

# Visual Control



# Visual Control

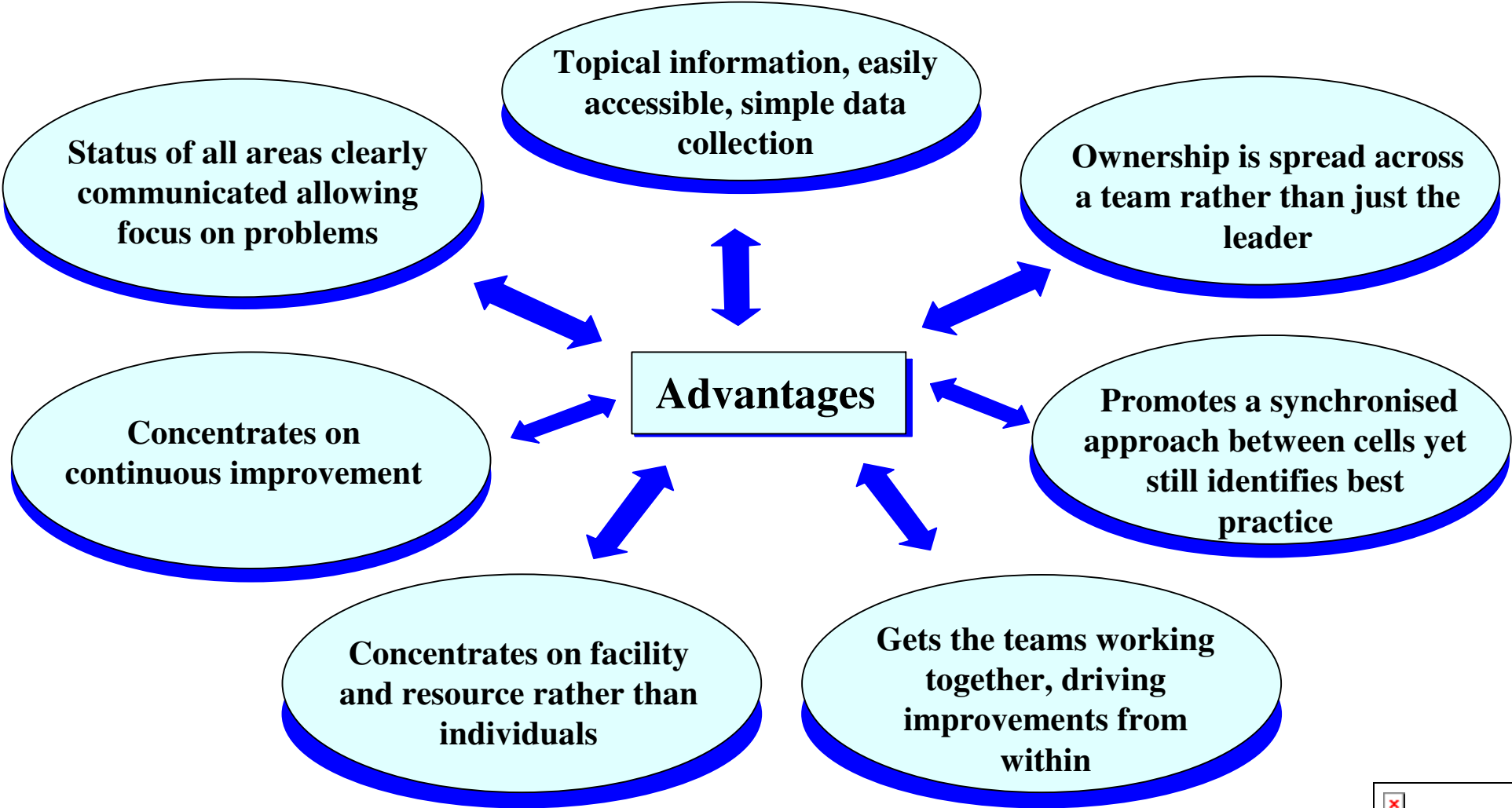


Visual Controls are :-

**Simple, clear and concise visible indicators which show at a glance the status of a machine, a resource, and an entire plant in connection with a plan or definable objective.**



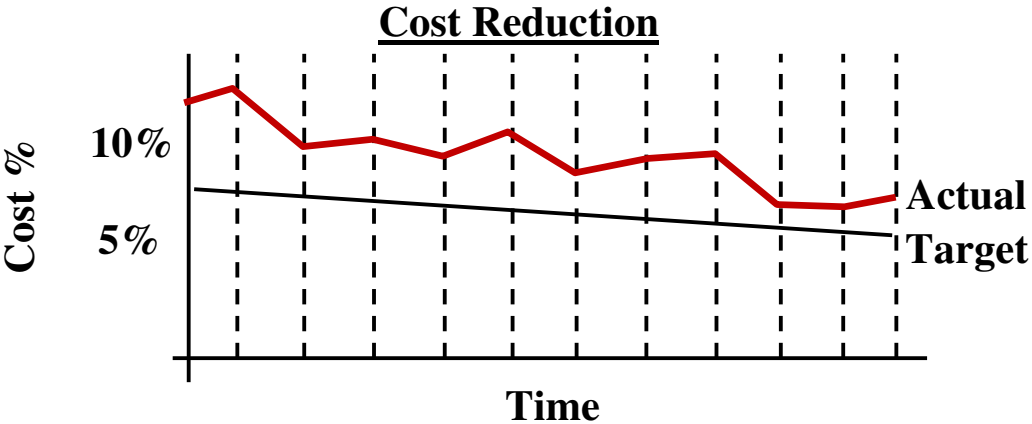
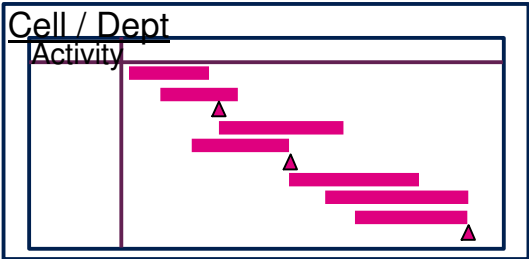
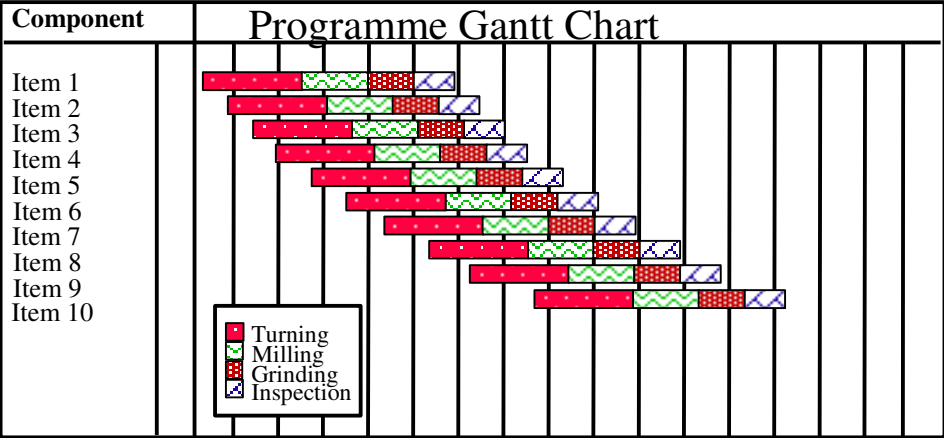
# Visual Control



# Visual Control



## Examples of Visual Controls:



# Visual Control



## Skills Matrices

Examples of Visual Controls :

-  - No Training
-  - Planned Training
-  - Gaining Experience
-  - Fully Trained

	Joe Bloggs	Bill Door	Sam Grimes	Mike Jones	John Petal	Hugh King	Paul Smith	Jim Smart
Marking								
Degrease								
Alochrome								
Anodise								
Flaw detect								
Stripping								
Spray								
Masking								

## Allows :

- Quick identification of available current skills.
- Management to deploy workforce where required.
- The workforce to be provided with additional relevant skills in a timely manner.
- The workforce to be as flexible as possible.



# Visual Control



## Production Control

Examples of Visual Controls :

Part Description - ANT Shaft		Date :- 10 September 1998		Daily Target:- 400 Items				
Part Number - ANT 32561								
Time	Target Quantity	Accumulated Target Quantity	Actual Quantity	Accumulated Actual Quantity	Loss	Accumulated Loss	Remarks	Actions
08:00 - 09:00	60	60	60	60	0			
09:00 - 10:00	60	120	50	110	10	10	Fault material	Change batch material
10:00 - 11:00	40	160	44	154	0	6	Regained 4 items	
11:00 - 12:00	60	220	56	210	4	10	4 items scrapped	Tool set changed
12:00 - 13:00	20	240	20	230	0	10		
13:00 - 14:00	60	300	65	295	0	5	Regained 5 items	
14:00 - 15:00	40	340	41	336	0	4	Regained 1 item	
15:00 - 16:00	60	400	52	388	8	12	Dia (c) out of tolerance	Tool set changed
Overtime			12	400		0		
TOTAL ITEMS PRODUCED :- 400								

Enables quantification of over spend (eg. material, labour etc.)

*Targets taken from customer schedules*



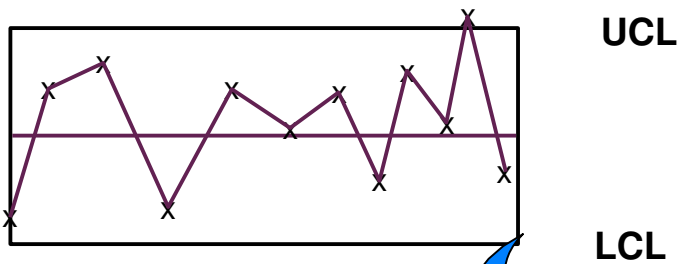
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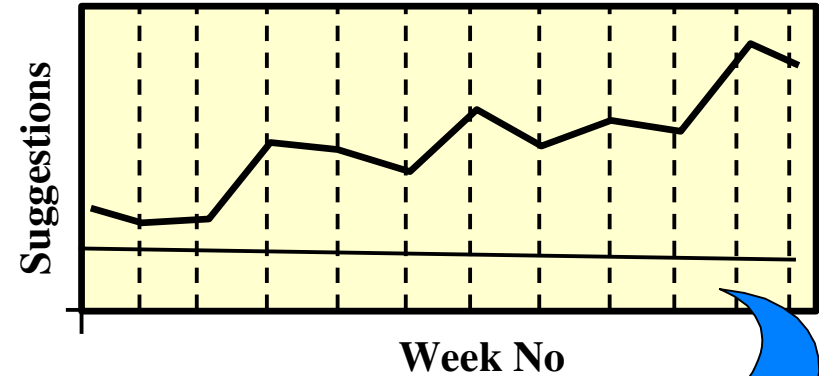
## Quality / Defects

Examples of Visual Controls :

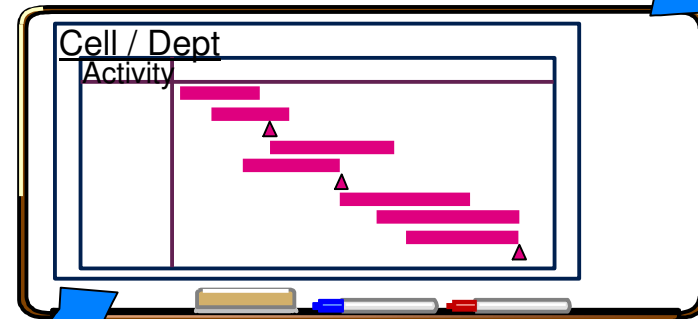
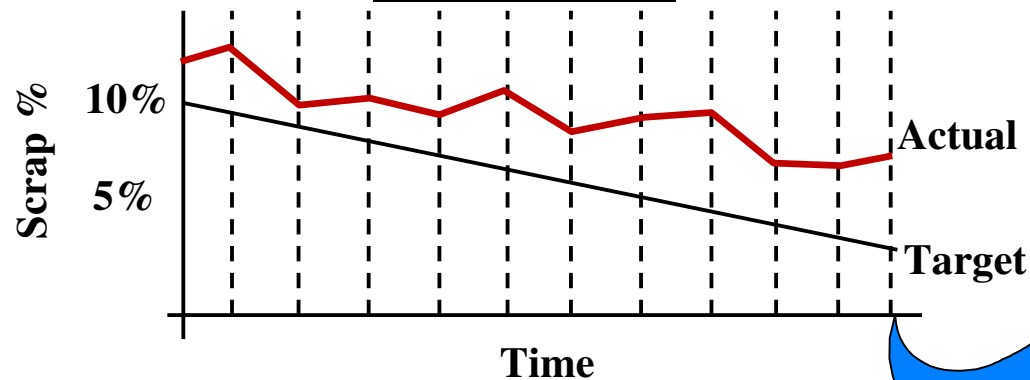
Statistical Process Control



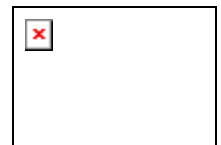
Quality Improvements



Material Defects



Backed-up by an action plan to reduce Defects

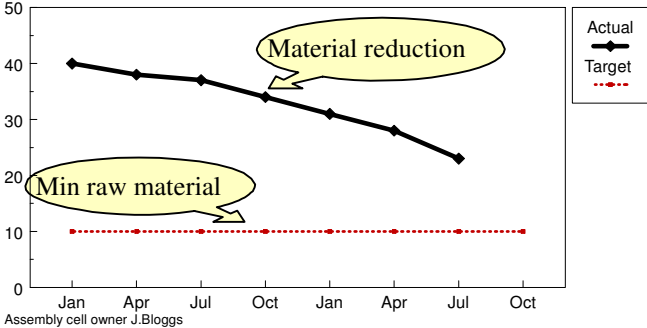


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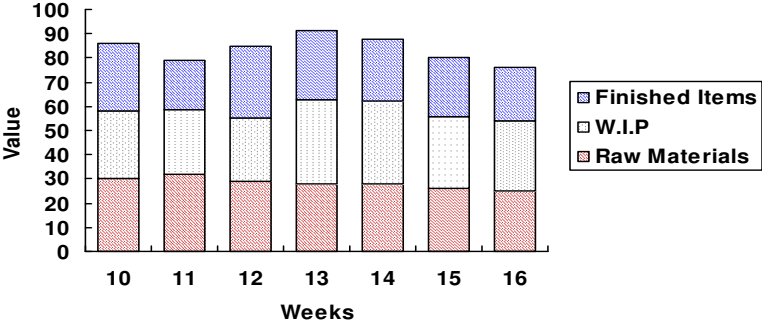


## Inventory

Examples of Visual Controls :



### Material Inventory



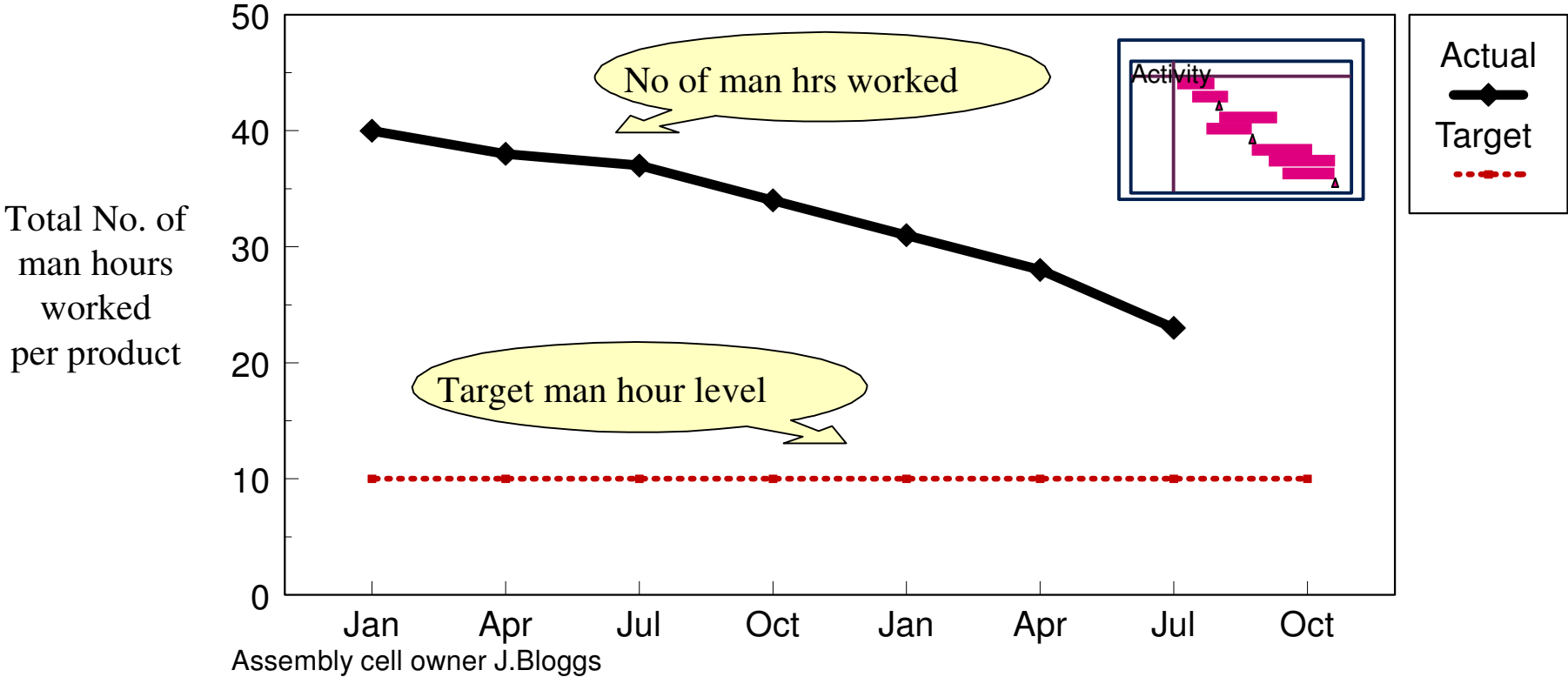


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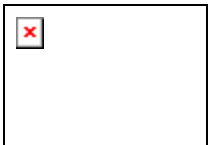


## Man-hour Reduction

Examples of Visual Controls :



# Job Standardisation



# Job Standardisation

## What is Job Standardisation?

- A formalised method of documenting procedures, tasks, and times - relating to man, machines and materials.
- More than a set of job instructions.
- Enables everyone to understand the instructions involved.
- A process that involves the whole team in the development of standards.
- A method which ensures repeatability of the manufacturing process

➔ **The foundation for improvement**



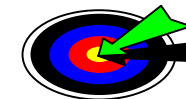
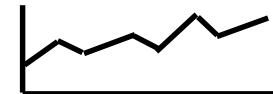
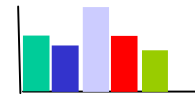
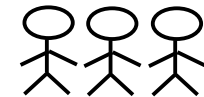
# Job Standardisation

## Why ?

Method and time are fundamental to :

- Product costing
- Man-hour / manpower planning
- Capacity planning
- Scheduling
- Performance analysis / review
- Target setting

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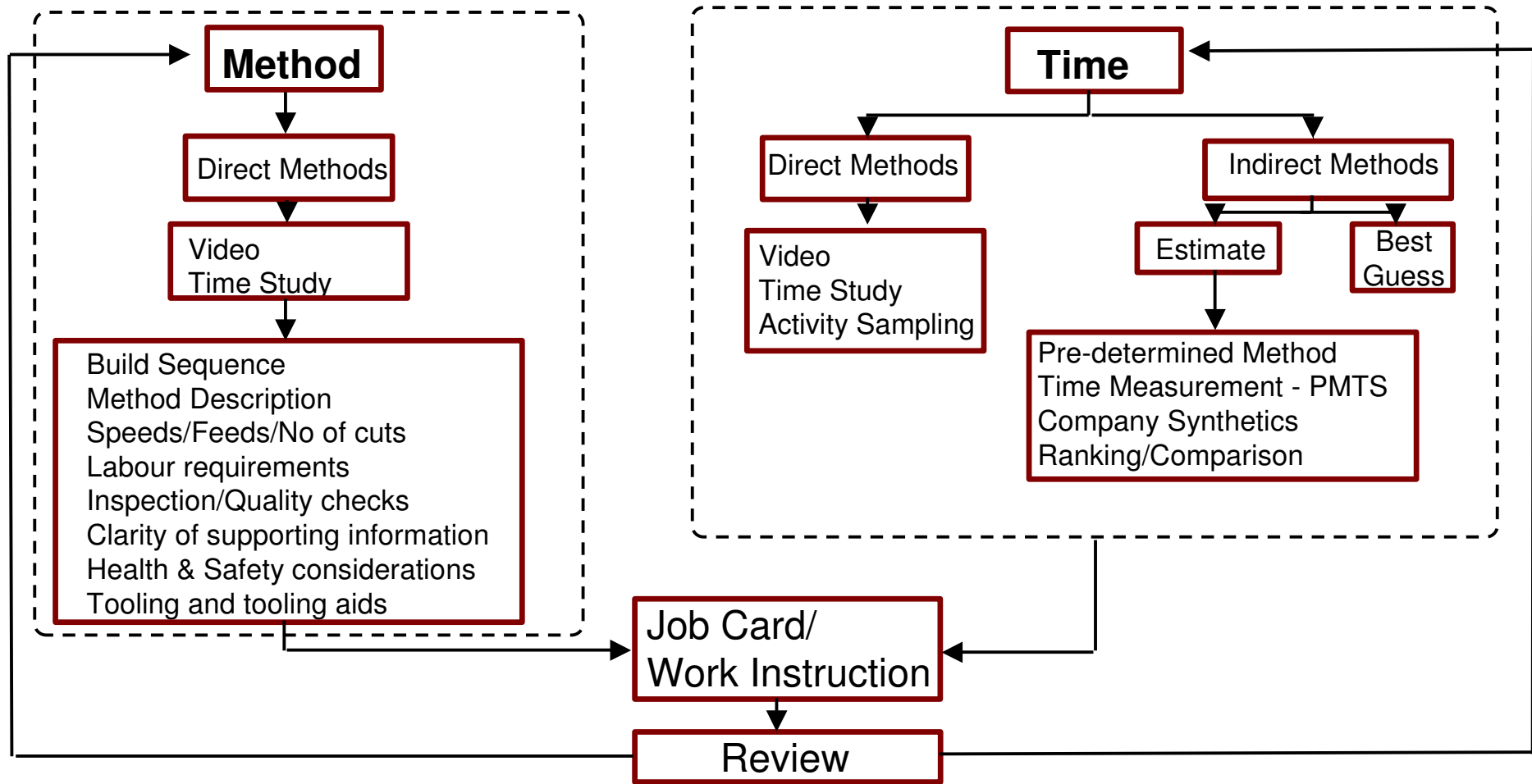
# Job Standardisation

## Benefits

- Enables capable and repeatable processes.
- Process control at source.
- Improves accuracy of planning.
- Leads to better adherence to plans.
- Provides a platform from which continuous improvement can be made.
- Reduces costs.
- Improves quality



# Job Standardisation



*Method and time are both essential to job standardisation*



# Job Standardisation

## Review

Example of a low volume / high variety job sheet

Predominantly used low volume industry. e.g. aerospace

All methods must be stamped to indicate that they have been correctly carried out.

Deviations from agreed time are usually captured on Shop Floor Data Capture System

Part No : pC564J0001-000			
Part - Hinge pin			
Material - Aluminium / Steel			
Operation No	Time Run/ Set	Method	Stamp
1.0	/	Receive Material	★
2.0	5	Inspect Material	★
3.0	/	Marshall Book in	★
4.0	/	Receive Material	★
5.0	/	Milling :- - Block Up - Mill 2 Rebates - Mill 2" Slot	★



# Job Standardisation

## Review

Example of a high volume / low variety job sheet

- Measures differences in cycle times within the cells.
- Used for analysing any variances.
- Brings a standard approach to walking, handling & machine times, methods, cycle time & work in progress.

