



CASE STUDY: OFI's (Opportunities For Improvement)

ISS approaches every new inspection/sort ready to review an entire workflow, identify opportunities for improvement, and implement efficiencies that save labor and time while reducing cost.

SITUATION:

ISS was brought in and asked to adopt a workflow that included the following steps:

- 1) Press Operator produces parts and places them into a wire basket.
- 2) When parts total reaches 1500, they were forklifted to another area to be inspected/sorted.
- 3) Inspector 1 would bend down, grab a single part from the wire basket, air blow each end, then place it into an adjacent tote for Inspector 2.
- 4) Inspector 2 would inspect the part, apply a witness mark, and then place it into a Certified, or Rejected, metal container.

CHALLENGES:

Forklifts were not at the ready and at times there was significant delay in transporting material from the press to the inspection/sorting area, incurring downtime for the inspectors.

The wire baskets were low, requiring an inspector to bend over for each part, which over the course of the shift would cause discomfort and reduce performance levels.

STRATEGY:

Instead of inspecting/sorting the parts at a separate location, ISS positioned a rolling cart at the end of the press, so as the parts were produced, they would slide directly onto the cart to be inspected, eliminating the need of a forklift. A single inspector, now being able to stay in an upright position, could now perform all the steps necessary, and keep pace with the press operator.

OUTCOME:



Cost Savings:

By improving efficiencies, a second inspector was no longer needed.
1 inspector / 2 shifts / 6 days = > \$3,500 weekly cost reduction.



Reduced Downtime:

By removing the unpredictable time variable of having a forklift in the workflow.



Improved PPH:

By eliminating the labor-intensive step of bending over productivity remained consistent.



Health/Safety:

By improving ergonomics, bodily stress and fatigue levels were reduced, while mental clarity, focus, and engagement improved. Healthier workers are happier workers.