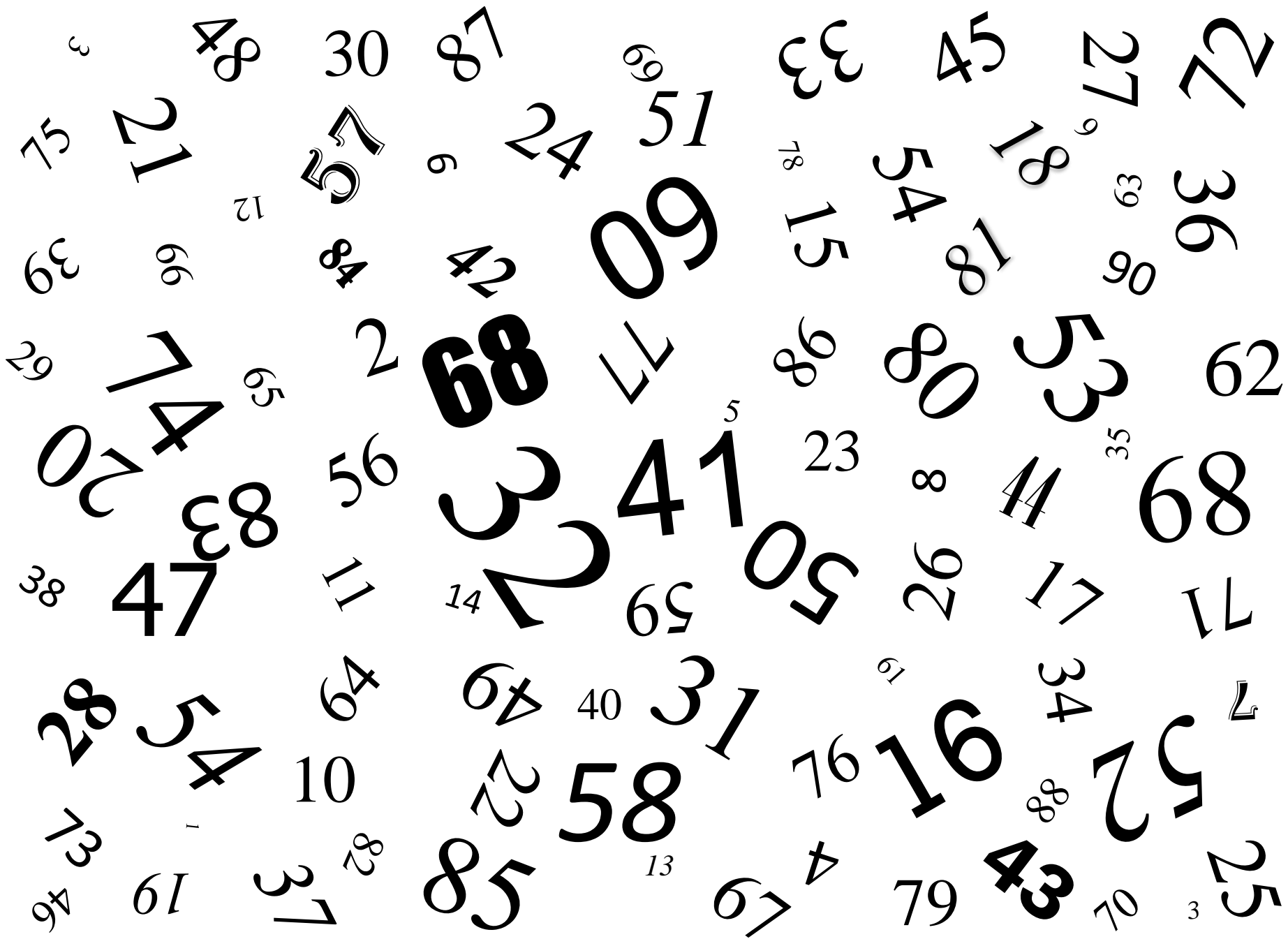
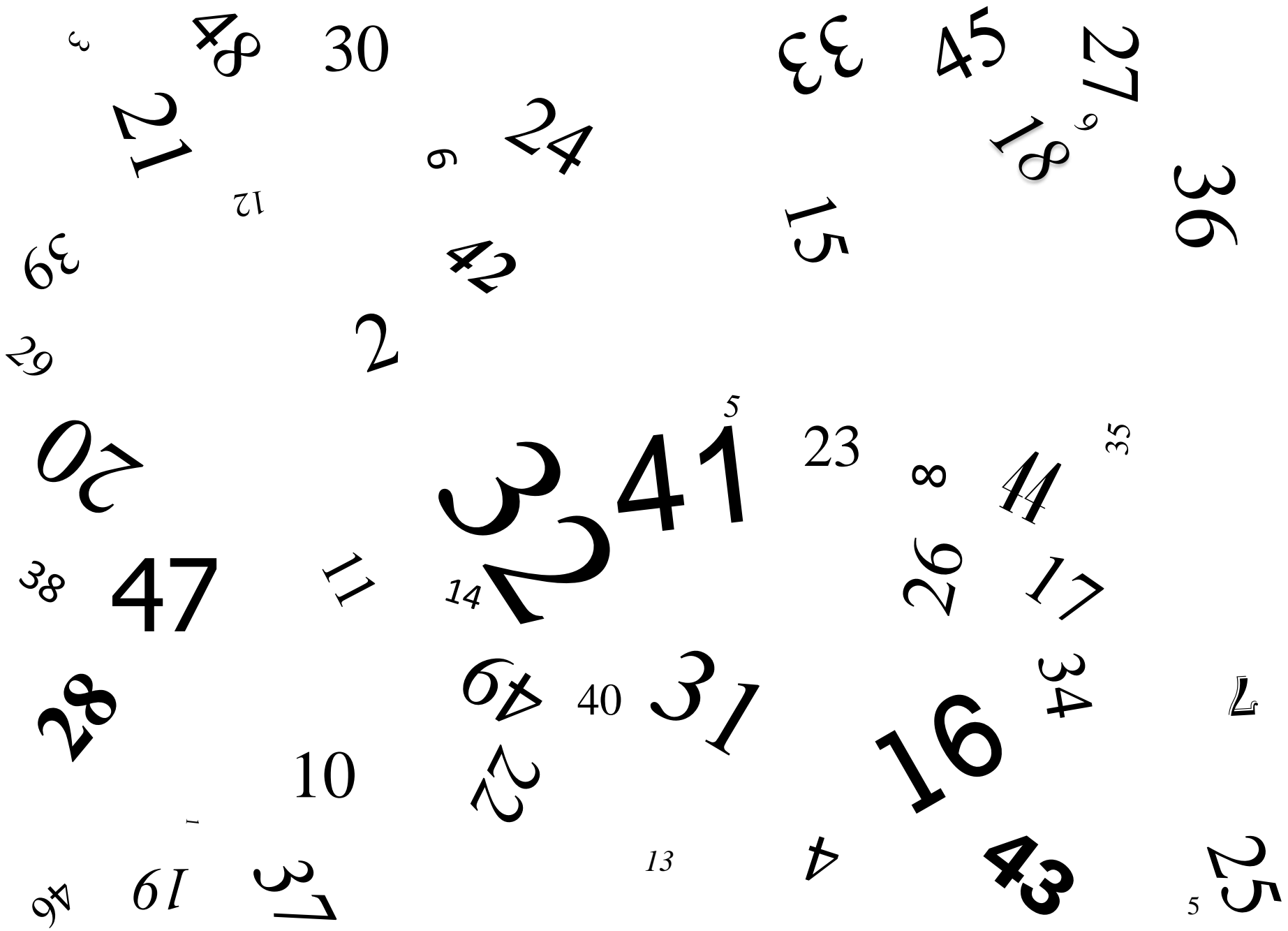


The 5S numbers game.

- This sheet represents our current work place.
- Our job during a 20 second shift, is to strike out the numbers 1 to 49 in correct sequence. Example: ~~1~~ ~~2~~ ~~3~~
- The team score will be represented by the lowest individual score achieved.
- Give the sheets out face down and have someone keep time.
- Ask each person to call out their individual scores and mark them on a flipchart. Circle the lowest and therefore team score.
- Ask if they are happy with the score



- For our first action, we are going to implement 5S in this area.
- The first step of this is “Sort” and so we have removed from the area all the numbers from 50 to 90 which are not needed.
- Same rule apply. Strike out numbers 1 to 49 in sequence during a 20 second shift.



- Having achieved some improvement, we now need to move onto the next step "Set In Order".
- We have installed some racking, and we have organized the items so that with Number 1 in the bottom left hand corner, the numbers are located from left to right and bottom to top - examples 1 in the bottom left, 2 in the middle, and 3 in the top left.
- Same rules apply 20 second shift, lowest individual score equals team score etc...

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27⁹

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48

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43

4

31

13

40

67

22

10

37

28

1

19

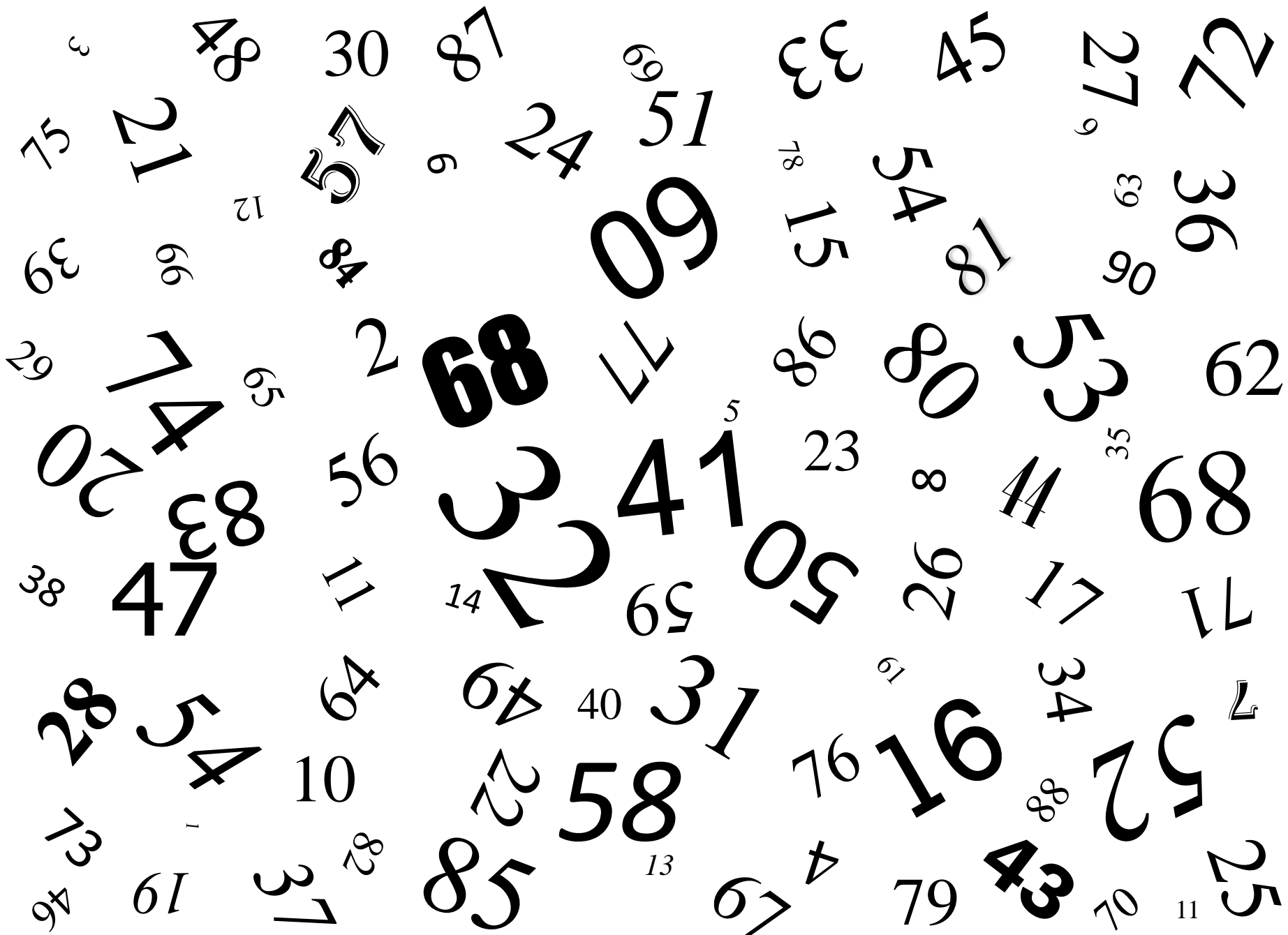
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- Having now made a significant step forward, and having ignored “Shine” for this exercise, we must “Standardize”.
- Since we are dealing with numbers 1 to 49 in sequence, it seems logical to re-organize them in a standard way that makes the completion of the work task as easy as possible.
- This should ensure that everyone is able to complete the task (and therefore produce a team score of 49.)

Numbers from 1 to 49

1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20
21	22	23	24	25	26	27	28	29	30
31	32	33	34	35	36	37	38	39	40
41	42	43	44	45	46	47	48	49	

- To show respect for Standards it is necessary to make the “management” of the area visual.
- Returning to our original work area, we have for this assignment two numbers missing. We cannot complete the task without these numbers - so first we have to find them.
- Start a clock running and every 20 seconds, tell them how many “shifts” they have been down looking for the appropriate numbers.



- Now how much easier is it to find the quality problems?

Numbers from 1 to 49

1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17		19	20
21	22	23	24	25	26	27	28	29	30
31	32	33	34	35	36	37	38	39	40
41		43	44	45	46	47	48	49	