

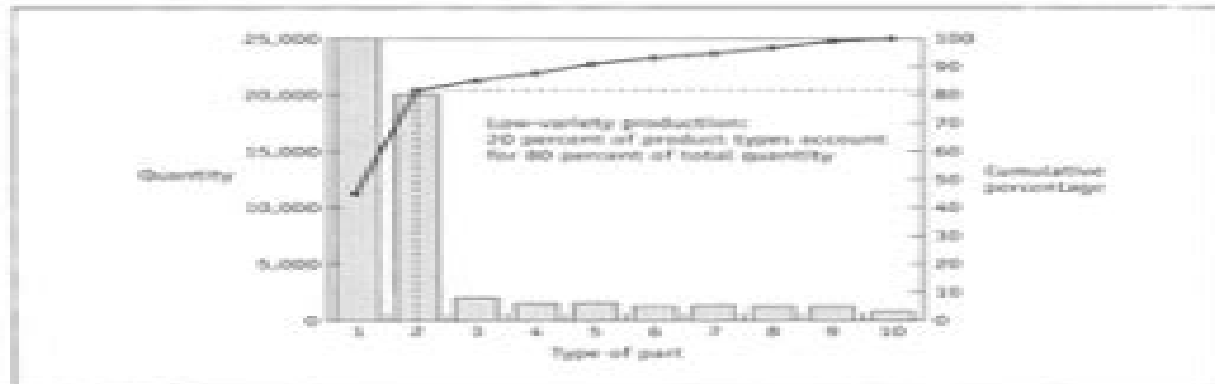


Figure 3-1. A PQ Analysis Chart Showing a 20-80 PQ Ratio (Low Variety)

This chapter* describes the three basic phases involved in converting a work area into a manufacturing cell:

1. Understanding the current conditions
2. Converting to a process-based layout
3. Continuously improving the process

Phase 1: Understanding the Current Conditions

The first phase in cell conversion, understanding the current conditions, helps the conversion team determine what process to convert. It also provides a baseline against which to measure improvement.

Collect Product and Production Data

Product Mix

Deciding what process to convert to a cell is simpler if the company makes a few product types in relatively high volume. A high volume process tends to pull the maximum benefit from the improvement, while low variety avoids issues such as changeover. PQ (*product type/quantity*) analysis is used to display the product mix as a Pareto chart (see Figures 3-1 and 3-2).

*This chapter is longer than the other chapters. You may want to read it in sections; for example, you might read the text about one of the phases, then pause for reflection and group discussion.

Chapter 3basic Pharamocology

Scott C. Dulebohn



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