Value Stream Mapping Process Step Data Collection- Manufacturing Operations

Process Name:	**Step #:**
C/T =	**min**
C/O =	**min**
1st Pass Quality Yield% =	**%**
Machine Reliability %=	**%**
Transfer batch Size =	**# Units**
Distance to next Op =	**# Feet**
# Operators Required=	
Shifts available =	
Other:	

Inventory Box

_____# units of physical inventory for part (family)

Queue Box

_____ amount of avaiable production time needed to finish ALL work presently at a station in a FIFO non-expedited disposition.

NOTES:
Triggers: How do I know when to begin the process step for this part?
How is this step linked with upstream and downstream operations?

1st Pass Quality Yield %: When there are defects or other problems, what are they?

DEFECTIVE MATERIAL DEEP DIVE		
a. % Material Scrapped=		**%**
b. % Material Requiring Rework=		**%**
c. Avg. Time required for Rework =		**hrs**

Flow Stoppers, Issues and "Points of Pain": What is stopping flow? What do you need that you don't have? What issues need to be solved?

DEFINITIONS:
C/T (Cycle time)= How often is a part completed by a process (as observed)?

C/O (Change Over)= How much time between the last good piece of the previous run until the first good piece of the new run?

1st Pass Quality Yield %= What percent of the time does the material and process work RIGHT the FIRST TIME in and through? (no defects in or out, nor rework required)

Machine Reliability %= What percent of the time do you go to use this machine and it works properly (vs. doesn't work properly or broken)?

Tranfer batch Size= How many pieces must be produced before the first piece is transferred to the next operation