

Make the welding bay ready to work

Fabrication fit-up, consumables and return

Oily bench edges, mixed fixtures and trailing leads slow preparation and hide the intended condition. Trial one bay with the weld team before expanding the arrangement.



PROPOSED CONCEPT / A-GRADE TARGET, NOT AN ACHIEVED SCORE

SAMPLE START	PROPOSED TARGET	EVIDENCE COVERAGE
27.8% Grade D	90.3% A-grade target	72% 18 of 25 criteria

The visible fit-up bay, fixture storage and local material return. Welding procedures, fume assessment, hot-work controls and machine suitability remain with authorized local owners.

Sample inspection notes supply the numbers. Generated scenes illustrate the arrangement. A starts at 90% of observed criteria; unknown Sustain evidence stays unscored.

See the change. Keep the same workplace.

The proposed arrangement keeps the machinery and viewpoint. It is a discussion image.

ILLUSTRATIVE STARTING CONDITION



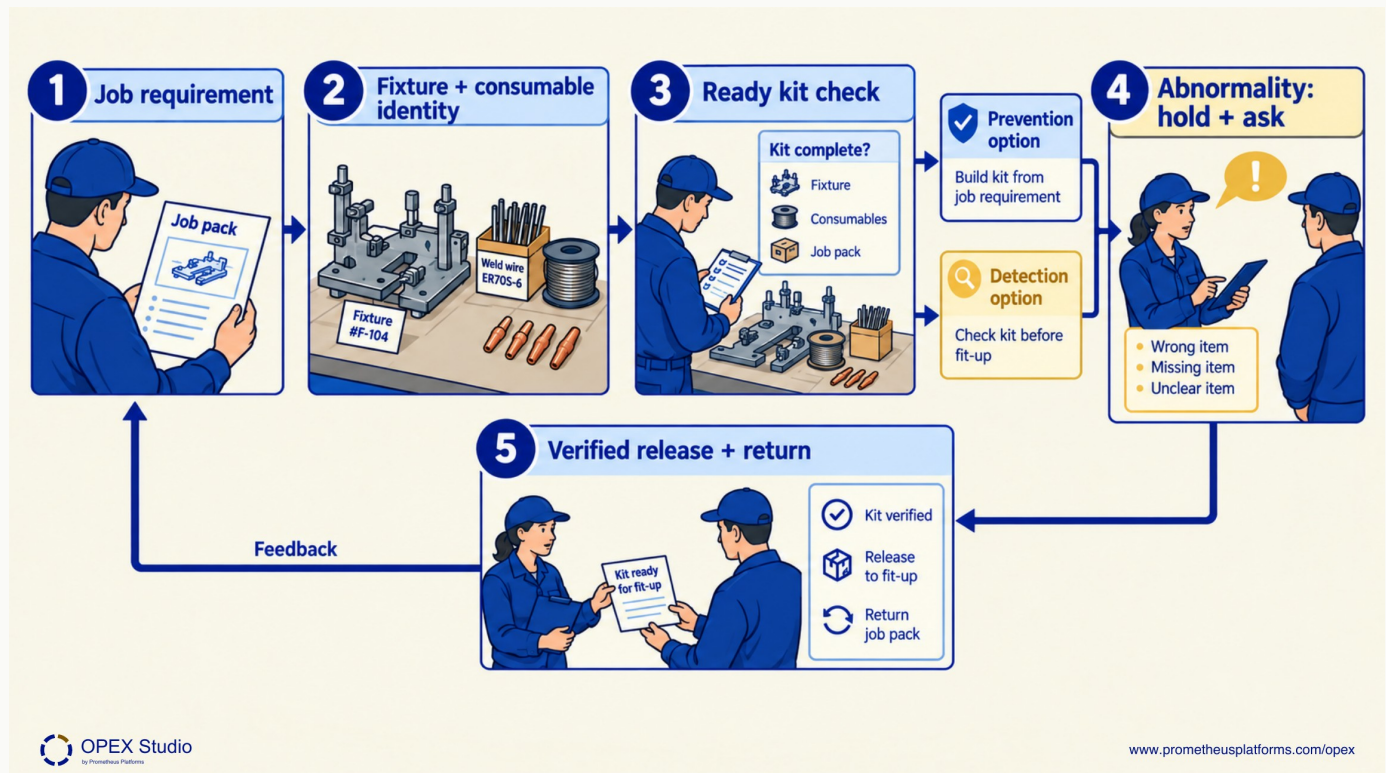
PROPOSED CONCEPT / A-GRADE TARGET



Neither scene verifies guarding, technical suitability, sustained practice or an earned result. Use actual inspection and recheck evidence before accepting any improvement.

Build the correct kit before fit-up

Make the welding bay ready to work



GENERATED TEACHING ILLUSTRATION / FICTIONAL WORKPLACE

01	02	03	04	05
Job requirement	Fixture + consumable identity	Ready kit check	Abnormality: hold + ask	Verified release + return

Retained kit-preparation search: 12 observations, median 8 minutes; proposed goal 3 minutes. Start with the approved job pack and finish with correct verified fixtures and consumables at fit-up.

The retained twelve preparation-search observations have an 8-minute median and 3-minute goal. A kit standard must make the right item easier to select, not merely make all items look organized. Teach quality at source through visible identity, readiness and abnormality response. A proposed physical cue may prevent selection error; a check may detect one. Each needs verification. Welding parameters, extraction and other technical controls remain with approved practice.

TRY IT / DISCUSS

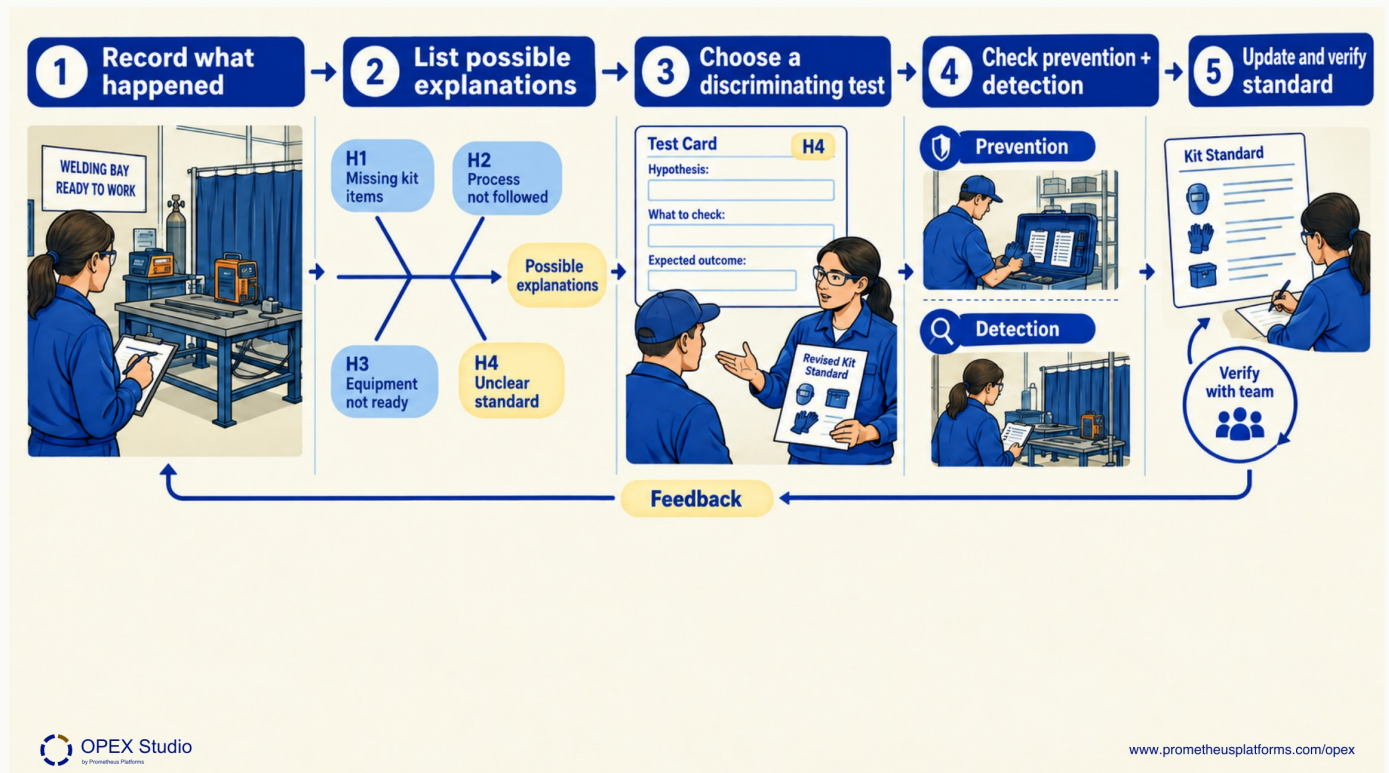
How does a shaped fixture location differ from a final visual inspection?

Check your reasoning: It may prevent an incorrect selection; inspection detects a condition. Neither should be claimed effective without a test.

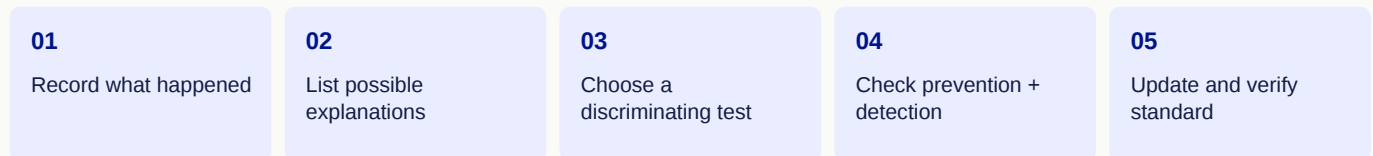
METHOD SOURCES / Q09: Jidoka | Q10: Fishbone Diagram | Q07: Gemba | F10: Standardized Work

Observe the condition before choosing the fix

Make the welding bay ready to work



GENERATED TEACHING ILLUSTRATION / FICTIONAL WORKPLACE



Record the exact wrong or missing item, job context and consequence. Ask the people doing the work how the kit is prepared. Use a cause diagram to organize possible explanations, then test the useful ones. Check both whether the proposed change prevents the error and whether remaining errors are detected. Repeated exposure after implementation is needed before claiming recurrence prevention.

TRY IT / DISCUSS

Is Operator careless an adequate causal statement?

Check your reasoning: No. Investigate the conditions, information, standard and system that shaped the action.

METHOD SOURCES / Q09: Jidoka | Q10: Fishbone Diagram | Q07: Gemba | F10: Standardized Work

Six standards. One clear next step.

The baseline is an authored inspection exercise. Target levels are proposed for the same criteria.

Category	Start	Target	Observed	Coverage
Sort	30%	75%	5/5	100%
Set in order	37.5%	87.5%	4/4	100%
Shine	18.8%	100%	4/4	100%
Standardize	25%	100%	2/4	50%
Sustain	Unknown	Unknown	0/3	0%
Safety	25%	100%	3/5	60%

Start: $20 / 72 = 27.8\%$. Target: $65 / 72 = 90.3\%$. Unknown criteria remain outside both scores.

Priority work and accountable owners

Due	Action / sample owner	What must be checked
Day 7	Agree the bay boundary Jada / Fabrication lead	Confirm material identity, fixture status and local work-control requirements.
Day 14	Restore clear positions Tom / Maintenance lead	Tom records the residue-source investigation, authorized correction and real recurrence check; verify the storage arrangement too.
Day 21	Practice the handover Amira / Welding lead	Each shift demonstrates the correct consumable and fixture selection.
Day 30	Verify the preparation Ben / Quality lead	Repeat twelve comparable preparation samples and review local control evidence.

Correct the source, then check the condition

Tom / Maintenance lead / day 14: Identify why grease or debris recurs, record the authorized equipment or handling correction, then inspect again after normal bay use.

- Fume extraction, shielding, hot-work arrangements and suitable consumables need competent verification; a clean bay does not establish them.
- Retain material and consumable identification through every sort and relocation.
- Any rerouting of leads or equipment must respect the local approved work arrangement.

The physical condition.

Criterion by criterion.

All notes are authored examples. Levels describe the sample starting condition; targets require later verification.

Existing production criterion	Sample inspection note	Start / target
Required materials production-01	Current-job plates and unidentified remnants occupy the same rack position.	1/4 3/4
Tool selection production-02	Clamps needed now are mixed with unused fixtures.	1/4 3/4
Inactive equipment production-03	A damaged stand remains inside the active fit-up zone.	1/4 3/4
Scrap separation production-04	Sharp offcuts and reusable pieces share the same unbounded holding area.	1/4 3/4
Working surface production-05	Part of the fabrication bench remains usable, with unnecessary fixtures at its edge.	2/4 3/4
Tool locations production-06	Frequently used clamps have no consistent home positions.	1/4 3/4
Material locations production-07	Stock racks are recognizable but several items need clearer identification.	2/4 3/4
Travel paths production-08	A stored frame narrows the marked walking approach.	1/4 4/4
Work sequence production-09	The receive-fit-up-return sequence exists but crosses a storage position.	2/4 4/4
Floor condition production-10	The sample notes record oily residue and loose debris at the bay edge.	0/4 4/4
Equipment exterior production-11	Exterior dust and grease conceal small changes in equipment condition.	1/4 4/4
Waste containers production-12	The scrap container is congested and loose pieces sit beside it.	1/4 4/4
Cleaning access production-13	The cleaning position is blocked by a spare fixture.	1/4 4/4

Review state: pending. An unknown is not a zero. Keep the original rubric definition and record what was accepted, changed, rejected or still needs an on-site check.

Standards, routine and safety.

Keep unknowns visible.

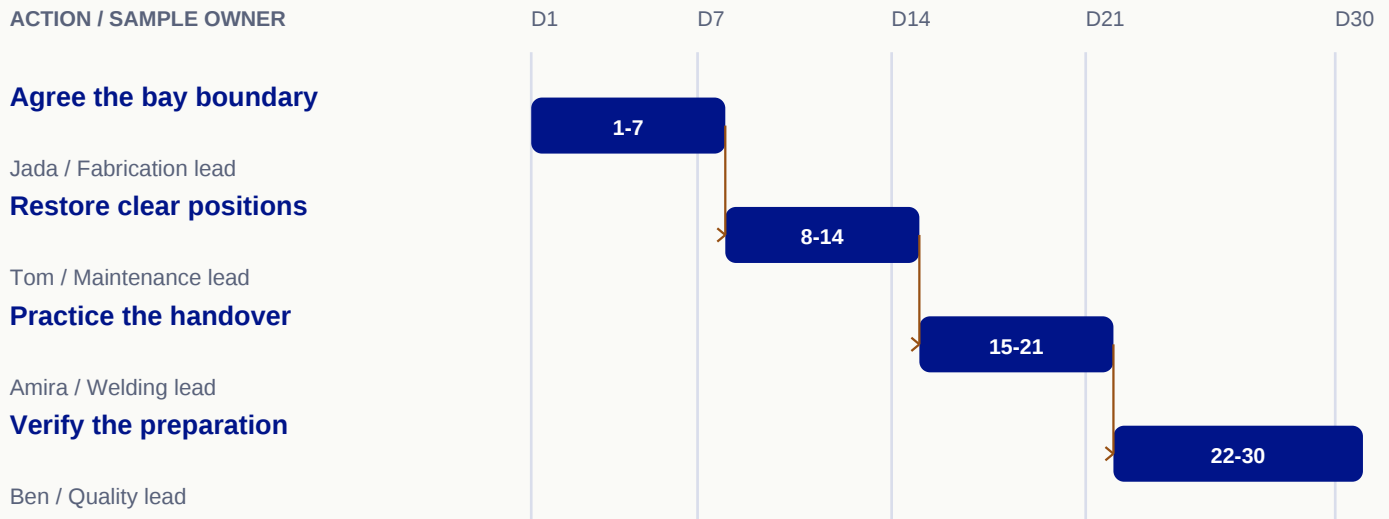
All notes are authored examples. Levels describe the sample starting condition; targets require later verification.

Existing production criterion	Sample inspection note	Start / target
Location labels production-14	Fixture-location labels are incomplete in the sample walkthrough.	1/4 4/4
Visual instructions production-15	No readable point-of-use instruction evidence is supplied.	Unknown Unknown
Condition reference production-16	The sample arrangement reference omits the lead-return route.	1/4 4/4
Inspection prompts production-17	No clear inspection-prompt evidence is supplied.	Unknown Unknown
Recorded checks production-18	No repeated checks are supplied.	Unknown Unknown
Issue follow-through production-19	No open-to-closed issue history is supplied.	Unknown Unknown
Ownership cues production-20	No retained reset-ownership record is supplied.	Unknown Unknown
Emergency route production-21	The sample local walk identifies a stored frame narrowing an exit approach.	1/4 4/4
Guarding visibility production-22	Machine guards and protective arrangements need competent local review.	Unknown Unknown
Trip exposure production-23	Leads and offcuts cross the walking approach in the sample notes.	1/4 4/4
Emergency equipment access production-24	Emergency-device access is not established in the inspection record.	Unknown Unknown
Hazardous material containment production-25	The sample notes flag an unidentified container for local handling review.	1/4 4/4

Review state: pending. An unknown is not a zero. Keep the original rubric definition and record what was accepted, changed, rejected or still needs an on-site check.

Thirty days. Owners, checks and follow-through.

A fictional sample team and proposed operating-day sequence. Each phase depends on the previous check.

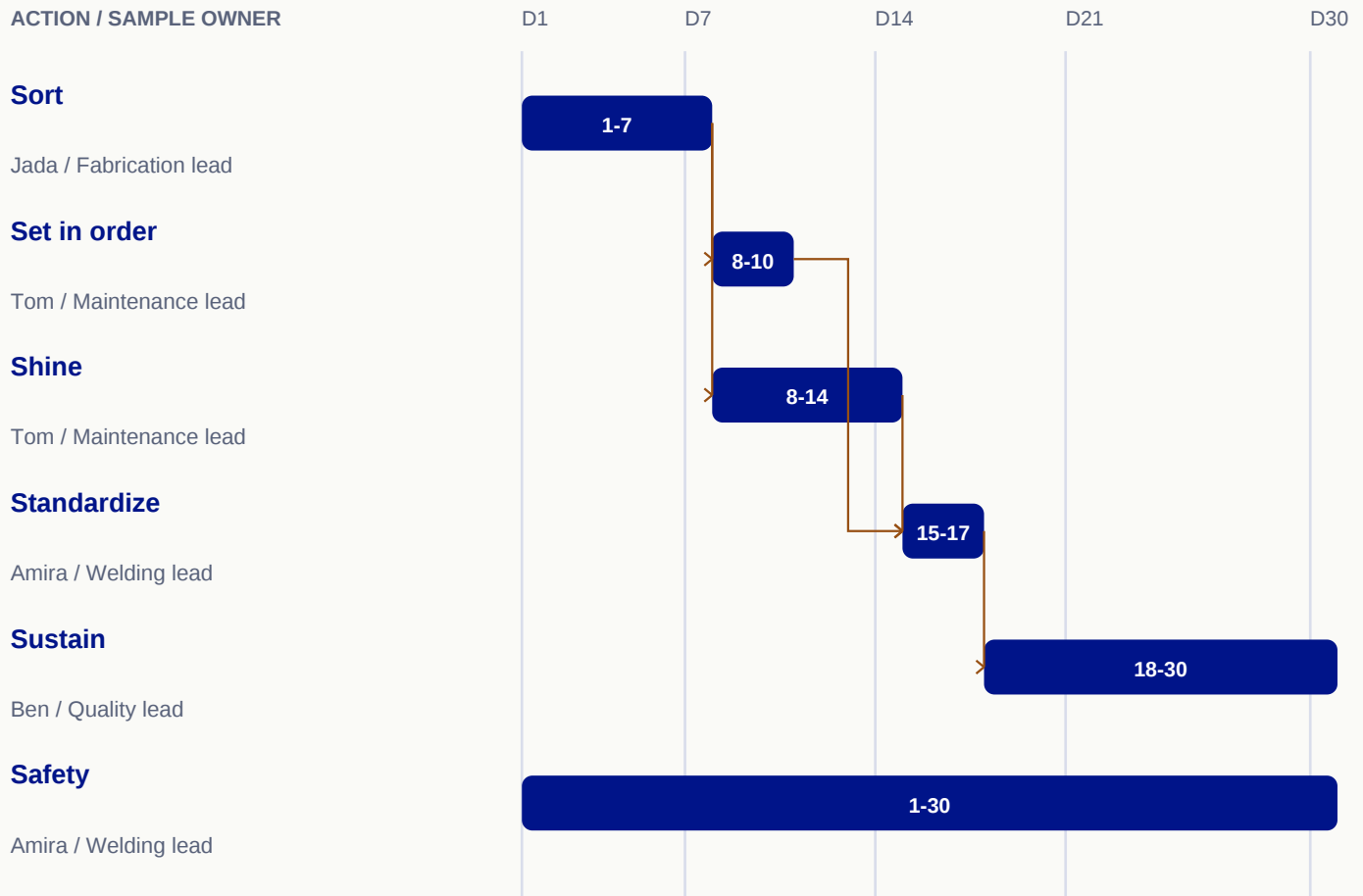


Day	Decision / owner	Evidence to bring
1	Agree scope and local controls Jada / Fabrication lead	Fume extraction, shielding, hot-work arrangements and suitable consumables need competent verification; a clean bay does not establish them.
3	Record the starting condition Jada / Fabrication lead	Retain the item register, sample observations and full timing definition.
7	Accept one bounded trial Jada / Fabrication lead	Confirm material identity, fixture status and local work-control requirements.
10	Check the proposed arrangement Tom / Maintenance lead	Ask a second practitioner to demonstrate the correct selection and return route.
14	Keep, adapt or reverse the trial Tom / Maintenance lead	Tom records the residue-source investigation, authorized correction and real recurrence check; verify the storage arrangement too.
21	Review both shifts and exceptions Amira / Welding lead	Each shift demonstrates the correct consumable and fixture selection.
25	Collect the complete recheck Ben / Quality lead	Repeat twelve comparable preparation samples and review local control evidence.
30	Decide and assign the next review Ben / Quality lead	Compare actual results with the target; retain unresolved work and set a day-60 review.

Choose actual dates around approved access, operating shifts and required technical checks. A failed trial can return to an earlier phase.

Six S. One shared timeline.

Proposed project completion: operating day 30. Each workstream has a named owner; Safety remains active throughout.



Arrows show the checks that must finish before the next dependent action starts. Sort is followed by arrangement and correction of recurring problems; both feed the agreed standard.

Day 30: review, decide and assign the next step

Review the measured project result, all six workstreams and unresolved actions before deciding to retain, revise or extend the trial.

Required local controls are checked before the trial and remain active throughout.

Repeated checks provide evidence for review; the schedule does not establish a Sustain score.

Fictional sample team. Relative operating days; set real dates with the responsible team. A due date is a planned check, not evidence of completion.

What each S will deliver.

Proposed actions and acceptance evidence. All results remain unmeasured until the team completes its checks.

S / owner / timing	Action to complete	Evidence for acceptance
Sort Jada / Fabrication lead Days 1-7	Separate usable materials Identify reusable stock, offcuts, damaged leads and unneeded fixtures with the fabrication lead.	Each item has an approved use or disposition; uncertain equipment remains out of service pending review.
Set in order Tom / Maintenance lead Days 8-10	Clarify fixtures and leads Trial defined positions for fixtures, tools and stored leads while preserving screens, extraction and cylinder restraints.	The next setup retrieves the required fixtures and the bay access remains clear.
Shine Tom / Maintenance lead Days 8-14	Remove grime and find recurrence Maintenance investigates repeated grease, oil and debris sources and verifies the approved corrective response.	The cause is addressed and the next operating cycles are checked; cosmetic cleaning alone cannot close it.
Standardize Amira / Welding lead Days 15-17	Agree the bay handover Publish the accepted fixture locations, lead storage and reset check with the welding lead.	The receiving shift demonstrates the handover and reports missing equipment or recurring concerns.
Sustain Ben / Quality lead Days 18-30	Review repeated setups Track fixture-ready time, missed handovers and unresolved conditions through the month.	Comparable setup observations and action closure evidence support the day 30 decision.
Safety Amira / Welding lead Days 1-30	Check welding work controls The competent welding lead checks approved hot-work arrangements, extraction, screens and cylinder restraint before the layout trial.	Existing work authorization and equipment controls are confirmed; the illustration proves none of these.

The receiving owner checks the evidence before closing an action. Record a failed check, the next response and a revised review date; do not mark the whole project complete because the area looks better.

Check the real change. Keep what works.

The concept starts the conversation. The recheck decides whether the work improved.

Process measure	Sample start	Proposed goal	Actual recheck
Kit preparation search	8 minutes	3 minutes	Not measured

Median of 12 authored sample observations. Start with the approved job pack; finish when the correct verified fixtures and consumables are available at fit-up.

Also protect: No incorrect material, consumable or unverified fixture enters the work kit.

Bring evidence to the day-30 decision

1. Retain an actual later source image from the same area and a comparable viewpoint.
2. Review every criterion against its original definition; record what is still unknown.
3. Repeat the full 12-observation timing sample using the same start/end rules.
4. No incorrect material, consumable or unverified fixture enters the work kit.
5. Review repeated checks, misses and issue response separately from the visible-condition score.
6. Adopt, adapt or stop based on actual evidence; retain the first report and create a new revision.

Keep the improvement working

Routine	Sample owner	Response
Each-shift reset	Amira / Welding lead	Record a missed check or recurring concern and assign the next action.
Comparable process sample	Ben / Quality lead	Review the complete sample and any quality or workload tradeoff.
Day-60 review	Jada / Fabrication lead	Confirm continued use, unresolved work and the next improvement cycle.

Original OPEX production rubric opex-6s-2026-09-v1. The A threshold is 90%; this is a conditional visible-condition target, not an organization rating or safety certificate. Fictional people, authored sample notes and generated scenes; no achieved result is claimed.