



Standard Work – Process Control

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Effective processes must be standardized and controlled. Current methods are analyzed using observation and videotaping. Then procedures and forms are used to document standard work. Standard work is the formal sequence of human tasks required to make a product using the best methods currently known to minimize waste. It identifies the work sequence to improve methods and balance work content.

Every time a task is performed we can verify that the person doing the task is capable of executing it correctly and that the work sequence and content produce the expected results. It is the foundation for continuous improvement at the shop floor level. .

Standard work removes operator variability from the process, improving process control. Statistical Process Control (SPC) monitors a process over time for random and assignable cause variation. Operators input to SPC using digital gauges connected to automatic control chart displays. In this way trends can be identified and common cause variation differentiated from assignable cause variation. Procedures, policies and visual controls define the standard process and control strategy - what to do in response to out of control condition. Use of SPC avoids process tweaking, which can introduce or amplify variation. Process control can be applied to product / output measurement or to actual process elements such as sensors measuring load on motors, heat or vibration.

Key Benefits

- Standard work ensures process consistency and reduces operator-introduced variation
- Methods continuously improved and documented for efficiency, quality improvement and cost reduction
- Statistical Process Control stabilizes the process and improves quality by appropriate response to variation

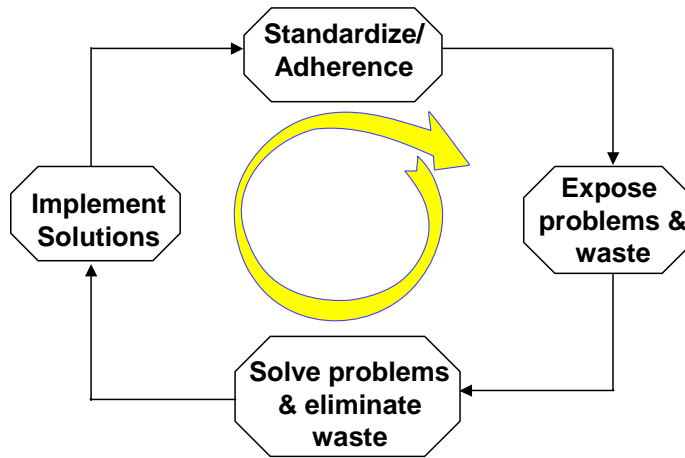
Activities

- Apply standard work tools based on the Toyota Production System for tried and true results
- Train and assist teams to analyze processes using observation, videotaping, documentation and methods optimization
- Assist teams to plan and implement Statistical Process Control policies, procedures and practices
- Call upon experience with SPC in various industrial and service applications

Do operators follow non-standard practices leading to increased opportunities for error and inefficiencies? Is your process out of control – generating excessive defects? If so, get help to effectively apply standard work process analysis and statistical process control to stabilize production and improve quality.

Standard Work

Standard Work Improvement Process:



1. Standardize and follow standard
2. Expose problems & waste
3. Solve problems & eliminate waste
4. Implement solutions
5. Set new standard
6. Repeat cycle

Standard Work - Elements

Four Elements:

