

## 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%           |

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**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%           |

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**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%           |

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**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%           |

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**CMP: Crankshaft Machining Cell (5 machines)**

|                 | Before   | After   | % Improvement |
|-----------------|----------|---------|---------------|
| Order Lead Time | 336 hrs. | 11 hrs. | 86%           |
| Crank Shaft WIP | 2200     | 12      | 46%           |
| Part Travel     | 4752'    | 142'    | 97%           |

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**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**

|  | <b>Before</b> | <b>After</b> | <b>% Improvement</b> |
|--|---------------|--------------|----------------------|
| <b>Operator Foot Travel (5 units)</b>  | 3726'         | 1314'        | 65%                  |
| <b>Assy. &amp; Packaging (5 units)</b> | 87 min.       | 37 min.      | 57%                  |

**Baker Hughes: Horizontal Mill Changeover**

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

**Victory Energy: Sales Make-to-Order Quote Process**

|                      | <b>Before</b> | <b>After</b> | <b>% Improvement</b> |
|----------------------|---------------|--------------|----------------------|
| <b>Lead Time</b>     | 1223 hrs.     | 206 hrs.     | 83%                  |
| <b>Process Steps</b> | 34            | 12           | 65%                  |

**OSECO: Invoicing Process**

|                  | <b>Before</b> | <b>After</b> | <b>% Improvement</b> |
|------------------|---------------|--------------|----------------------|
| <b>WIP</b>       | 22            | 5 ave.       | 77%                  |
| <b>Lead Time</b> | 4 days        | 6 hrs.       | 81%                  |

**Gunnebo Johnson: Quality Returns Process**

|                               | <b>Before</b> | <b>After</b> | <b>% Improvement</b> |
|-------------------------------|---------------|--------------|----------------------|
| <b>WIP (to be transacted)</b> | 238           | 34 ave.      | 86%                  |
| <b>Lead Time</b>              | 80.5 days     | 9.5 days     | 88%                  |

**Nautilus: Engineering Change Order Process**

|                  | <b>Before</b> | <b>After</b> | <b>% Improvement</b> |
|------------------|---------------|--------------|----------------------|
| <b>WIP</b>       | 83            | 23           | 72%                  |
| <b>Lead Time</b> | 96 days       | 7 days       | 92%                  |

