Orientation to the Paper Boat Factory
Paper Boat Factory

Product Catalog
Paper Boat Factory

SBGS

![Image of a paper boat](image-url)
## Paper Boat Factory: The Bottom Line

<table>
<thead>
<tr>
<th>SBGS</th>
<th>GBSS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Materials cost $0.50</td>
<td>Materials cost $0.50</td>
</tr>
<tr>
<td>Labor cost: $2.00/person/shift</td>
<td>Labor cost:</td>
</tr>
<tr>
<td>Facilities cost: $0.75/sq ft/shift</td>
<td>Facilities cost:</td>
</tr>
<tr>
<td>Material cost: $.25/sheet paper</td>
<td>Material cost:</td>
</tr>
</tbody>
</table>
Production Process Orientation

1. Sales Representative
   Processes “Customer Order”
2. Production Scheduler
   Generates “Factory Order” from forecast
3. Kitter(s)
   Organizes raw materials for “Factory Orders”
4. Material Handler
   Moves product between ALL workstations
5. Folder I
   Initial folding: Gold
6. Folder I
   Initial folding: Silver
7. Folder II
   Final folding: Gold
8. Folder II
   Final folding: Silver
9. Logo Stamper (Gold)
10. Logo Stamper (Silver)
11. Oven Operator (Gold)
12. Oven Operator (Silver)
13. Inspector
   Assures Quality
14. Re-worker
   Repairs failed boats
15. Warehouse/Ship Clerk
   Matches boats to “Customer Orders”
16. Production Supervisor
   Supervises production
17. Industrial Engineer (2)
   Monitors production process
18. Trucker
   Ships products to the customer
Production Batching

GBSS  4 per batch

SBGS  4 per batch
Production Scheduling Process

- Customer orders (demand)
- Customer order forms
- Shipments to customers
- Production forecast
- Factory order forms
- Finished Goods Warehouse

Flowchart showing the process:
1. Customer orders (demand) to Customer order forms
2. Customer order forms to Shipments to customers
3. Shipments to customers to Finished Goods Warehouse
4. Finished Goods Warehouse to Production forecast
5. Production forecast to Factory order forms
6. Factory order forms to Customer order forms
All orders are filled “first-in, first-out” (FIFO)
• All shifts are 10 minutes
• Keep busy at all times
• Yell if you need parts
• Handle all parts first-in, first-out (FIFO)
• Only the Material Handler can move parts
• Stay at your workstation
• The boss is *always* right!
Set-up

• Role assignment
• Paper boat folding practice
• Wet the line
• IE data collection strategies/objectives
3 Factories

- **Round 1: Present State**
  - Take your new factory out for a spin

- **Round 2: Oil the Squeaky Wheels**
  - Factory Layout
  - Point of Use Storage (POUS)
  - Line Balancing

- **Round 3: Stop the Pushing**
  - Factory Layout
  - Pull System, Kanban
  - Continuous Flow and Supermarkets
  - Poke-Yoke, Quality at the Source