



Manufacturers Alliance Seminar **Lean for Custom Manufacturers**

Practical experiences from practitioners on how custom and job shop manufacturer can benefit from Lean

Design Ready Controls

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READY
CONTROLS

Our Focus

UL508A and UL698A Certified Products

- Industrial Control Panels
- Wiring Harnesses
- Low Voltage Control Panels
- Medium Voltage Control Panels
- Enclosed drive packages



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Our Customer Profile

OEM Machine Builders
with "Flow Business"

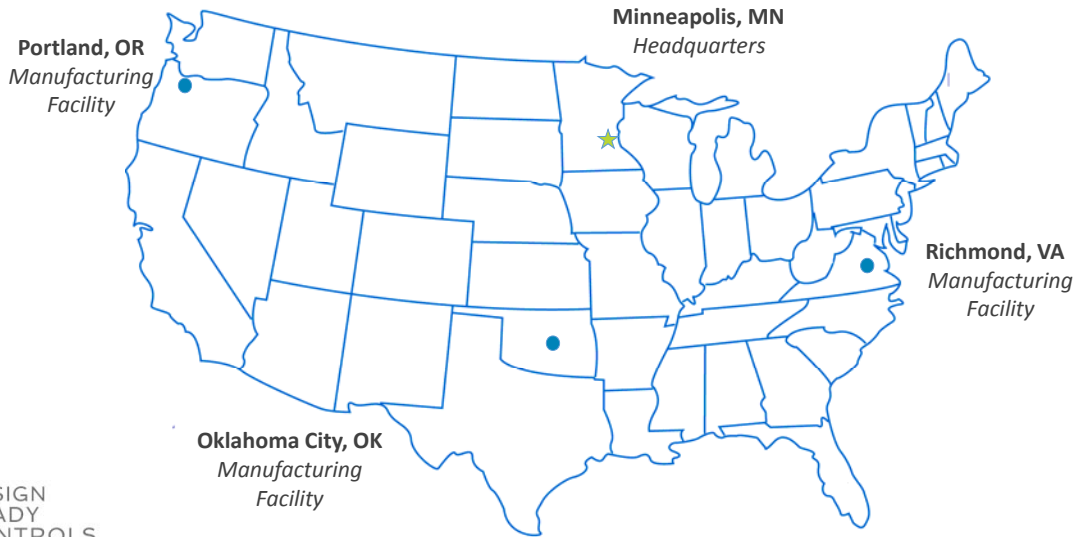


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All our facilities are ISO 9001:2015 registered

Where We Are



Motivation

Staff planning – preparing for expected increase

- How many people to hire?
- When to start hiring?



Version 1: Overview

Inputs

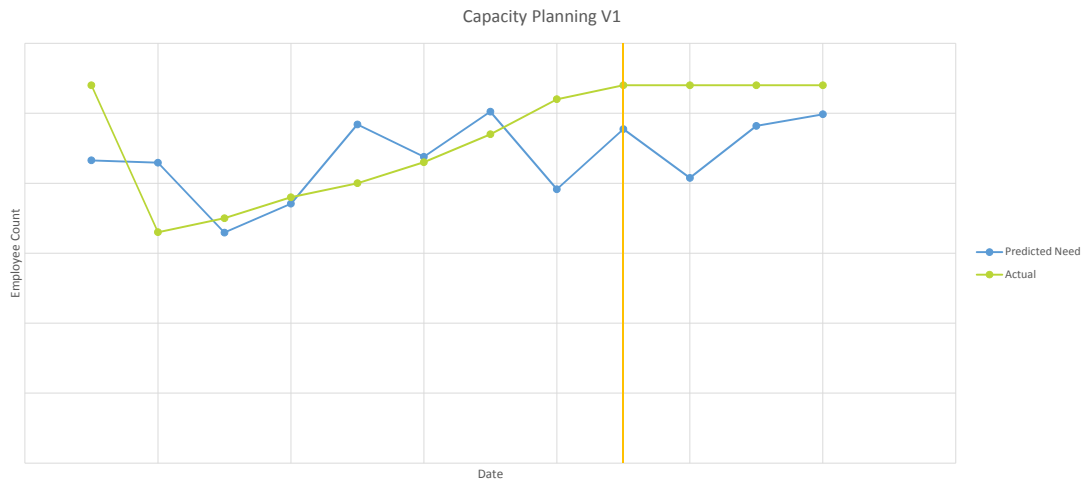
- # of production employees: month-by-month
- Predicted volumes: current products, based on running averages

Outputs

- # of employees needed for next 6 months/workstation



Capacity Planning Tool: Version 1



Version 1: Conclusion

Assumes 40hrs of available labor/person/week

Doesn't account for employee skill level

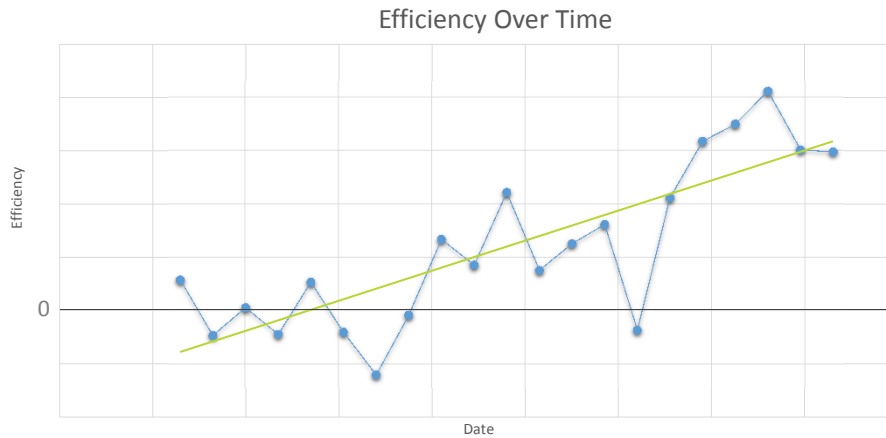
New business was not incorporated, current business based on running average

Commercially-available tool unavailable

End Result: **Over-Estimated Available Labor**



Background – Efficiency



Version 2: Overview

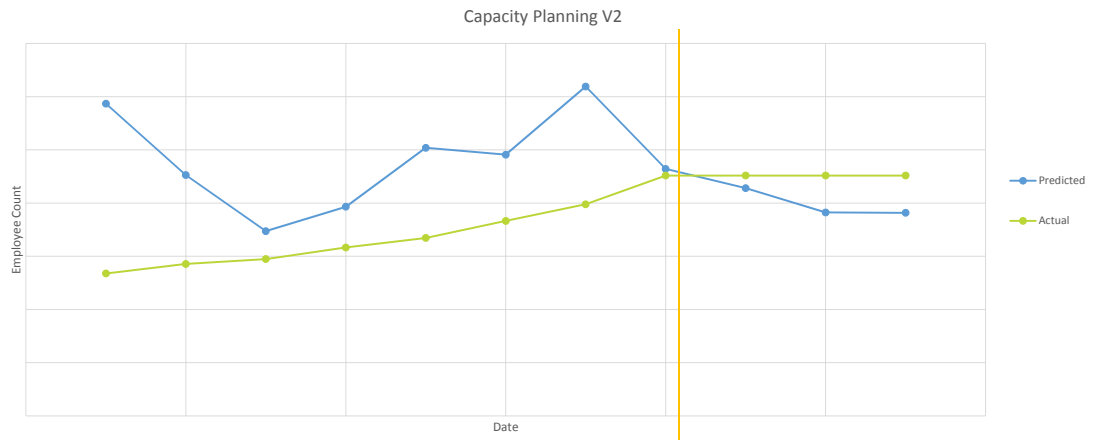
Inputs

- # of production employees by efficiency, direct/indirect time → effective person count.
- Predicted volumes – current products AND future products based on customer forecasts.

Outputs

- # of employees needed for next 6 months/workstation

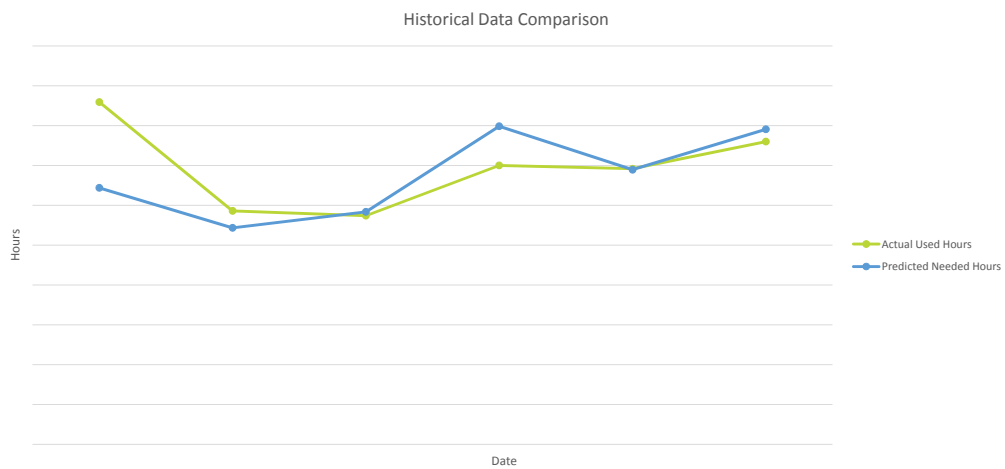
Capacity Planning Tool: Version 2



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Historical Data



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Version 2: Conclusion

Matches historical data

Run monthly – guiding hiring and overtime

Limitations

- Missing employee gains/losses until end of month
- Entering new products with existing products



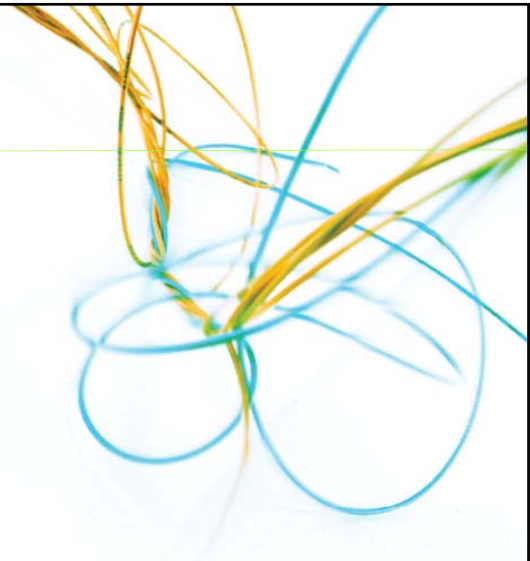
Conclusion/Next Steps

Conclusions

- Capacity planning is possible
- Opportunity to proactively hire
- Easier to plan for new products

Next Steps

- More user-friendly
- Correct for turnover
- Incorporate training capacity
- Targeted investigations



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Thank you!



Manufacturers Alliance
Thank you for joining us!

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