Discrete/ Assembly
East African Growers: Flow implementation in flower packing

Workstation – Before & After

Current W/station – 1.47sq.m
New W/station – 0.95 sq.m
Floor Space reduction – 30 sq.m (34%)

MUDA reduced, Activities improved and standardized

Before

Cluttered work place

Un-tidy workplace

After

Standardized work place

Clean & tidy workplace

Standardized flow for Supply & Evacuation

Results

<table>
<thead>
<tr>
<th>Primary Measure</th>
<th>Before Kaizen (b)</th>
<th>Target (t)</th>
<th>After Kaizen (a)</th>
<th>% Improvement [(a-b)/b] x100</th>
</tr>
</thead>
<tbody>
<tr>
<td>Throughput Time</td>
<td>662 4sec</td>
<td>1400</td>
<td>2906</td>
<td>55%</td>
</tr>
<tr>
<td>S K Audit Score</td>
<td>22%</td>
<td>90%</td>
<td>75%</td>
<td>53%</td>
</tr>
<tr>
<td>Manpower Used</td>
<td>93</td>
<td>70</td>
<td>83</td>
<td>10%</td>
</tr>
<tr>
<td>Manpower Productivity</td>
<td>2600</td>
<td>5000</td>
<td>4082</td>
<td>57%</td>
</tr>
<tr>
<td>WIP</td>
<td>3113</td>
<td>1400</td>
<td>1400</td>
<td>55%</td>
</tr>
<tr>
<td>Distance moved by Material</td>
<td>65mtrs</td>
<td>60mtr</td>
<td>65mtrs</td>
<td></td>
</tr>
<tr>
<td>Distance moved by people</td>
<td>130mtrs</td>
<td>120mtrs</td>
<td>120mtrs</td>
<td></td>
</tr>
<tr>
<td>Distance moved by Material Handling</td>
<td>130mtrs</td>
<td>120mtrs</td>
<td>120mtrs</td>
<td></td>
</tr>
<tr>
<td>Distance moved by Documents</td>
<td>65mtrs</td>
<td>65mtrs</td>
<td>65 mtrs</td>
<td></td>
</tr>
<tr>
<td>Space Used</td>
<td>1017 sq. mtr</td>
<td>762 sq.mtr</td>
<td>1017 sq.mtr</td>
<td></td>
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