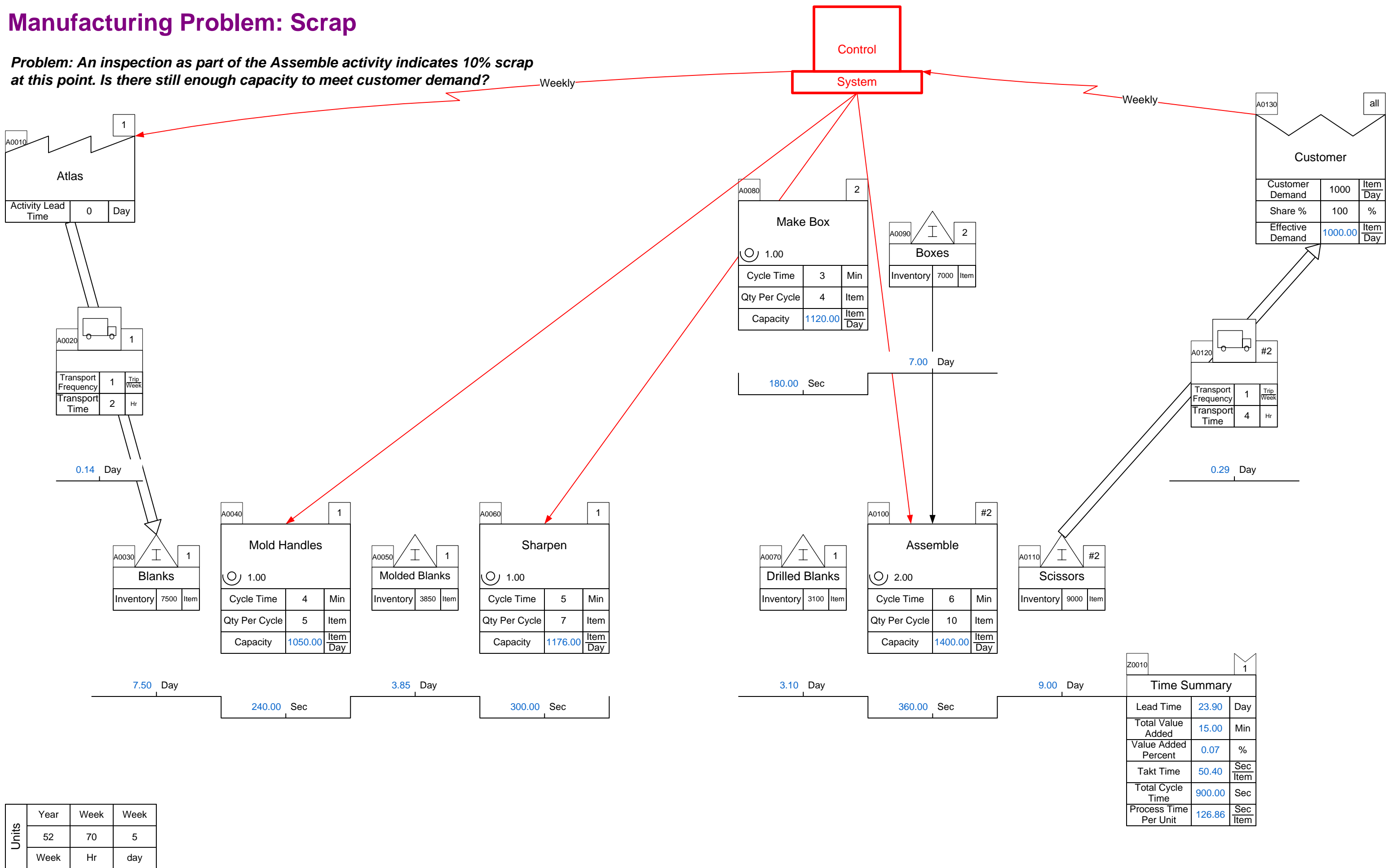


# Manufacturing Problem: Scrap

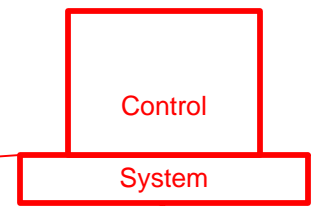
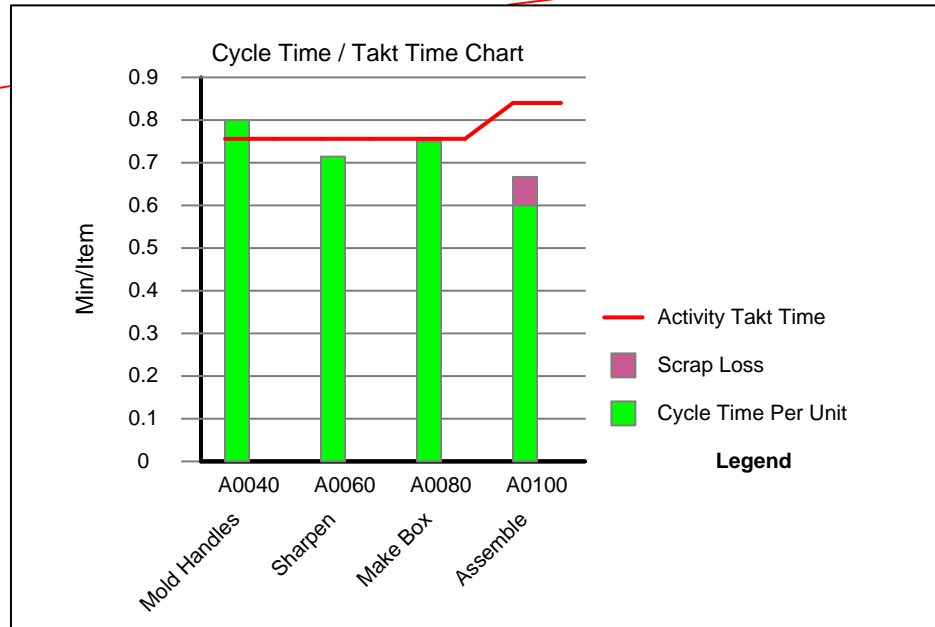
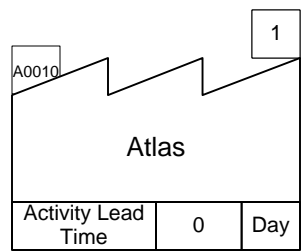
**Problem:** An inspection as part of the Assemble activity indicates 10% scrap at this point. Is there still enough capacity to meet customer demand?



Units	Year	Week	Week
	52	70	5
	Week	Hr	day

# Manufacturing Solution: Scrap

**Problem:** An inspection as part of the Assemble activity indicates 10% scrap at this point. Is there still enough capacity to meet customer demand?



Customer		
Customer Demand	1000	Item Day
Share %	100	%
Effective Demand	1000.00	Item Day

Make Box		
Cycle Time	3	Min
Qty Per Cycle	4	Item
Capacity	1120.00	Item Day
Pre OEE Capacity	1120.00	Item Day
OEE Percent	100.00	%
Activity Takt Time	45.36	Sec Item

Boxes		
Inventory	7000	Item

Transport		
Frequency	1	Trip Week
Time	2	Hr

## Answer:

The Scrap loss at the Mold Handles activity reduces Takt Times upstream such that there is inadequate Capacity.

Mold Handles		
Cycle Time	4	Min
Qty Per Cycle	5	Item
Capacity	1050.00	Item Day
Pre OEE Capacity	1050.00	Item Day
OEE Percent	100.00	%
Activity Takt Time	45.36	Sec Item

Molded Blanks		
Inventory	3850	Item

Sharpen		
Cycle Time	5	Min
Qty Per Cycle	7	Item
Capacity	1176.00	Item Day
Pre OEE Capacity	1176.00	Item Day
OEE Percent	100.00	%
Activity Takt Time	45.36	Sec Item

Assemble		
Cycle Time	6	Min
Qty Per Cycle	10	Item
Capacity	1260.00	Item Day
Pre OEE Capacity	1400.00	Item Day
OEE Percent	90.00	%
Activity Takt Time	50.40	Sec Item
Scrap Percent	10	%

Scissors		
Inventory	9000	Item

Time Summary		
Lead Time	23.90	Day
Total Value Added	15.00	Min
Value Added Percent	0.07	%
Takt Time	50.40	Sec Item
Total Cycle Time	900.00	Sec
Process Time Per Unit	126.86	Sec Item

Units	Year	We	7.50	Day
	52	70	5	
	Week	Hr	day	

