CUTTING PROCESS

600 cm^2 per a day

1 cm^2 = 1 EURO

Day	Material used	Waste	Costs
1			
2			
3			
4			
5			
6			
7			
8			
		Total cost	

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MILLING PROCESS

2 x 300 cm^2 per a day

1 cm^2 = 2 EURO

1 cm^2 = 4 EURO in additional shift

	Milling machine 1 Profile: A		Milling machine 2 Profile: B, C	
Day	**Real machine load**	**COST First shift Additional shift (if any)**	**Real machine load**	**COST First shift Additional shift (if any)**
1				
2				
3				
4				
5				
6				
7				
8				
First shift			**First shift**	
Additional shift			**Additional shift**	
Total cost				

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LAMINATING PROCESS

2 x 300 cm^2 per a day

1 cm^2 = 3 EURO

Day	Material used	Waste	Costs
1			
2			
3			
4			
5			
6			
7			
8			
		Total cost	

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Erasmus+

ILA-LEAN

ORDERS COMPLETIONS AND SHIPMENT

Client number	Work in Process Number of pieces			Total number of days of delay	Cost of delay 1day = 500 Euro
	C	M	L		
C-1					
C-2					
C-3					
C-4					
C-5					
C-6					
C-7					
C-8					
C-9					
C-10					
Sum of work in process	Σ =	Σ =	Σ =	Total cost	
Cost of Work in process (1 piece = 50 Euro)					

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RESTOL

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RESULTS TABLE

	Team 1	Team 2	Team 3	Team 4
Cost of waste in cutting process				
Cost of additional shift in milling process				
Cost of waste in laminating process				
Cost of Work in Process				
Cost of delayed deliveries				
Total costs				

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A3 REPORT

Title: What do you want to write about?

An owner of the problem:

Date:

1. Problem description
Why do you want to write about this problem?

2. Current situation
What is a current situation?
Use visual tools to present the current situation (schemes, flowcharts, pictures, diagrams, VSM, spaghetti diagram etc.)

3. Goal(s), indicators
The goal(s) should be SMART (Specific, Measurable, Achievable, Realistic, Time-bound)
Indicators should give the possibility to assess improvements in the future

4. Analysis
What are the source causes of the problems?
Use a tool which will help you to find the causes of the problem (5xWhy?, Ishikawa diagram, interrelationship diagram, brainstorming, etc..)

5. Proposed countermeasures
What do you propose to implement to achieve the goal(s)?
How the proposed solutions can influence on the source causes of the problem and can change the current situation to achieve the future state?

6. Plan
What we have to do?
What is a deadline?
Who will be responsible for the activities?
How much it will cost?
You can use Gant chart, table or other visual tool.

7. Further improvement
What kind of problems can appear (risk analysis)?
Use PDCA to plan further improvement.
Assess what was achieved?

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A3 REPORT

Title: What do you want to write about?	An owner of the problem:	Date:

1. Problem description

2. Current situation

3. Goal(s), indicators

4. Analysis

5. Proposed countermeasures

6. Plan

7. Further improvement

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Milling Machine 1

Profile: A

Milling Machine 2

Profile: B, C