Process Study Sheet

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Kaizen Express



Example of Process Study Sheet (作業分析の例)

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	A. Landa	Process:		Product:	luct					Obs	Observer:	er:	Date/Time:	ie:	Page
Frocess Study	Stuay	Final Assembly #7			DV.	DV-020332	3337	2			,	Benny	April 18	April 18, 2007 14:00	1/3
				OP	ERA	OPERATOR	~						MACHINE	,,,,	
Process	Work F	Work Flement			0	psel	rvec	Observed Times	nes						
oteba			-	ณ	ო	4	വ	9	7	ω	0	10 Repeatable		Notes	6
Assembly 1	Get bas	Get base & put into fixture	4	2	9	B	4	4	4	4	2	4 4		Base far away	
	Get pin	Get pin & put into fixture	9	8	10	15	6	10 10		7 1	11 10	01 0		Fixture unstable	e)le
	Put fixt	Put fixture into machine	7	0	1	7	7	8	7			2			
	Machin	Machine cycle	1	1	_							1	9	Operator waiting	ing
	Remove	6	2	7	7	1	7	7				2			
	Check :	Check appearance & place	8	11	8	20	7	8	6	6	3 6	8 8		Checking unstable	table
	Subtotal (Jø										27			
Assembly 2	Get low	Get lower case Timing Tip	Sdi	—	,	— ,	-	-,				·			
	Get wo	Get work piece • Collect real times at the process.	real	time	s at	the	proc	sess	الم						
	Put into	Put into lower case • Position	J yor	rsell	So	you	can	see	the	obe	rato	 Position yourself so you can see the operator's hand motions. 	ons.	Insertion unstable	able
	Get upt	Get upper case & Time each work element separately. • Time several cycles of each work element.	ach v	ork S	elen	nent of ex	sek	vor	tely. k ele	me	ŧ				
	Put inte	Put into forming m • Observe	e an	oper	ator	w.	o is	qua	lifie	5	perf	Observe an operator who is qualified to perform the job.		Machine gate far away	far away
	:	 Always separate operator time and machine time. 	seps	ırate	obe	ratc	or tir	ne a	n pu	nac	hine	time.			
	:	Select the lowest repeatable time for each element. Remember shop floor courtesy.	the Ic	wes	t reg	oeat or co	able	tim	le foi	r ea	ch el	ement.			
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