

Group Gleaning Chart

Waste	Location	Notes/Description
Defects	Pg. 157	trying to find bottlenecks moving & move Q.C. in front of Bottlenecks
Overproduction	Pg. 203	Bottlenecks make parts before they are needed
Waiting	153	Bottlenecks waiting NCX-10 is idle, workers eat at lunch
Non-Utilized Talent	Pg. 154	Review with Allison Singh
Transportation	245	Ship smaller parts at different times than larger parts
Inventory	Pg. 144 Pg. 210	Look for bottlenecks by finding excess inventory
Motion	143	Parts have to move mill → heat treat → Mill
Extra Processing	Pg. 316	Reducing shipping time Alice tells Johnny he can ship in 3-4 days

Waste	Description of Example	Explanation
Inventory Pg. 192	Parts are spending too much time in oven	Instead of monitoring parts that go in and out of the oven, it sits always a set time, which wastes time. Also, some baskets are left in the oven for longer than needed, which wastes time. Mike Hobb (Greenman) moves the ovens more efficient.
Defects Pg. 157	Parts are being scrapped.	Bottlenecks have enough to work on around. I would suggest that Q.C. be moved in front of the bottlenecks, to eliminate working on bad parts.
Waiting Pg. 153	Employees are waiting time/work	Employees are taking breaks when a machine is not running, instead of fixing their breaks when the machine has been started.
Over production Pg. 203	Time wasted on parts not needed	Bottlenecks are spending time on parts that aren't needed, instead of working on parts that are under a time constraint.