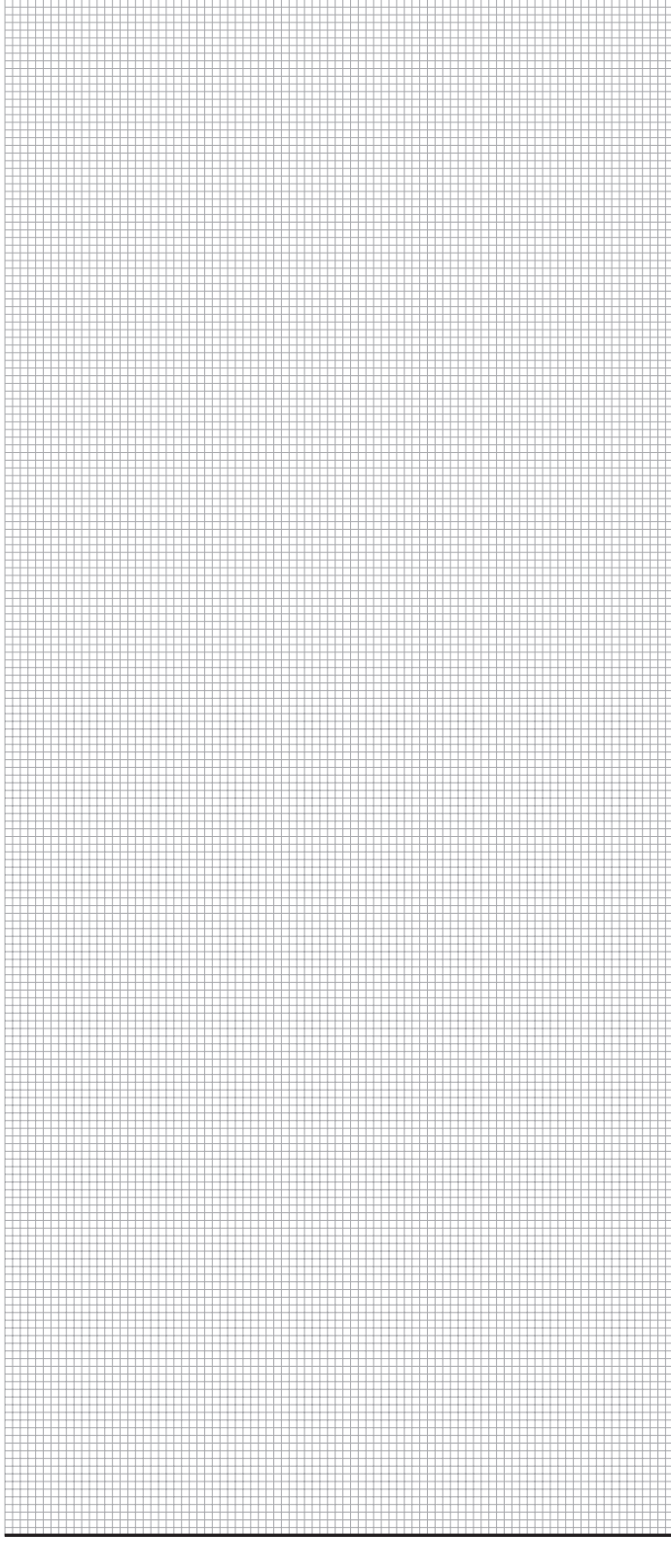


Operator Balance Chart (OBC)

Process:	Product:	Takt Time:	Date/Time:	Notes
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① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨

Process																			
Time																			

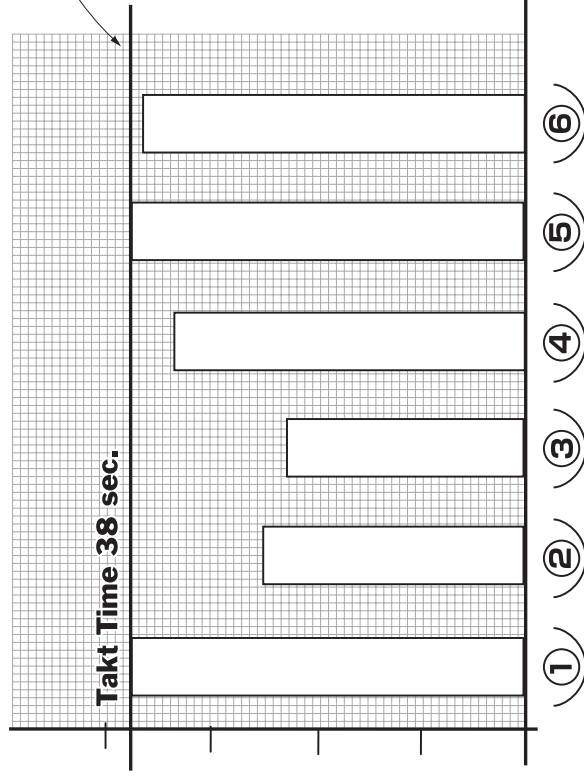
Kaizen Express

Example of Operator Balance Chart (OBC) (作業者バランスチャートの例)

Process: Final Assembly #7	Product: AB010	Takt Time: 38	Date/Time: Mar. 20, 2007	Notes: Kaizen Workshop #10 Operator Saving: 1
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タクトタイムは
必ず赤い線で記入!
Takt Time should be
lined in red ink

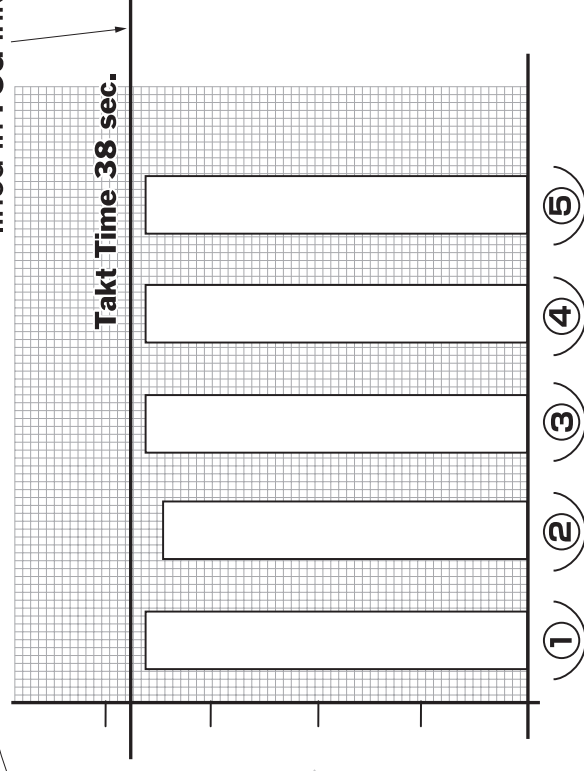
Current Situation



Process	Assemble 1	Assemble 2	Forming	Assemble 3	Tester	Appr.	Total
Time	38	25	22	33	38	37	193



After Kaizen



Assemble 1	Forming	Assemble 2	Tester	Appr.	Total
37	36	37	37	37	184