

ISI Led Event Summary Examples

Tulsa Centerless Bar: Twin Grip Centerless Grind Cell

	Before	After	% Improvement
Operator foot travel for 1 job	3245'	805'	75%
Time for 1 part job (min)	146	99	32%

Gunnebo Johnson: Snatch Block Weld/Assembly Cell

	Before	After	% Improvement
Operator Foot Travel	360'	24'	93%
Assy Time for 5 parts (min)	17:22	13:07	24%
WIP between Weld & Assembly	115 hrs.	2 hrs.	98%

Ditch Witch: Drill Pipe Weld Cell - Weld Cell 3

	Before	After	% Improvement
Total Operator Foot Travel	871'	345'	60%
Total Part Foot Travel	705'	228'	68%
Racks/day output	2.6	4.55	43%

Kimray: 3-Way Control Valve Assembly

	Before	After	% Improvement
Operator Foot Travel (for 3 parts)	1494'	210'	86%
Assy Time (for 3 parts)	72 min.	39 min.	46%

CMP: Crankshaft Machining Cell (5 machines)

	Before	After	% Improvement
Order Lead Time	336 hrs.	11 hrs.	86%
Crank Shaft WIP	2200	12	99%
Part Travel	4752'	142'	97%

S&R Compressors: Final Assembly Line

	Before	After	% Improvement
Units in WIP	13	8	38%
Monthly Rate	8 Units	14 Units	175%
Work Week	60+ hrs.	45 hrs.	25%

Weatherford: Arrowset Assembly Cell

	Before	After	% Improvement
Operator Foot Travel (5 units)	3726'	1314'	65%
Assy. & Packaging (5 units)	87 min.	37 min.	57%

Baker Hughes: Horizontal Mill Changeover

	Before	After	% Improvement
Set Up Time (min)	34:10	16:36	52%
Operator Foot Travel (ft)	932'	248'	73%

Victory Energy: Sales Make-to-Order Quote Process

	Before	After	% Improvement
Lead Time	1223 hrs.	206 hrs.	83%
Process Steps	34	12	65%

OSECO: Invoicing Process

	Before	After	% Improvement
WIP	22	5 ave.	77%
Lead Time	4 days	6 hrs.	81%

Gunnebo Johnson: Quality Returns Process

	Before	After	% Improvement
WIP (to be transacted)	238	34 ave.	86%
Lead Time	80.5 days	9.5 days	88%

Nautilus: Engineering Change Order Process

	Before	After	% Improvement
WIP	83	23	72%
Lead Time	96 days	7 days	92%

