

L N 2 J → test d'Entr. → 1 EXAMEN

60 { YB 1 J → T.E.
GB 3 J → T.C. } → 1 EXAMEN

Youri. Buffe @ teamsix sigma
belgium.com

10.35

15'

12 - 12.30

60'

15h

15'

17-1730

52

Client

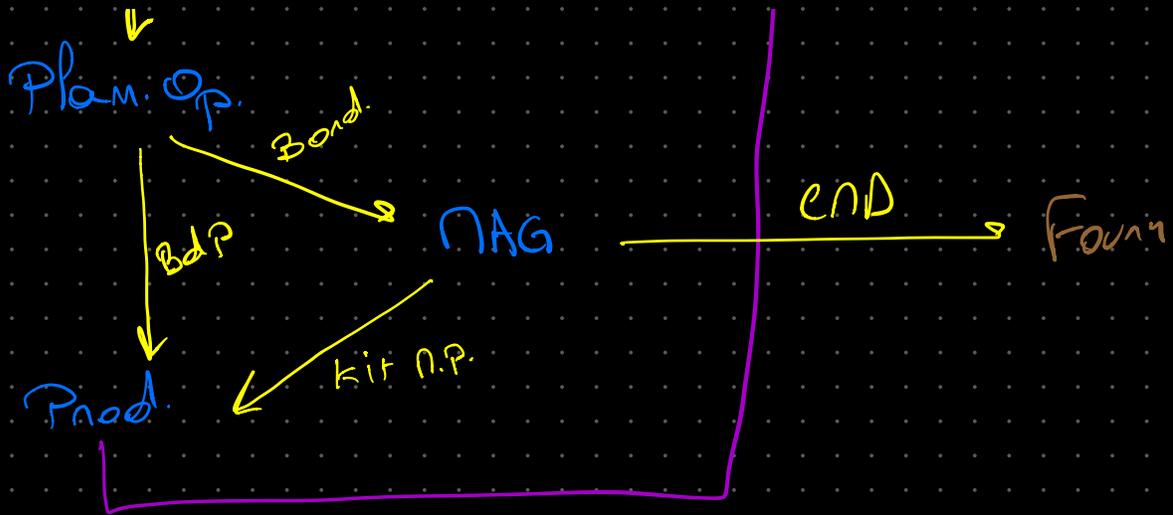
↓ CND

Vendeur

BdV

Fact. + P.F.

Prodif.



Client

- 1: Produit
- 2: Facture
- 3: DÉB: 60 sec.

Problèmes:

- Manque visibilité
- Difficulté à supporter
customisation
- Manque de standardisation

SYNPTONES

offres pas claires
prend du temps, erreurs

- manque d'ownership.

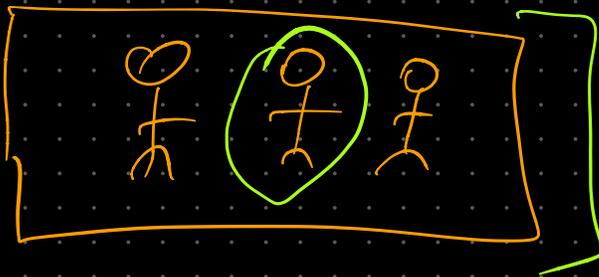
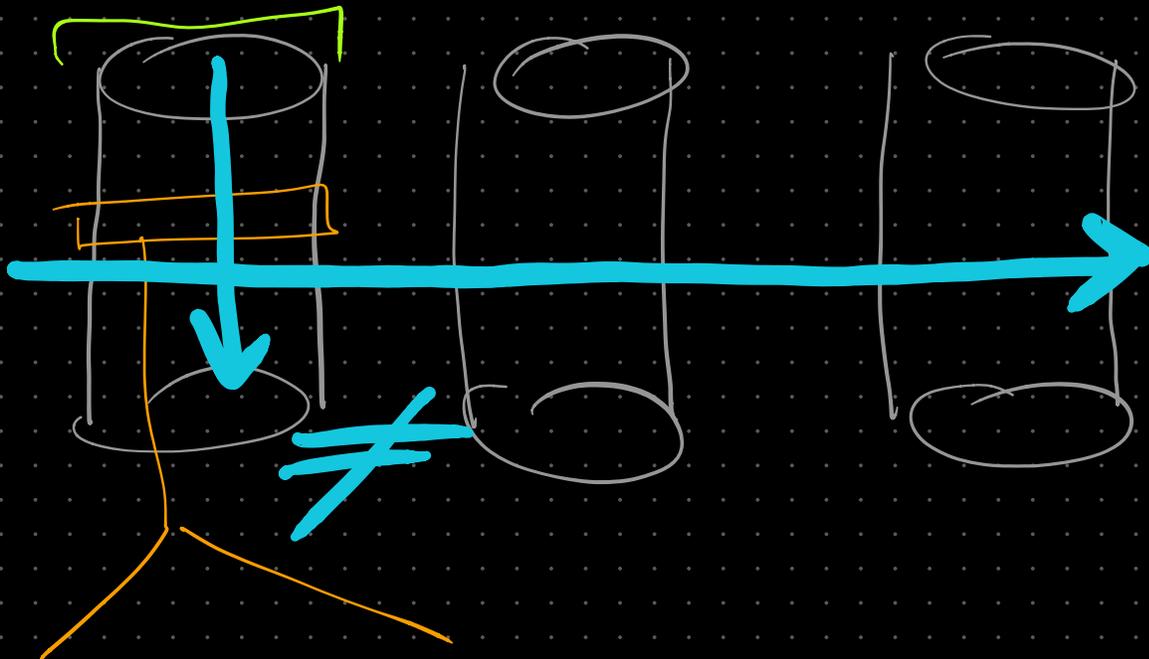
- Manque de responsabilités

pos de projets de change.

- Perte motivation

- travail à pression

- retards



DELAI





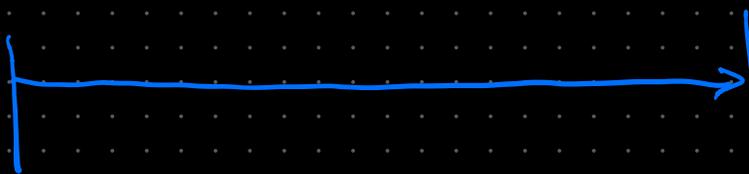
Tps Traitement
Unité



Temps de
File



Décal

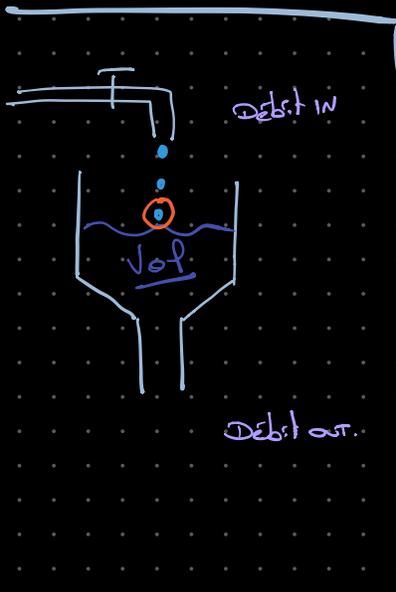


$$\text{Décal} = \text{Tps Traitement Unité} + \text{Temps de File}$$

↑ ↑ ↑ ↑

Temps Tr. Un. → nombre ou temps "En cours"

$$\text{Temps de File} = \frac{\text{WIP}_{\text{file}}}{\text{Débit sortie}} \rightarrow \text{work in Process} \approx \text{file d'attente}$$



$$\text{WIP} = \# \text{ CND IN} - \text{OUT}$$

$$\text{Déb. sortie} = \frac{\# \text{ CND at}}{\text{temps}}$$

NB WIP
↳ WIP proc.
WIP file

WIP stock

Retour à 13h26

Bon Appétit
😊



Tps In. U 120 sec

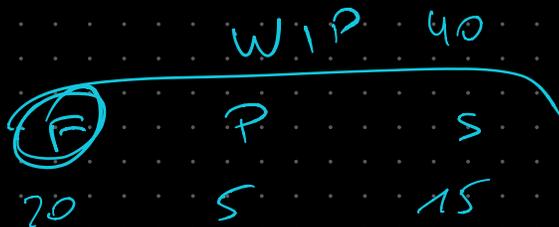
portée : 700 sec.

$$WIP = 35 \text{ CND} - \overbrace{5 \text{ CND}}^{WIP - WIPs} = 30 \text{ CND.}$$

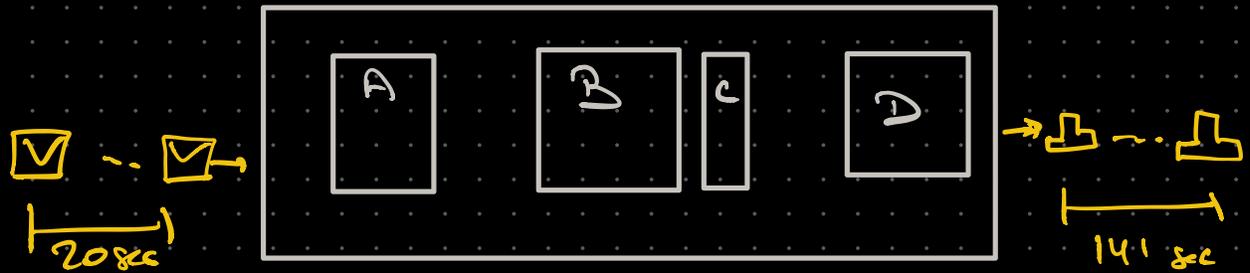
$$WIP_p = 25 \text{ CND.}$$

$$\text{Déb. sortie} = \frac{5 \text{ CND}}{700 \text{ sec}} = 0,0071 \text{ CND/sec}$$

$$\text{Délai} = 120 \text{ sec} + \frac{25 \text{ CND}}{0,0071 \frac{\text{CND}}{\text{sec}}} = 3641 \text{ sec.}$$



DANS: 40
- 5
- 15



Temps TAKT temps moyen tel 2 sorties
que je dois atteindre pour
supporter la demande.

$$\begin{aligned}
 &= \frac{\text{Tps Disponible}}{\text{Demande}} \\
 &= \frac{1h}{10 \text{ } \begin{array}{c} \text{CPU} \\ \uparrow \\ \text{CPU} \end{array}} = \frac{\cancel{5h} \text{ } 7h}{10 \text{ cp}} = \cancel{0,8h} \text{ } \underline{0,7h}
 \end{aligned}$$

Temps Cycle Processor temps moyen entre 2 sorties
réelles

TCP

$$\text{TCP} < \text{T.TAKT} \leftrightarrow \text{Sur-capacité}$$

PUSH
 PULL

$$\text{TCP} > \text{T.TAKT} \leftrightarrow \text{Sous-capacité}$$



IN

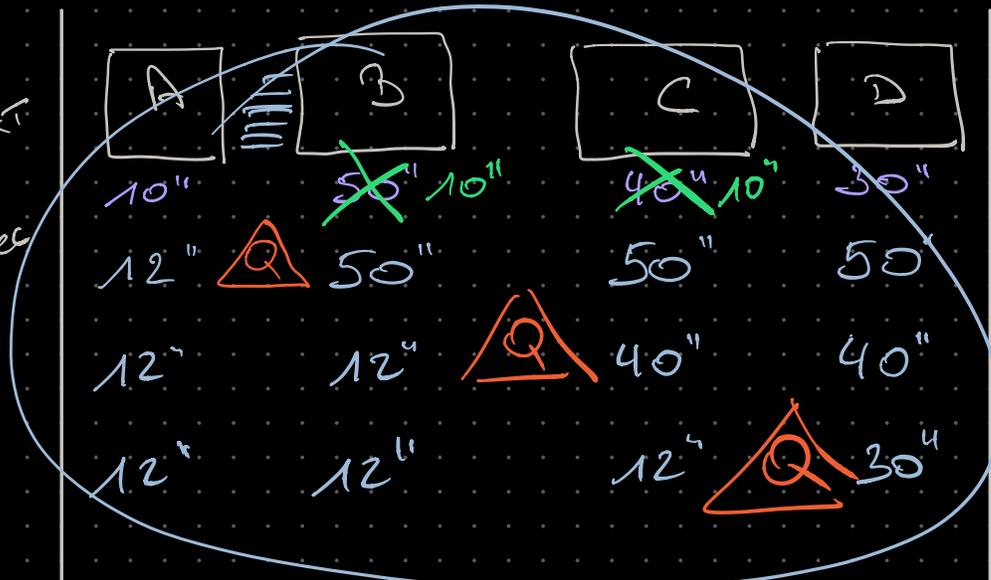


OUT

COLLECTE

PROD.

T. TAKT
12 sec

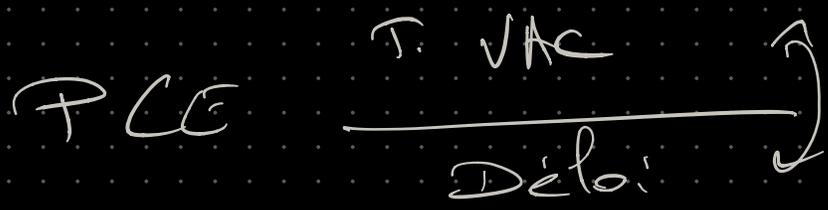
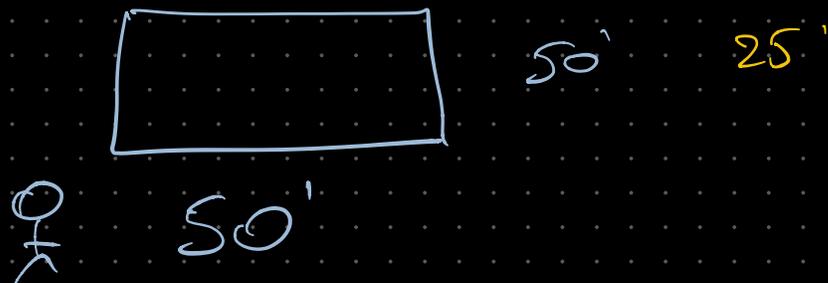


TCP

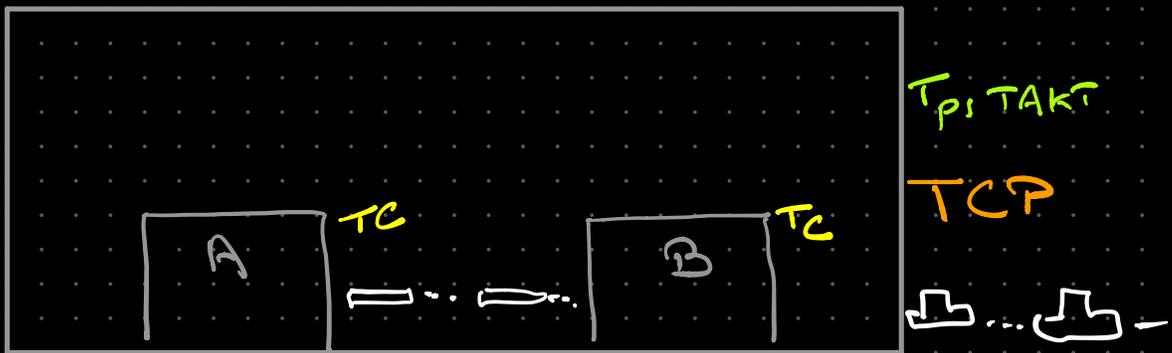
50"
40"
30"

Temps cycles

Diagramme
Rythmes



$$15 = 244$$

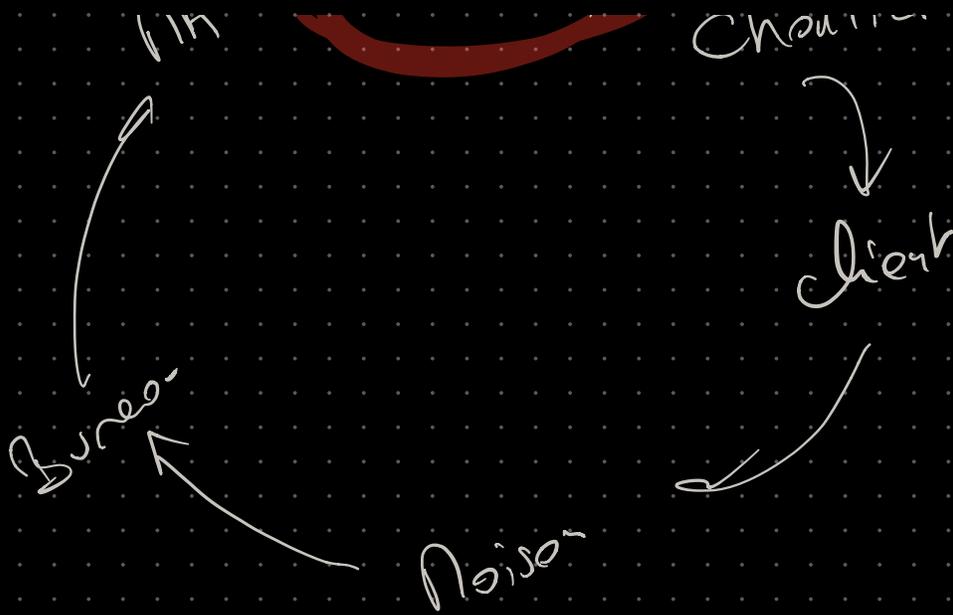


TC : Temps moyen entre 2 sorties d'un octaite

TCP : temps moyen entre 2 sorties de processeur que je ne pise

TTAKT : temps moyen entre 2 sorties que je vise pour être synchro avec Den.





$$0,85 \times 0,8 \times 0,85 = 0,65$$

First Pass Yield

Fabio:

13h30 - 14h00

11h30

15



~~134h~~ ~~134h~~
144

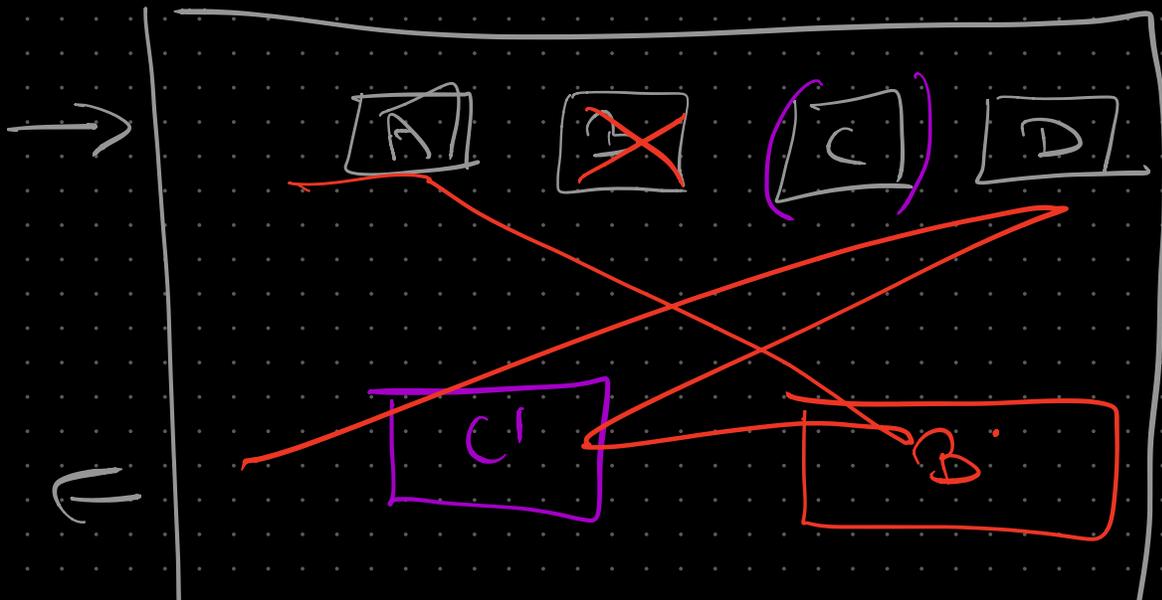
14 knots

Resumé du nouveau
Tpr Trait.

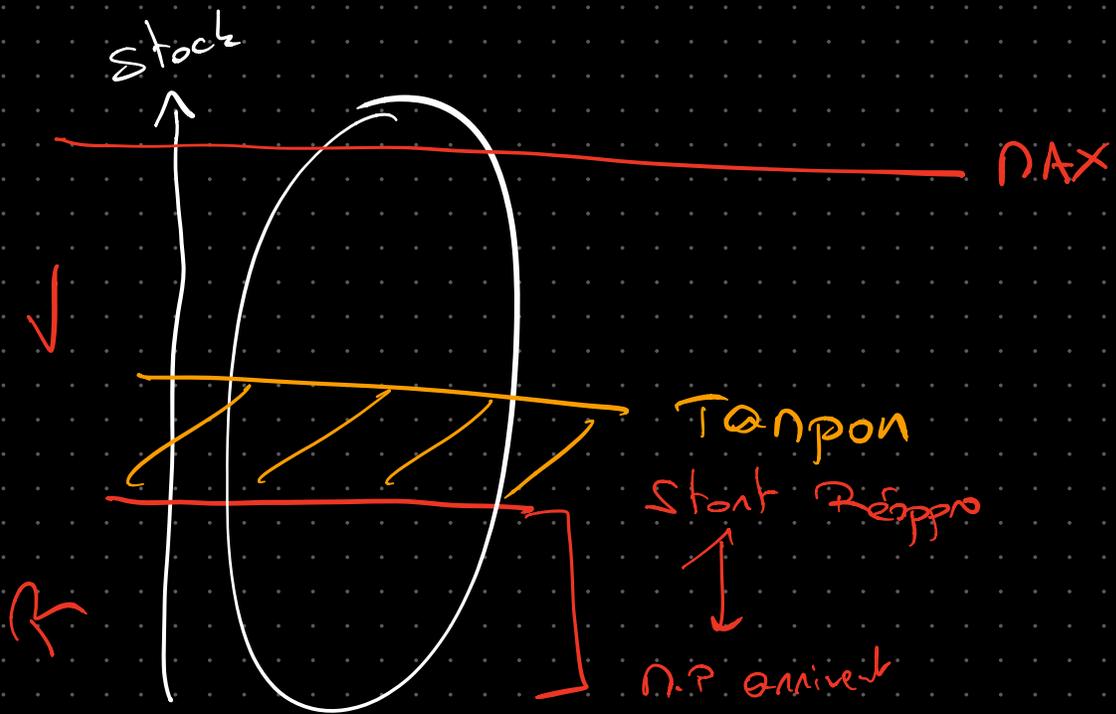
$$\text{Temps Cycle} = \frac{\text{Tps Traitement Proc.}}{\text{ETP}}$$

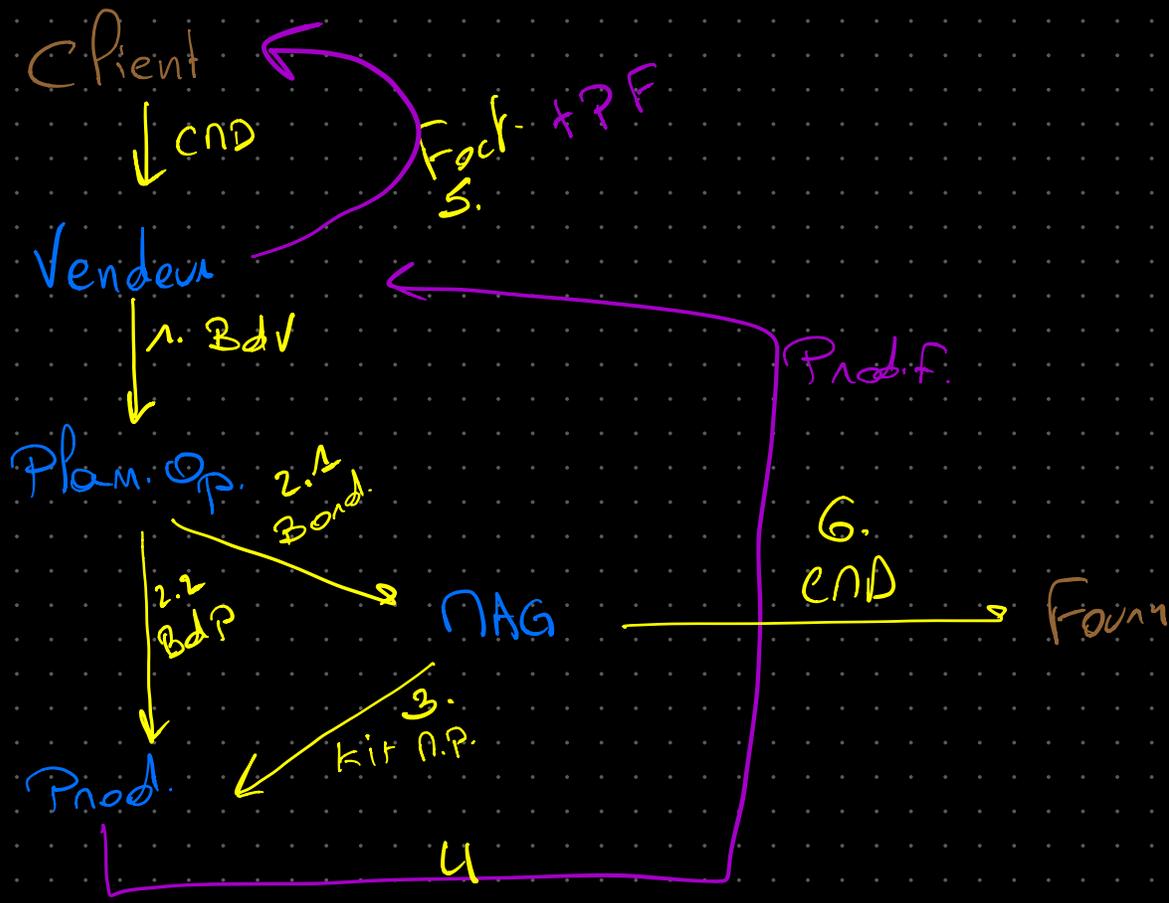
Temps Total

$$\text{ETP} = \frac{\text{Nouveau Tpr Trait.}}{\text{Temps Total}}$$

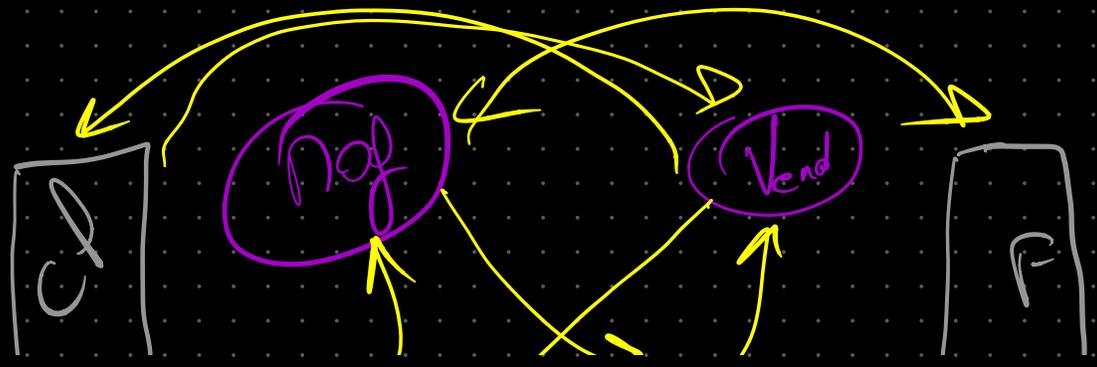


Reprise à 14h





Temps Total = 20 sec.



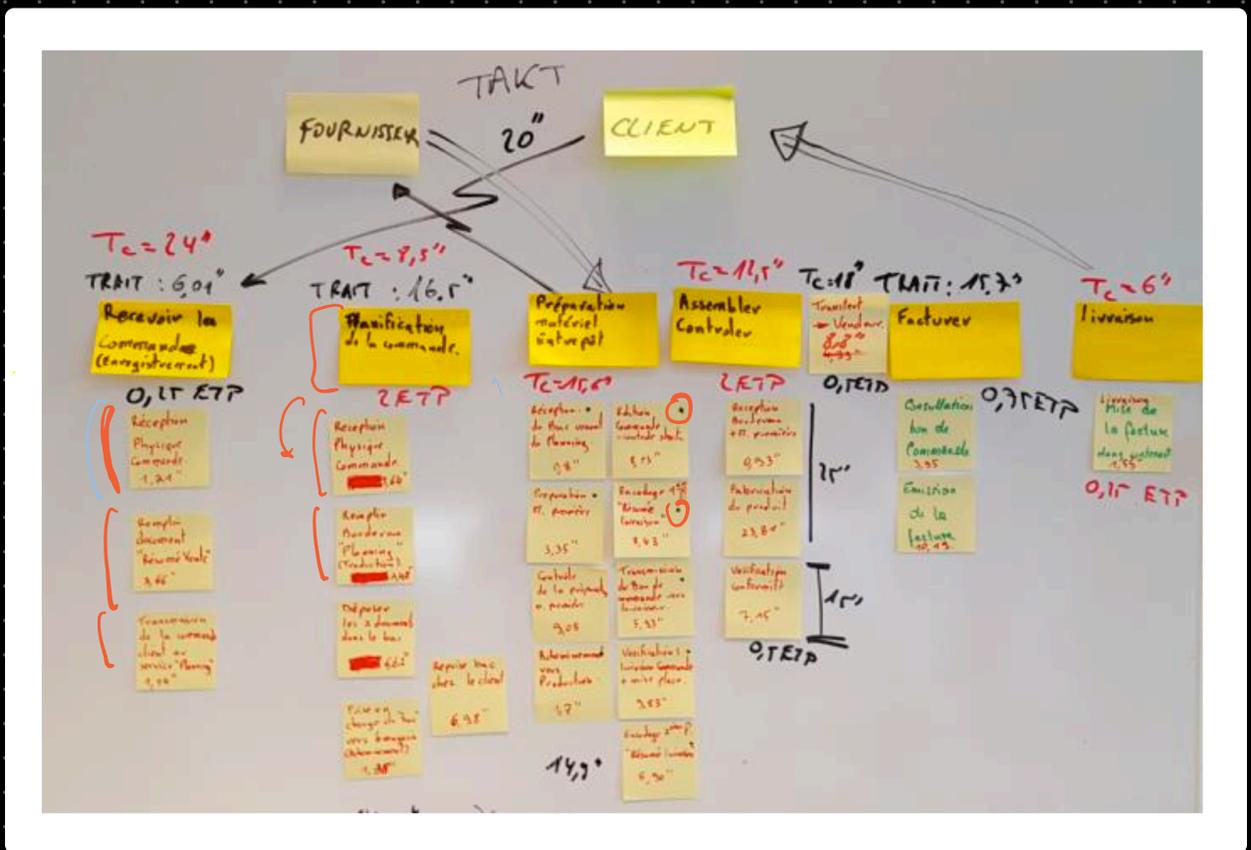


Groupe 1

PP assemblage

- Eric
- Isnoel
- Vincent

Groupe 2





10

B	V	J
—	—	—
—	—	—
—	—	—
—	—	—
—	—	—
—	—	—
—	—	—
—	—	—
—	—	—
—	—	—

$$\frac{\text{Temps Initiation}}{\text{Temps Test}} = \text{ETP} \quad \frac{55 \text{ sec}}{20 \text{ sec}} = 3 \text{ ETP}$$

$$\text{Débit} = \text{Tps Tn.t.U} + \frac{\text{WIP}_F}{\text{Déb. Sortie}}$$

100

80

20

$$\text{WIP}_F \text{ MAX} = (\text{Débit} - \text{Tps Tn.U}) \times \text{Déb. Sortie}$$

10