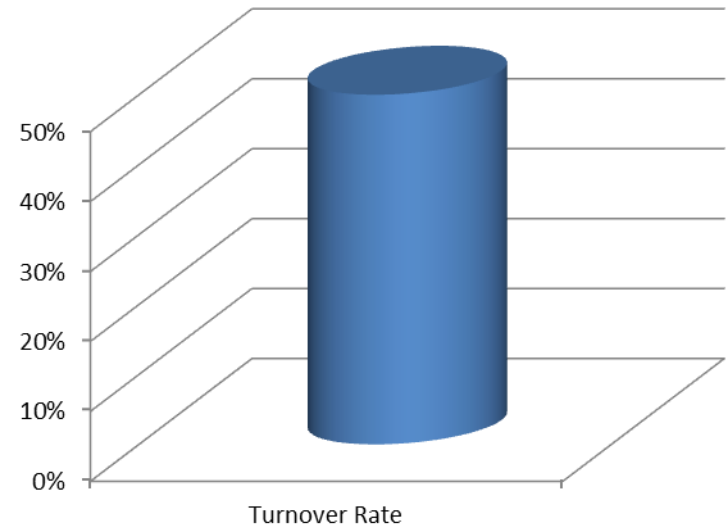
**“You Can Not Improve
What You Can Not
Measure.”**

W. Edwards Deming

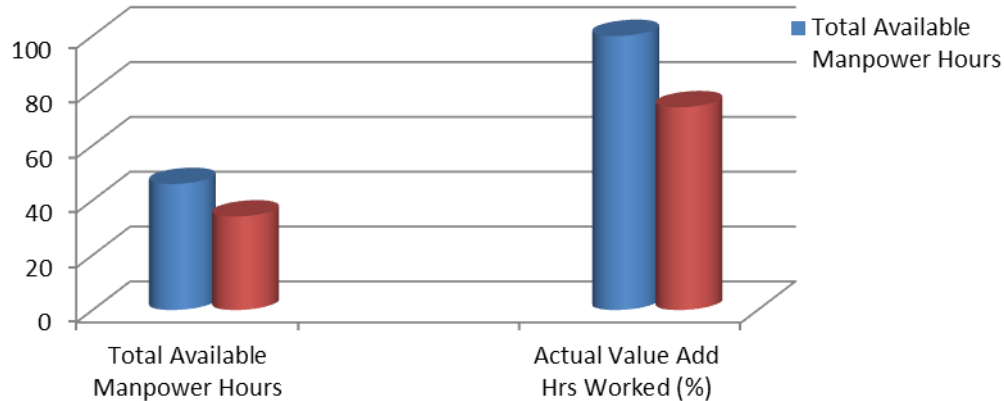
Planned Labour Hour Vs. Actual - Trending



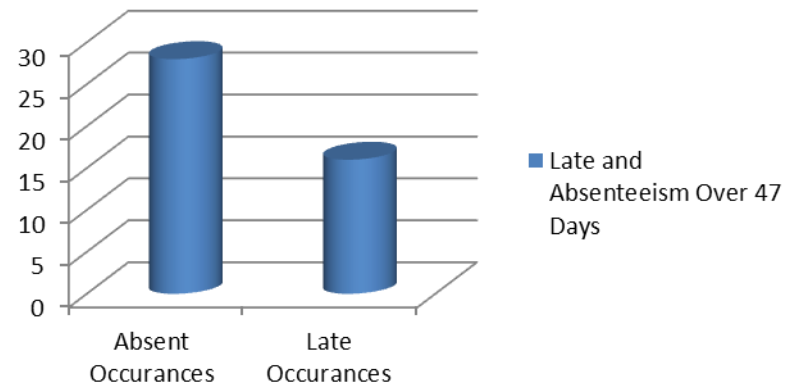
Receiving Manpower Turn Over Rate



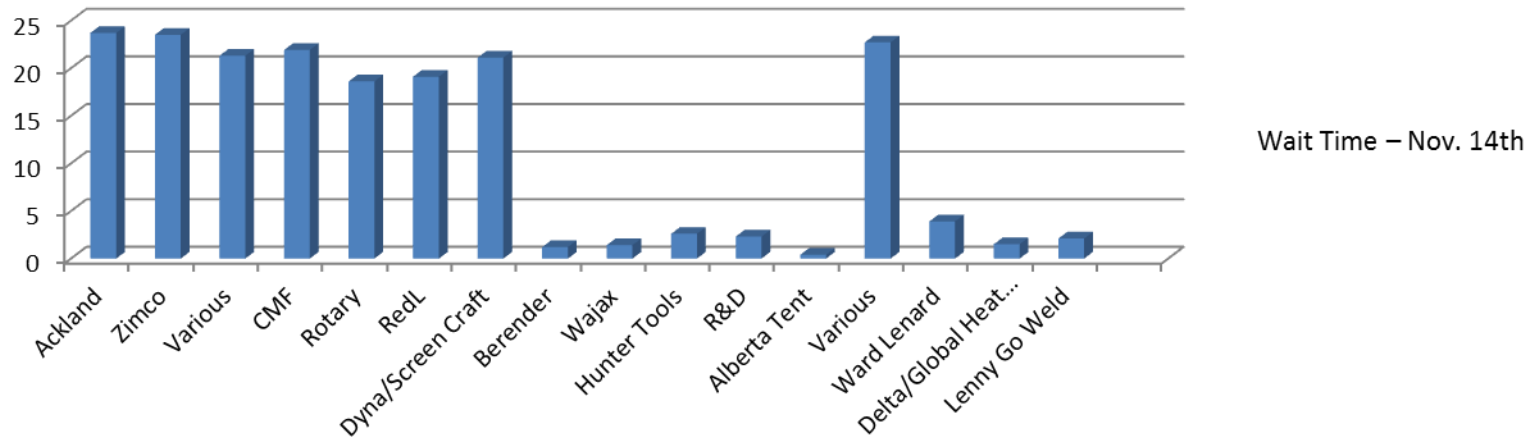
Manpower Utilization – Verifier/Put Away



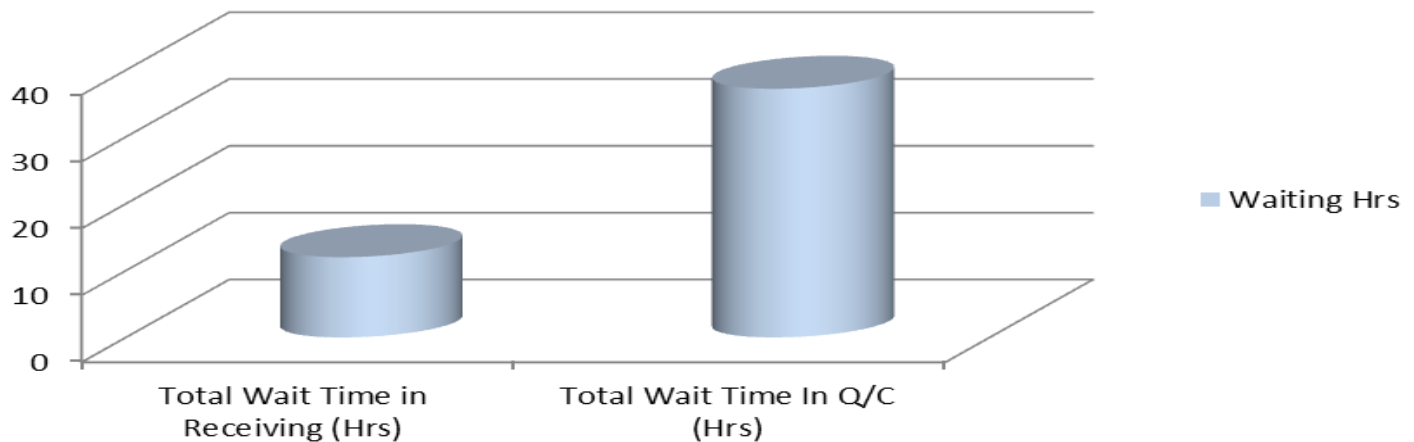
Departmental Late's and Absenteeism



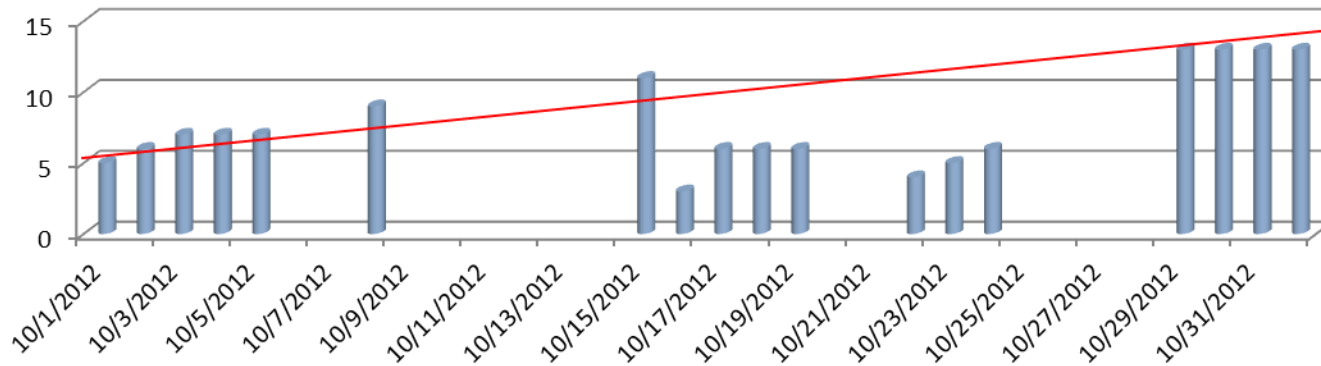
Length of Time Parts Sit On The Dock (Wait Time -Hrs)



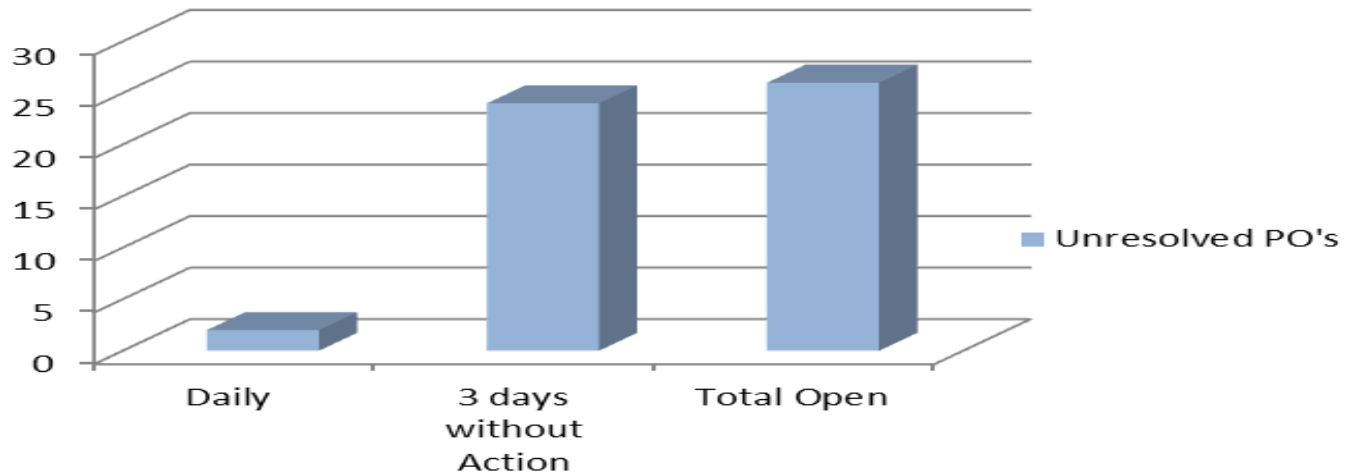
Receiving / Quality Waiting - Moving Average



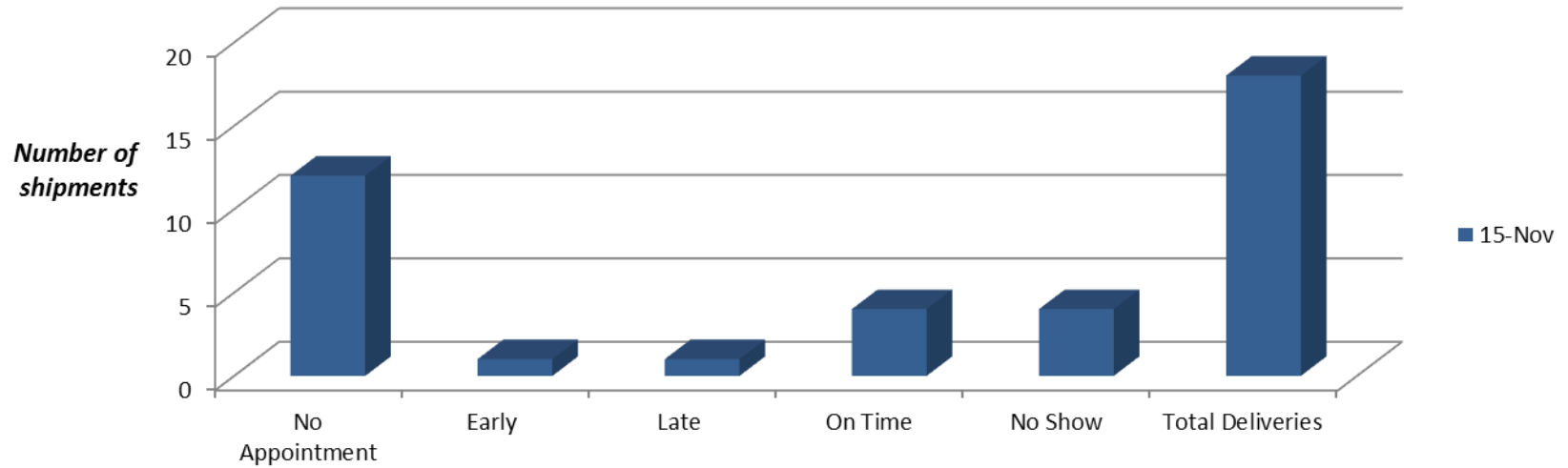
Open Discrepancies Exceeding 3 Days without Action



Unresolved PO's as of 11/13/12

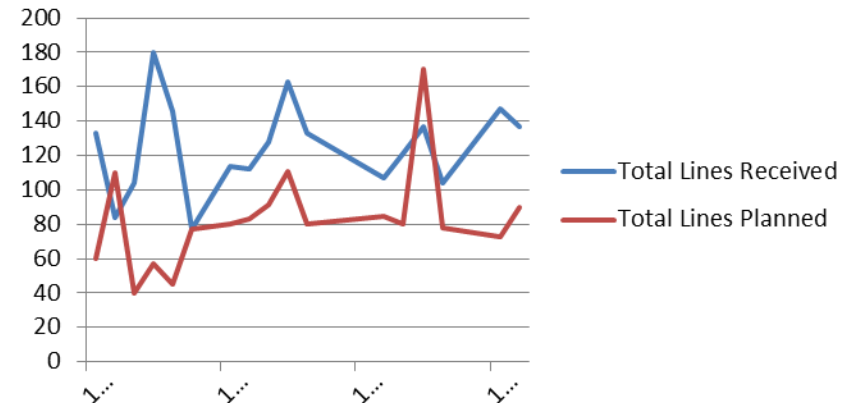
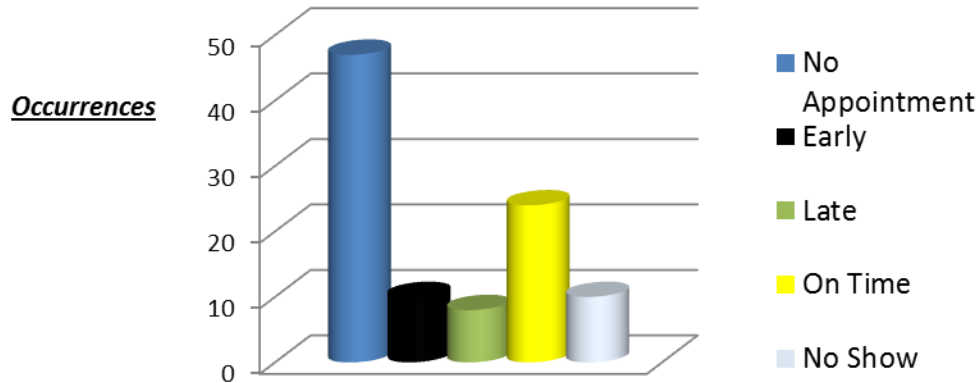


Delivery Performance 11/15/12

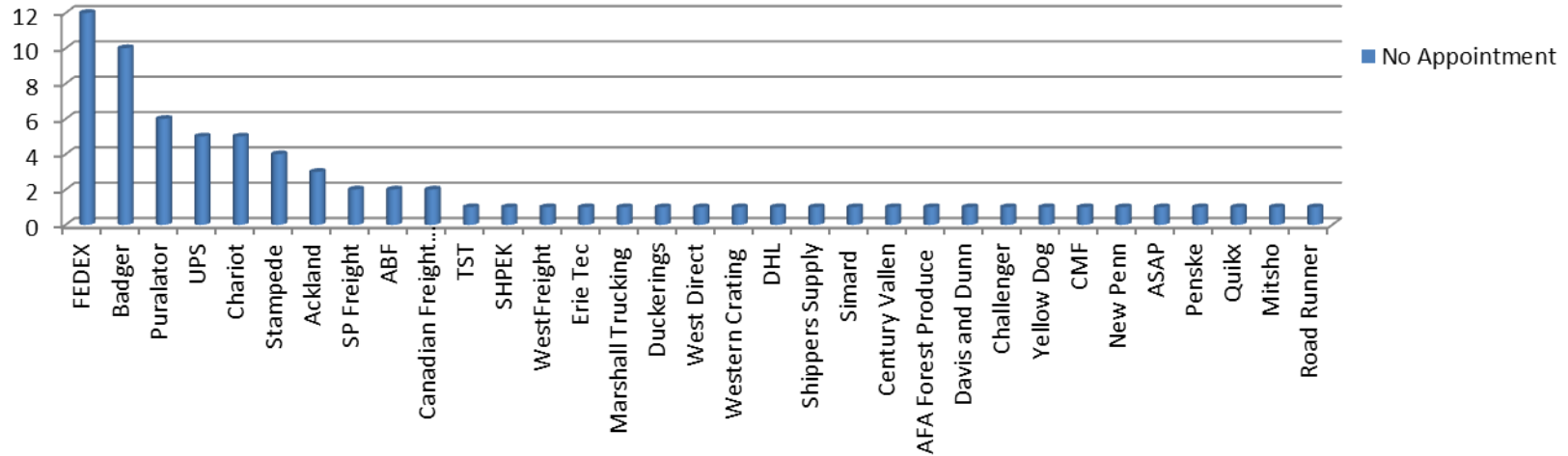


Delivery Performance - Trending

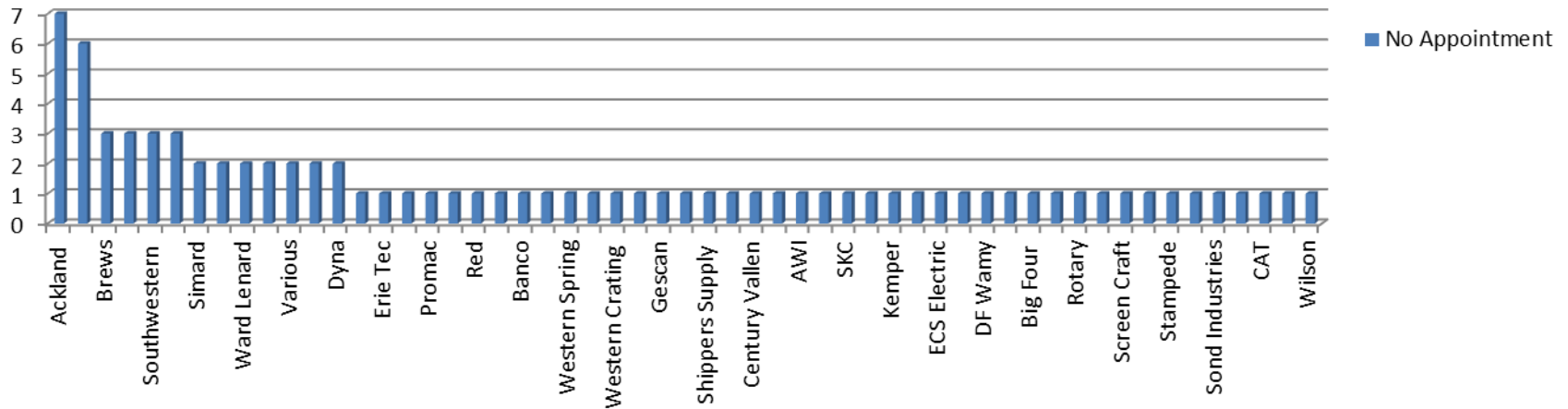
Line Received vs. Lines Planned



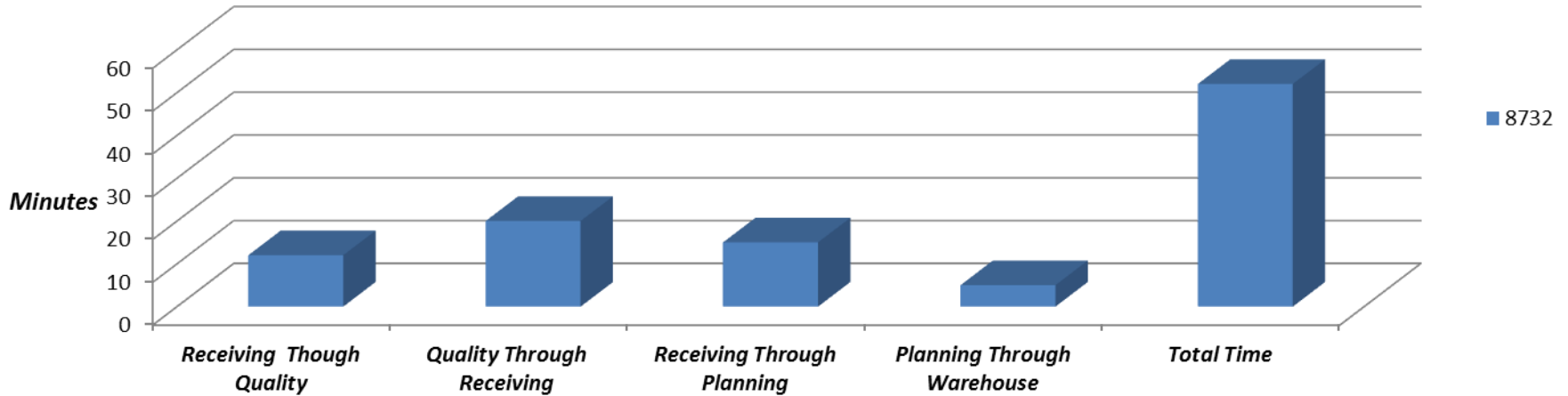
Carrier Delivery Without Appointment



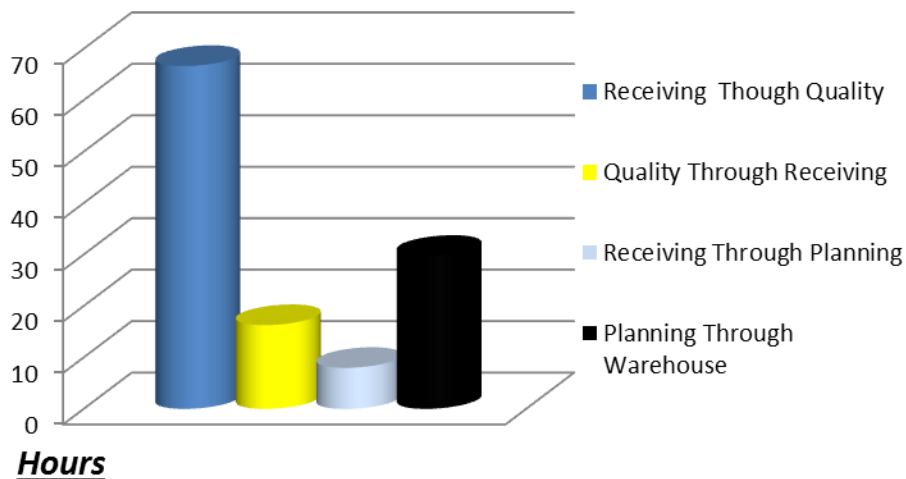
Supplier Delivery Without Appointment



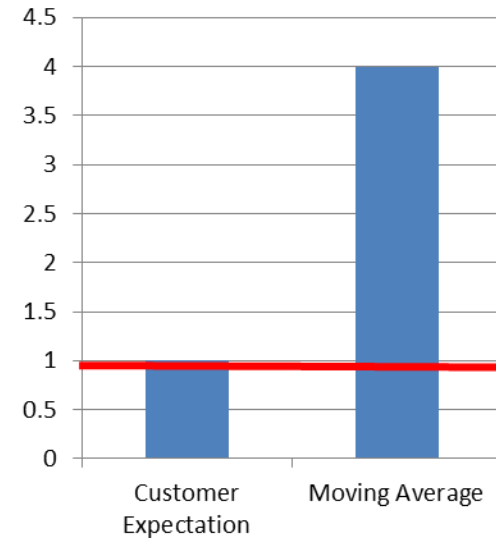
Fast Lane Performance 11/8/2012



Accumulative Hours Nov.6 - Nov. 16



Moving Average



QUESTIONS
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