



Kaizen Breakthrough Experience, October 5-9, 2009

Sponsored by TBM Consulting Group, Inc.

Hosted by Carlisle Tire and Wheel, Aiken, SC

Team #1 - Shop Floor Event: Setup Reduction Weld Cells

Carlisle Tire and Wheel Aiken, SC has 14 weld cells that have two processes consisting of a CSC welder and a four post press. There have been two kaizen events in the weld area, one on the K – 1 Weld Line 5 and one on the K – 2 Weld Lines 1,2,3. During these events, the teams focused on going from batch to one-piece-flow, introducing tack time and 5s. Floor space reduction, productivity increases, head count reduction and standard work implementation were also achieved.

Goals:

- Set-Up reduction by 50%
- Reduce run out rejects by 50%
- Increase productivity
- 2 safety and ergonomic issues per team member
- Improve 5's score by 30%
- Create and implement standard work
- Ensure cell team members are trained on new standard work

Team #2 - Business Process Event: Inventory, Rework and Scrap Reporting

The existing process being used to report inventory, rework, and scrap (IRS) is creating room for mistakes, causing numerous discrepancies and wasted man hours. This team will focus on building a more robust, standardized, and accurate system for reporting, resulting in freed up floor space, optimized manpower, and controlled inventory, rework, and scrap.

Goals:

- Develop a system to report inventory, rework, and scrap
- Develop a system to distinguish the difference between scrap and rework
- Develop a system to reduce repetitive rework
- Create and implement standard work
- Ensure cell team members are trained on new standard work

Please contact TBM to select your preferred project. Bill Swisher is available to answer any questions you may have, or to assist you with your registration. You can reach Bill at bswisher@tbmcg.com or 800-438-5535 x823, or you can register [online](#).