Lesson Worksheet: Standardized Work

Record Cycle Times & Data:

Run 1:
End Time: _____.

Instructions used:_____.

Does the product look like the picture on the final page (22) of the instruction set?
Is the colors and pieces correct? (If you can't tell, record the reason(s))

Run 2:

End Time: _____.

Instructions used:_____.

Does the product look like the picture on the final page (22) of the instruction set?
Is the colors and pieces correct? (If you can't tell, record the reason(s))

1. Compare times. Was there a large difference in the two cycle times? Why or why not?

2. Say your workstation is working at a plane production plant and you have a customer demand of 50 planes this week. Given the limitations of your available equipment, you only have 2 hours each day to produce all of the planes for your customers, and the plant is only open for 5 days a week. Calculate the Takt Time for the planes (in minutes per plane).

3. How do the cycle times from the production runs compare to your calculated takt time from question 2? Is this a good thing or a bad thing? Should something be done to the cycle times? What and why?

4. Is there a difference in quality between the two runs? What caused the quality issues in each run? Use the provided pictures to identify any defects on the plane from your second run to help with this question.

5. Is there any WIP (work-in-progress) at the end of the run?

#1: Yes or No

#2: Yes or No

6. Say that you received another order to make 10 planes today, for your group only. If you already had a lot of WIP at station #3 for a *different and larger* order, what possible reasons could negatively affect your ability to finish the order on time and why?

7. If you were in charge of creating the instructions for this Lego plane what would you add, subtract, change, or keep so that workers could make it faster, and have high quality? Then how would you distribute the instructions to the workers (what part would station 1, 2, 3 and 4 get)? (Create a list)

Finished Plane Diagrams 1 & 2