

## Circuitry/Electronics

**Issue**

The current delivery time of a Cluster I/O board does not meet expectations of the customer. The goal is to reduce cycle time to 3 days, while improving RTY and DPMO.

**Breakthrough Strategy**

- Measure** A process map and Pareto chart indicated the key process input and output variables.
- Analyze** A hypothesis test, focusing on key input variables, reduced the cycle time to 15.8 hours (or 1.9 days).
- Improve** A Kaizen team implemented changes to the manufacturing floor, such as consolidating operations to 1 floor, combining 3 departments into 1, and establishing a process flow capable of a 3 day cycle time. A failure analysis of defective components was formalized. Finally, implementation of a count scale and production procedure ensures availability of parts, thus reducing cycle time.
- Control** A control plan has been put into place, with a transition plan to the Kaizen team for implementation of manufacturing changes. Local project reviews will ensure adherence to new procedures to keep cycle time down.
- Results** A process capable of a 3 day cycle time has been established. The overall process has been greatly simplified, and a foundation for continual process improvement is in place.
- Savings** \$133,000