

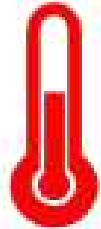
The Wrap Machine (1st in – 1st out)



Method of analysis



Define



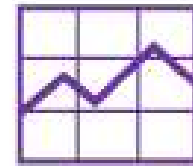
Measure



Analyze



Improve



Control

Table of Contents

1

What is the problem?

2

Analysis /
Measurements

3

Calculation

4

Improve

5

Control

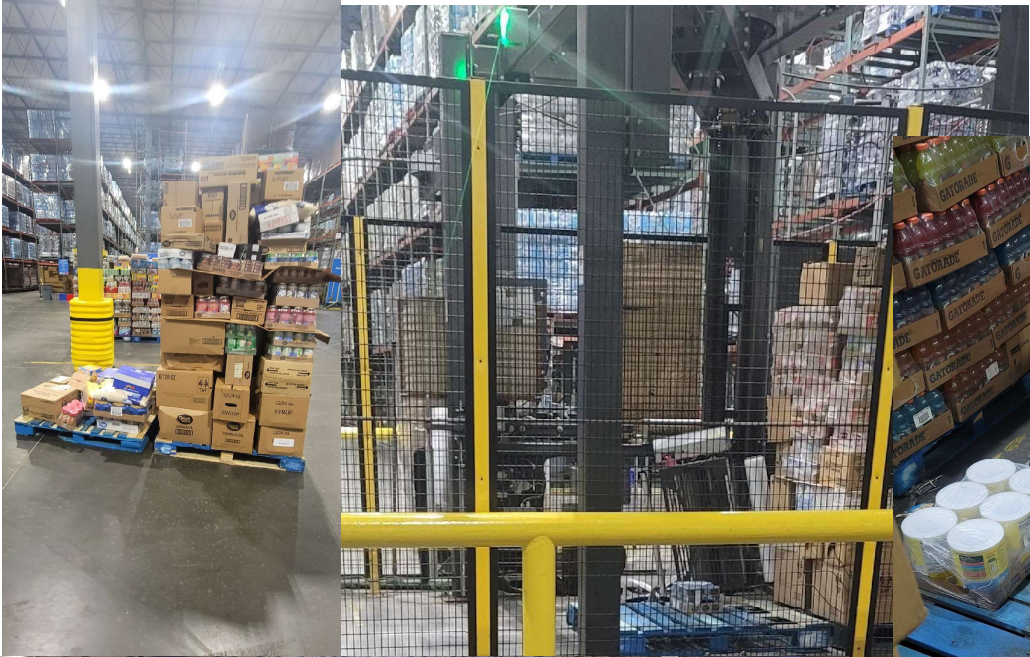
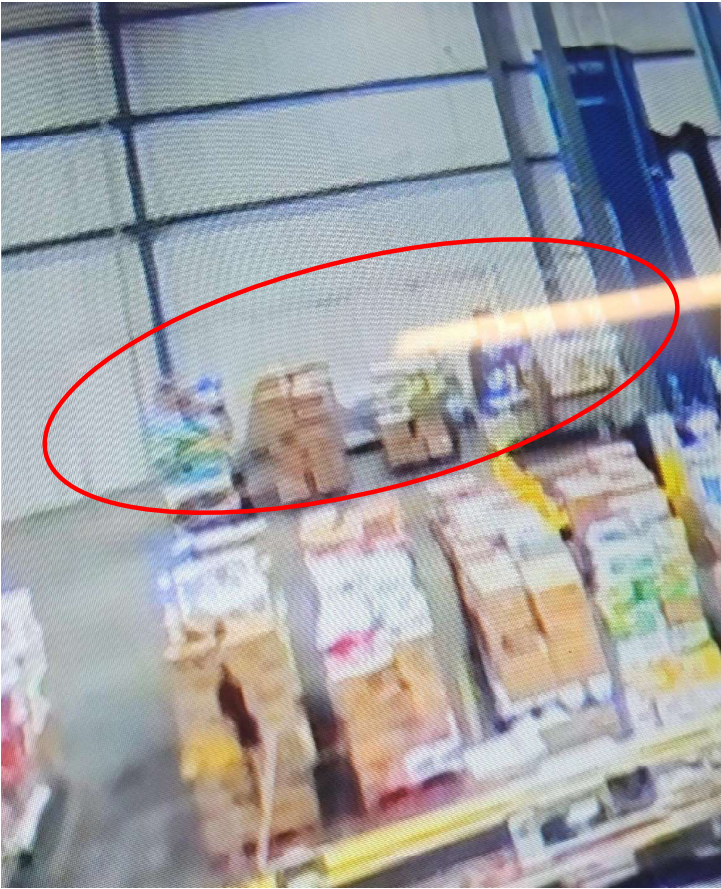
1

What is the problem?

The problem is that the order fillers do not have a consecutive order in which they place the pallets, creating spaces that are not within the 6 lanes already established and consequently we have the following problems.



-
- There is a loss of time between the three processes for loading the pallets
 - Become unsafe for the associates.
 - Pallets that need to go out first are left behind for a long time.
 - The loaders look for a pallets.
 - The loaders wait for a pallets.
 - The order filler do not know which lane the wrappers are working on. Therefore, we have that the orderfiller place a pallets in front of other pallets.
 - Small pallets are placing in the staging area.





Analysis / Measurements

Process Flow

The process is divided into:

- The order filling places the pallets in the staging area
- The wrapper grabs the pallets from the staging area and places them into the wrap machine
- Finally, the loader grabs the pallets from the wrap machine and places them on the door trucks.



Observations

- 1st The staging area becomes an unsafe
- 2nd Lanes were not fully visible
- 3rd The machines breaks down
- 4th Labels come out in a format that is not consecutive
- 5th Traffic is generated in the dry shipping area
- 6th The staging area is disorganized.
- 7th They do not have signing.
- 8th Unpredictable for the orderfillers on which row the wrappers are working
- 9th The space is limited between the staging area and the stacker machine.