

WAW  
5-4-88

4/26/88

SYNCHRONOUS MANUFACTURING MEASUREMENTS

The following measurement guidelines are recommendations that have been included to assist you in developing your own measurements for T, I, and OE. Remember, these are only suggestions - these may not be the final measurements. Keep the following guidelines in mind as you work to develop these measurements:

- o Measurements must reflect T, I, and OE.
- o Measurements must be meaningful and important to you and the people in your area.
- o Measurements should be quick and easy to obtain on a daily basis.
- o Everyone must use the SAME measurements.

GLOBAL (PLANT):

- T = Short stocks in -vs- Short stocks out  
Long stocks in -vs- Long stocks out  
Fore ends in -vs- Fore ends out  
Units Scheduled -vs- Units Made
- I = Plant WIP (Dollar\$)
- OE = Total plant OE / Units Made

LOCAL (AREA/DEPT):

- T = Units Scheduled -vs- Units Made.  
Some Currently available measurement methods:
  - o Items on Expedite sheet
  - o % Overdue orders
- I = Area/Dept. WIP (Dollar\$)  
WIP count in pieces (For major components)  
Lead Times (Item master -vs- Shop floor control)
- OE = Total hours worked (Each overtime hour counts as 1.5)