

Production Analysis Board

Line/Cell Name:		Team Leader:		Date:		
Quantity Required:		Takt Time:		Shift:		
				Num of Operator:		
Time	Hourly		Cumulative		Problem/Causes	Sign-off
	Plan	Actual	Plan	Actual		
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Example of Production Analysis Board (生産管理板の例)

A Production Analysis Board is a display that must be located at the exit of the cell (or the line) to show actual performance compared with planned performance on an hourly basis.

生産管理板とは、時間単位に出来高の計画と実績を表示する掲示板です。セルまたはラインの出口に必ず設置しましょう。

Supervisor signs hourly

Time		Hourly Plan/Actual	Cumulative Plan/Actual	Problem/Causes	Sign-off
06:00~07:00		90 / 90	90 / 90		Sharon
07:00~08:00		90 / 88	180 / 178	Tester Minor Stoppage	Sharon
08:00~09:00		90 / 90	270 / 268		Sharon
09:10~10:10		90 / 85	360 / 353	Defects (Appearance)	Sharon
10:10~11:10		90 / 90	450 / 443		Roy
11:40~12:40		90 / 90	540 / 533		Sharon
12:40~13:40		90 / 86	630 / 619	Defects (Bad Parts)	Sharon
13:50~14:30		60 / 60	690 / 679		Sharon
O.T.		11 / 11	690 / 690		Roy

Remember breaks

Just keeping visibility is not our real objective. Problems must be linked to corrective action!

Area Manager signs at lunch and end of shift