

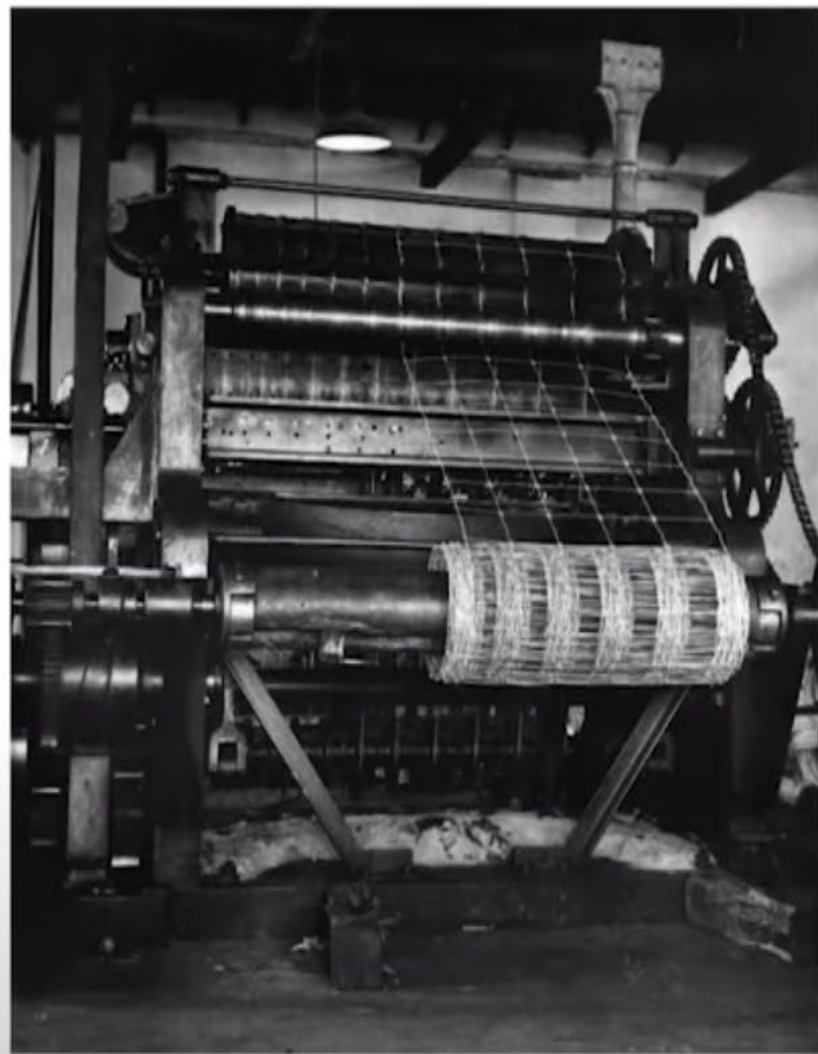


Vår Leanresa

Växjö teamet





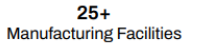
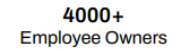


Fabriken i Växjö

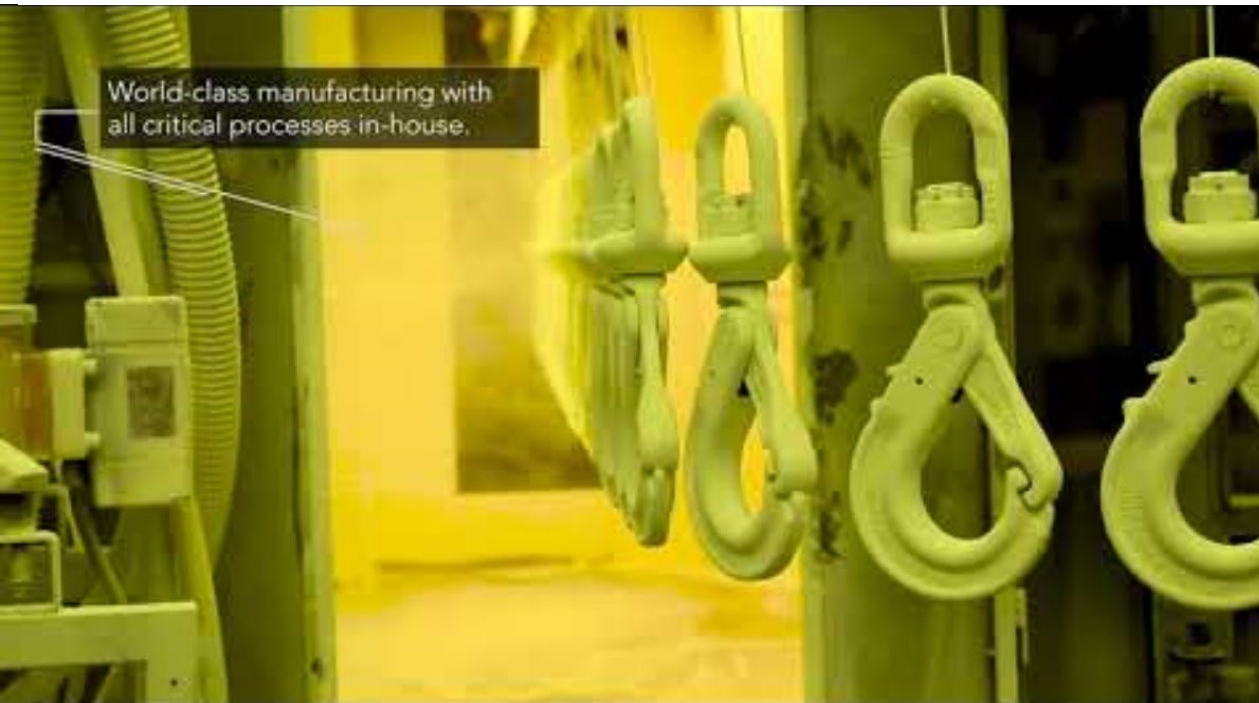


Ca 1,5 miljoner produkter, 300.000 reservdelar

Vilka är Kito Crosby?



Fabriken i Växjö



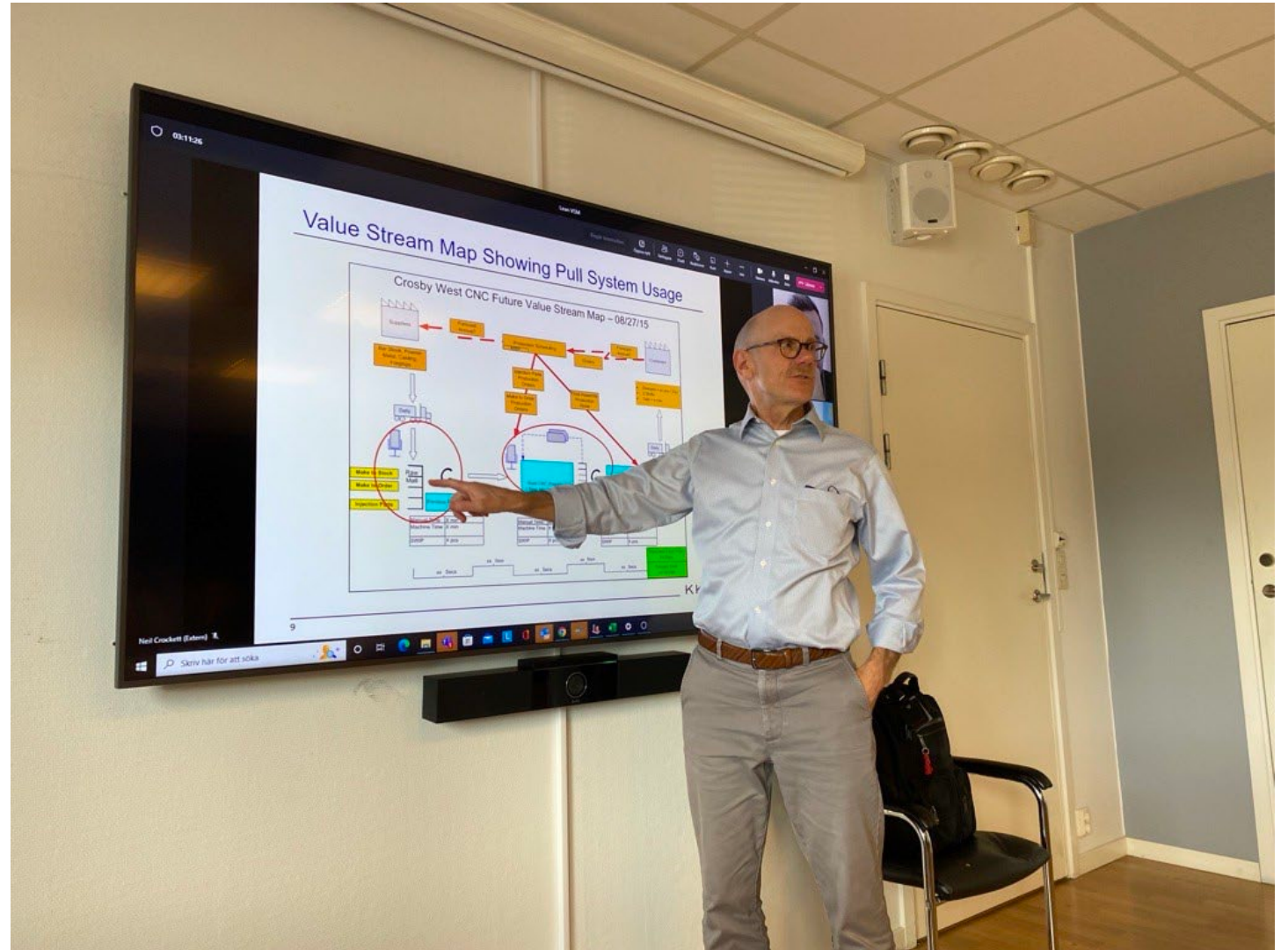
Vad har vi gjort?



VSM



Quote Neil Crockett Lean expert KKR
"-if it hurts you are doing it right"



Val av produktflöde

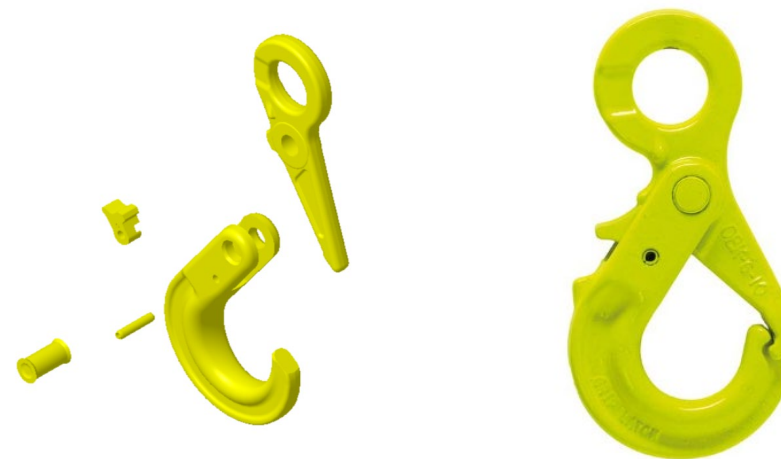
"BK" - Bygg Krok

	Annual demand units		Annual Revenue SEK		CW Stock level		Semi finished stock value		VOC (Customer) Quality issues		Internal Quality Issues (Scrap \$ is option)		Labor intensity HC Forge		Labor intensity HC Post forging		RANKIN G TOTAL	
	Value	Ranking	Value	Ranking	Value	Ranking	Value	Ranking	Value	Ranking	Value	Ranking	Value	Ranking	Value	Ranking		
Gaffel	259 911	3	23 629 343,00 kr	3	0	1	1 696 722,00 kr	3	Low	1	Med	3	10	3	11	3	729	10
Grabiq Duo	52 793	1	10 169 487,00 kr	1	0	1	297 533,00 kr	1	Med	3	Med	3	2	1	2	1	9	2
Lifting point assembly	178 980	1	29 844 662,00 kr	3	0	1	7 152 300,00 kr	5	High	5	low	1	7	1	8	1	75	7
Bk Hooks	344 369	5	79 430 639,00 kr	5	0	1	10 304 209,00 kr	5	High	5	High	5	13	3	15	5	46 875	13
Master Links total	249655	3	26 983 643,00 kr	3	0	1	1 176 770,00 kr	3	Med	3	Med	3	10	3	11	3	2 187	10
G links	557 798	5	50 050 545,00 kr	5	0	1	3 653 247,00 kr	3	Low	1	low	1	21	5	24	5	1 875	21

Dagligt behov – 1288 BK krok

Takt/behov – 45 sekunder, vid 2-skift

120 – varianter



Coaching via Teams varje vecka

The screenshot shows a Microsoft Excel spreadsheet titled "Optimal State Second flow". The spreadsheet is divided into columns A through E. Column A contains the title "Optimal State Second flow". Column B is labeled "Forklift from Supermarket". Column C is labeled "Machining Hook, Latch and Swivel". Column D is labeled "Assemble latch with Swivel". Column E is labeled "Assemble complete".

Below the column headers, there is a table with the following data:

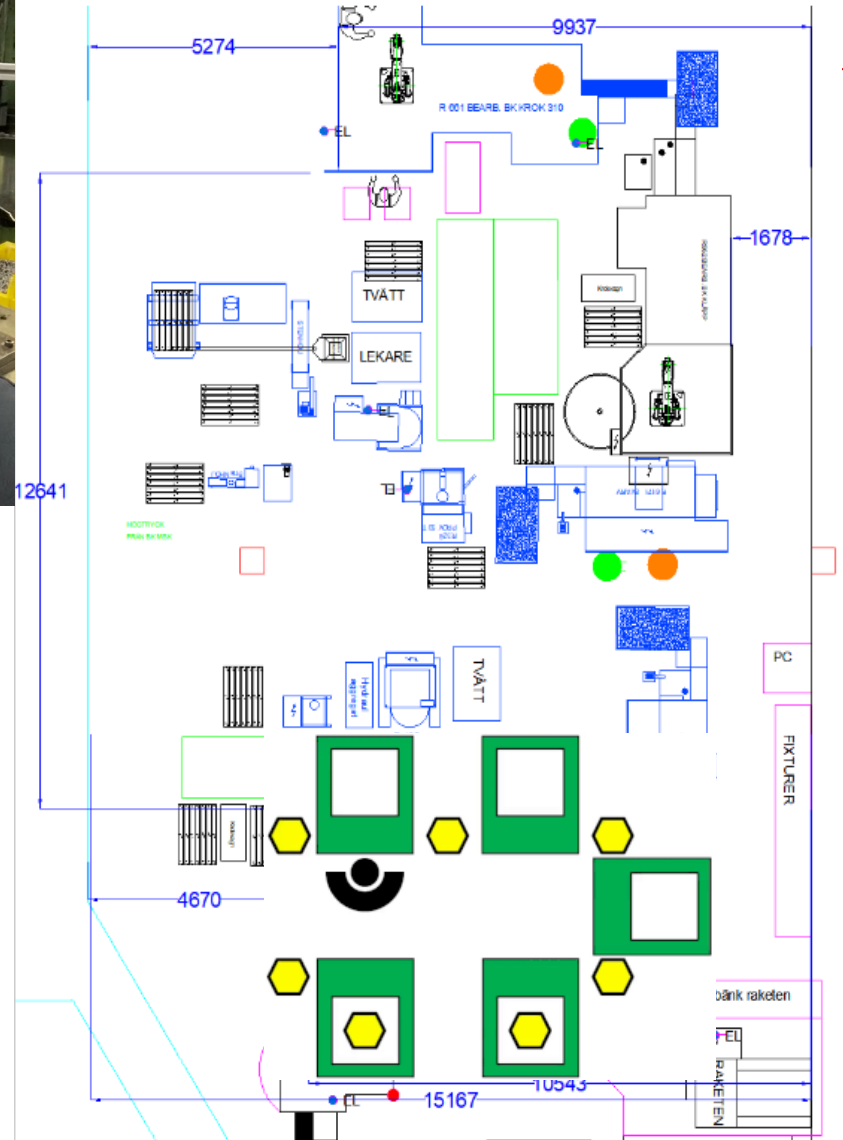
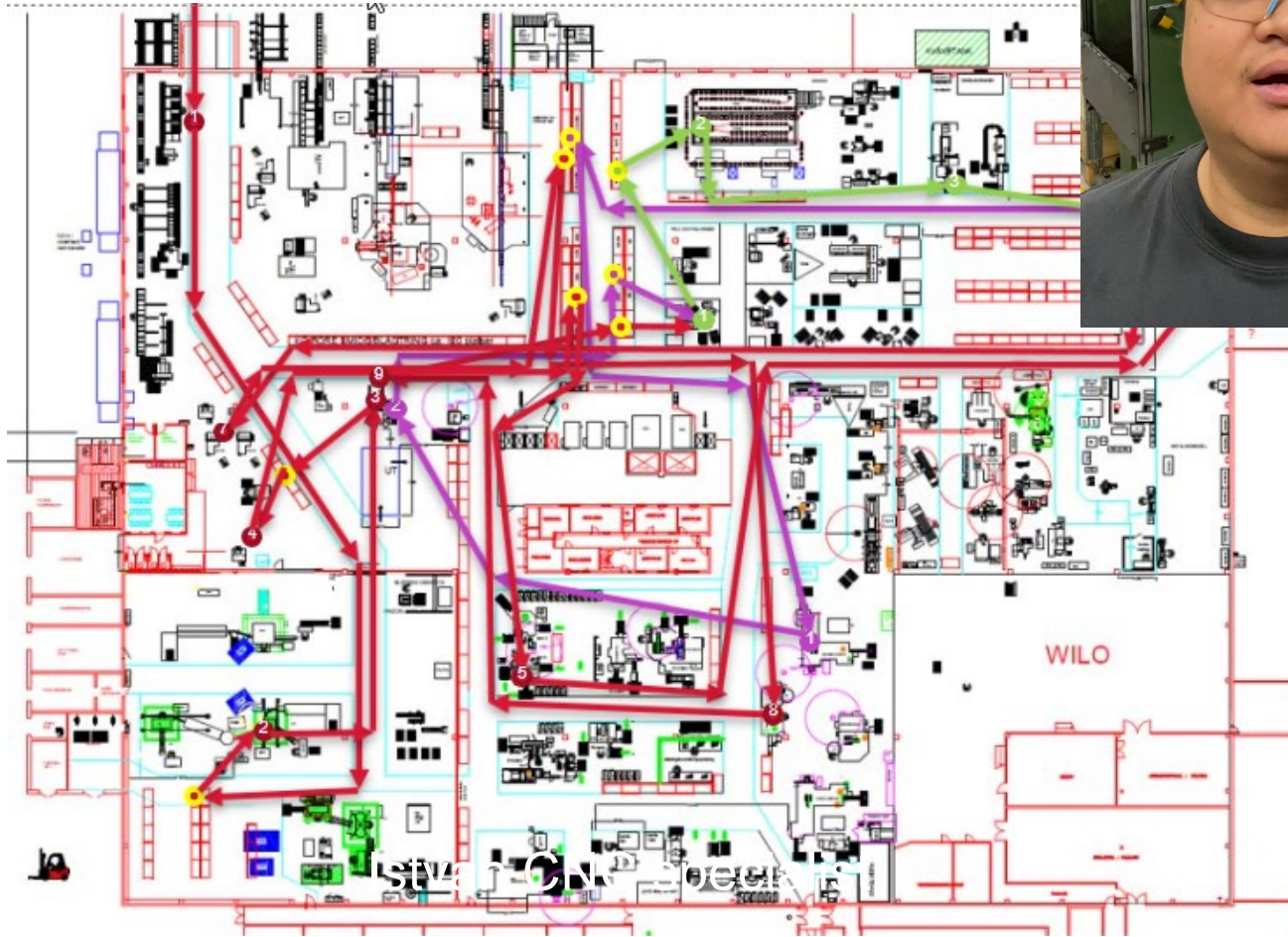
Machine	Machine - R952
Product	Latch GBK 10-10
Machine time	113
Machine Value added time	36
Manual time	8
Cycle time	24
Cycle time SAP Max	65,5
Cycle time SAP Min	21
Change over time	

Two yellow sticky notes are attached to the right side of the table:

- Clean** (with handwritten text "Self-aligning")
- Paint and Pack** (with handwritten text "Bulk")

The Teams video call overlay on the right shows three participants: a man in the top window, a man in the middle window, and a man in the bottom window. The bottom window also shows a profile card for "CP Carolina Pettersson".

Enstycksflöde



Batchproduktion



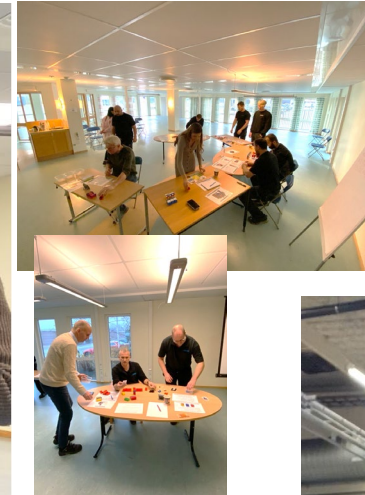
Smidda halvfabrikat



Batchproduktion



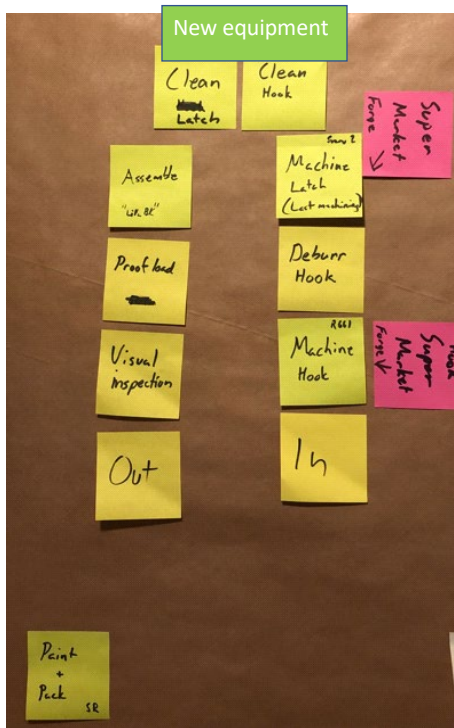
Lean spel



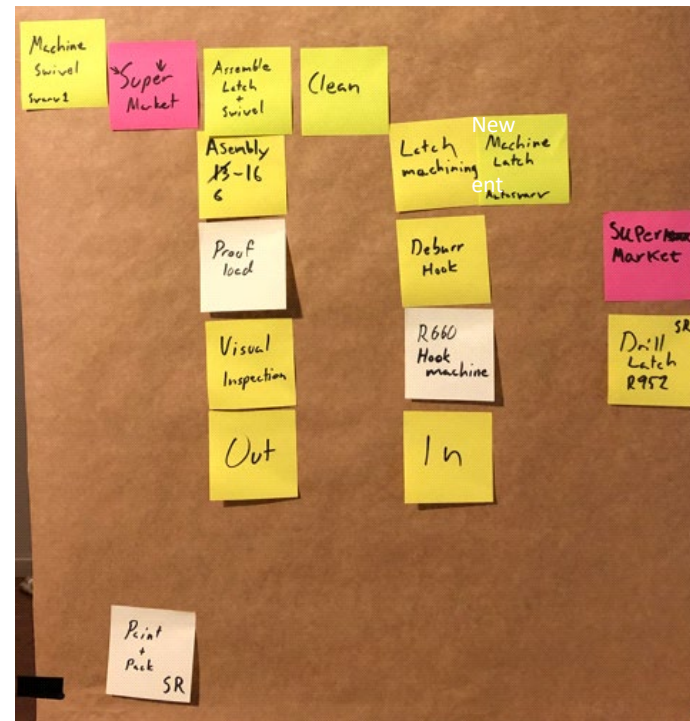
Istvan CNC
specialist

Cell design, brainstorming

Resultat från många timmar brainstorming, tre olika celler med produktgrupper baserade på 9 block analys och “process a glance”.



A

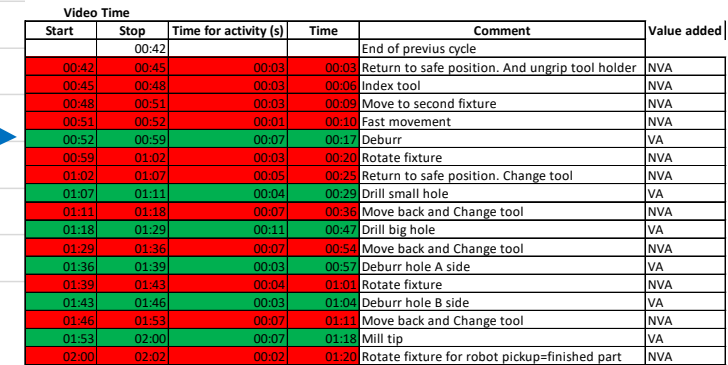


B



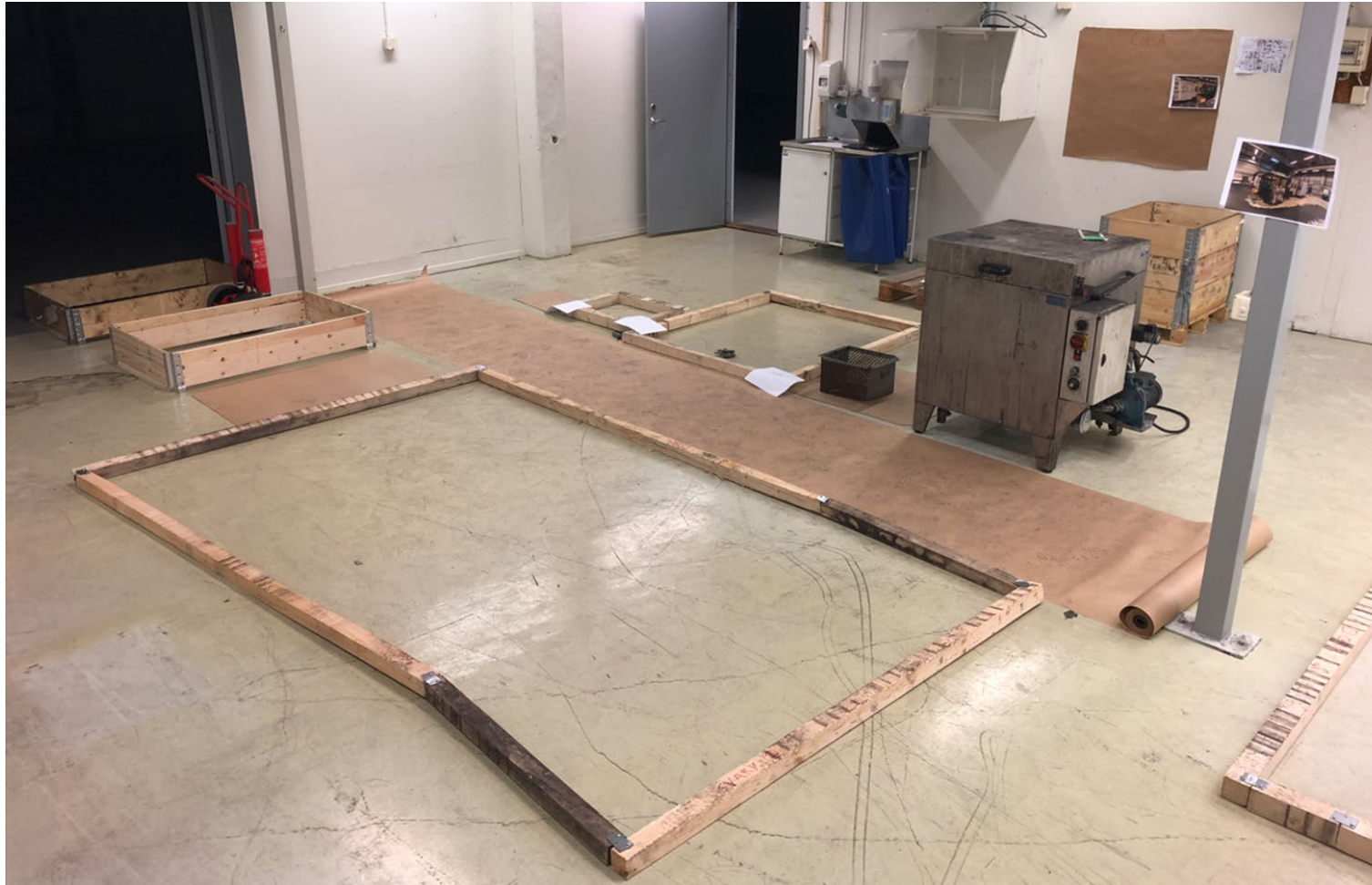
C

			Takt			Top end latch			
Production line A-B-C	Dayly demand	Nr. sku's	1-shift	2-shift	3-shifts	Dayly demand Swivel (threaded latch)	Dayly demand Drilled	Yearly demand	Cogs
A (size 6-10)	697	26	39	77	116	0	445	160 307	21 828 917
B (size 13-16)	548	71	49	98	148	357	100	125 975	33 656 411
C (size 18-32)	54	26	501	1002	1503	21	19	12 395	11 603 527
	1299							298 677	67 088 855

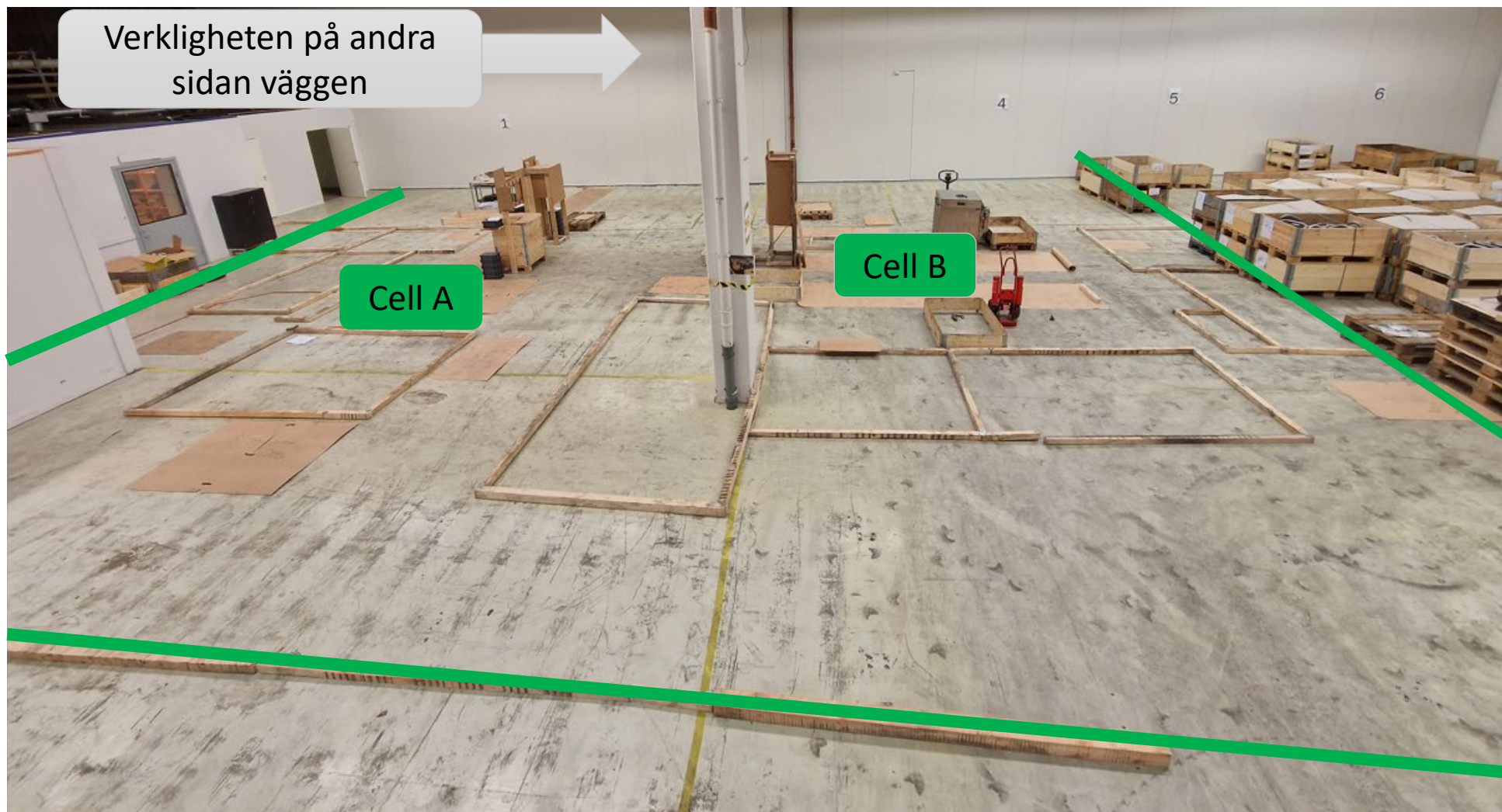


Vår första Mock-up

Cell A, bara en liten del av totala processen



Mock-up hela området



Vi börjar träna Mock-up 1.0



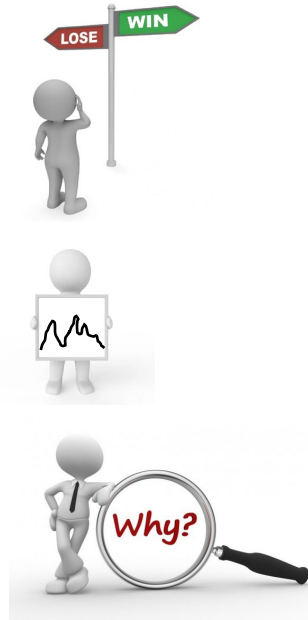
Mockup 2.0



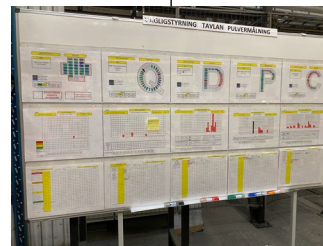
Hur det blev



Taylor – Daglig styrning



Område



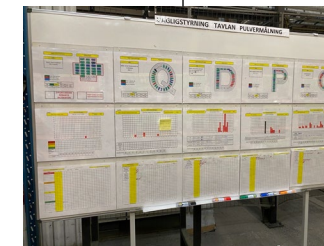
Område



Område



Område



Område



Område

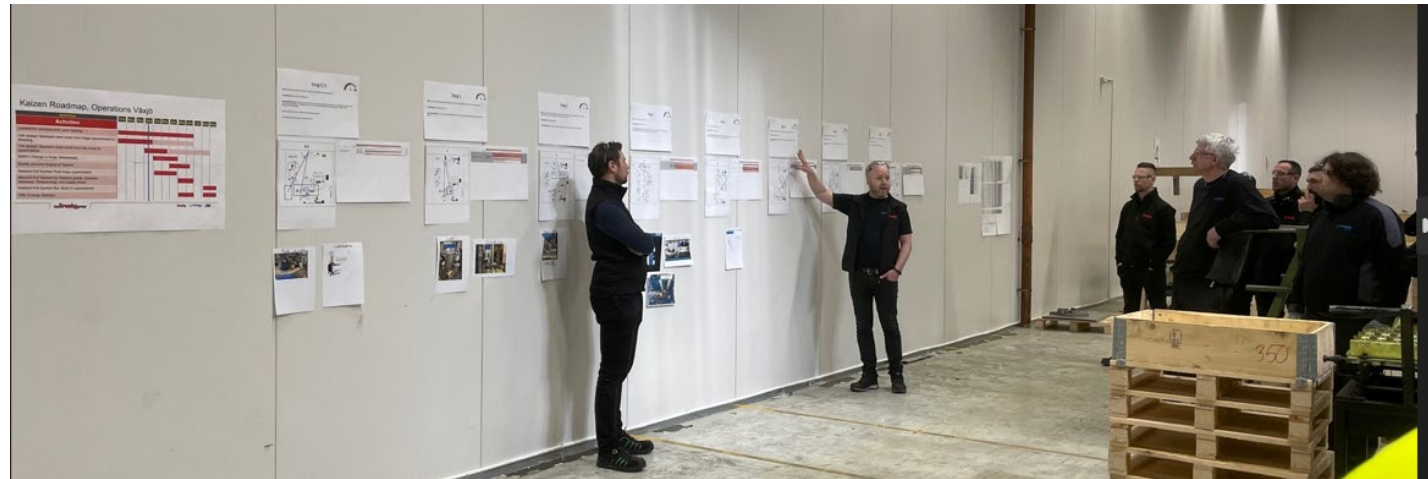
Utmana gamla sanningar



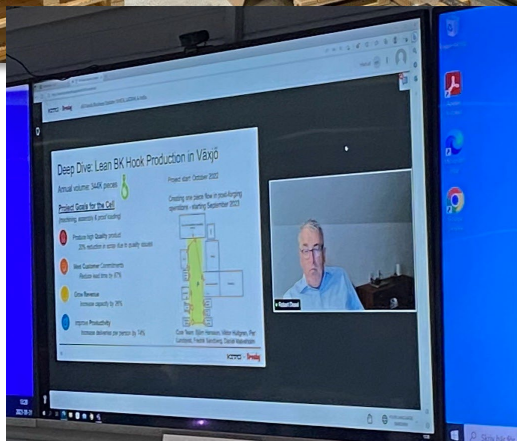
- *Det går inte sänka CT i befintliga maskiner*
- *Allt går inte att bearbeta härdat!*
- *Det går inte att inte köra enstycksflöde, man måste ha en buffert.*
- *Det går inte köra stl 16 i mellanmontering*
- *Vi måste samborra BKLK.*
- *Det måste vara en robot som flyttar detaljer*
- *Tvätt är omöjligt, man måste blästra detaljerna*
- *Vi kan inte hantera halvpallar i fabriken.*
- *Vi kommer alltid behöva omarbета detaljerna efter montering.*

Involvera brett

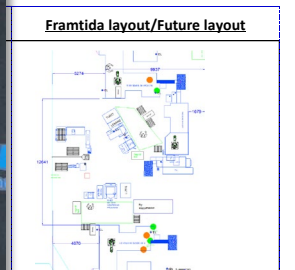
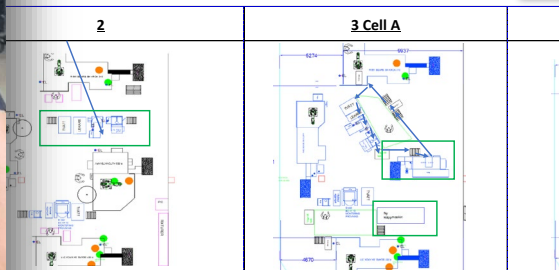
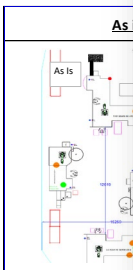
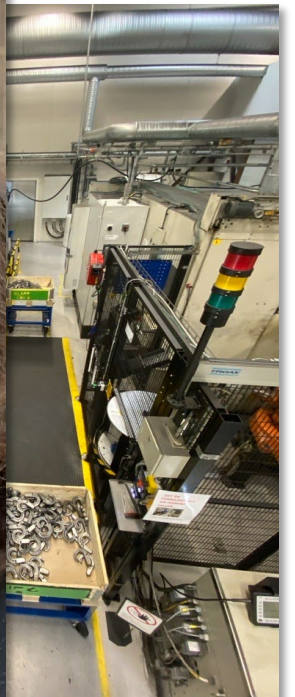
- Utmana gamla sanningar – Exempelvis tvätt istället för bläster
- Involvera med mycket visuella hjälpmedel.
- Mockup för träning och utvärdering, ovärderligt hjälpmedel
- Utvärdera med operatörer, testa och repetera.



Ledningens intresse/support

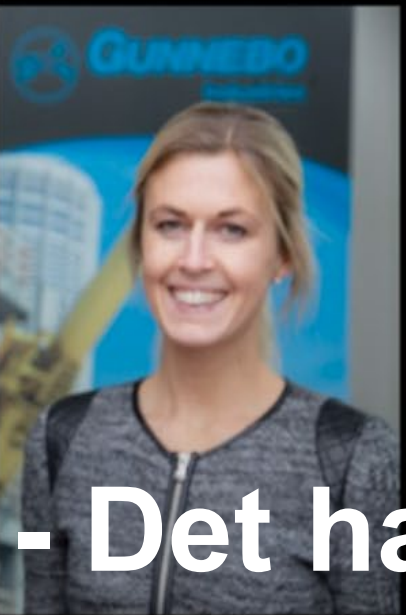


Summering



alisera / Testa / Repetera

Utföra



- Det har blivit jäkligt bra här faktiskt. /Anton

1764

1850

2024



Raise your world

