

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

Production Analysis Board

Line/Cell Name: Final Assembly #7		Team Leader: <i>Benny Li</i>		Date: <i>April 07</i>	
Quantity Required: 690 p		Takt Time: 40 sec./p		Shift: A	
				Num of Operator: 16	
Time	Hourly	Cumulative	Problem/Causes	Sign-off	
	Plan/Actual	Plan/Actual			
06:00~07:00	90 / 90	90 / 90		Sharon	
07:00~08:00	90 / 88	180 / 178	<i>Tester Minor Stoppage</i>	Sharon	
08:00~09:00	90 / 90	270 / 268		Sharon	
09:10~10:10	90 / 85	360 / 353	<i>Defects (Appearance)</i>	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	<i>Defects (Bad Parts)</i>	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