

A clearer start for every cut order

Saw station, stock identification and offcut return

Oily floor patches, loose offcuts and mixed stock obscure the saw station's ready condition. Begin with stock identification, the walking route and the approved return process.



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

SAMPLE START

26.3%

Grade D

PROPOSED TARGET

90.8%

A-grade target

EVIDENCE COVERAGE

76%

19 of 25 criteria

Visible stock staging, tool return and the saw surroundings. Blade selection, guarding, feeds, workholding and technical cutting methods remain with competent authorized 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



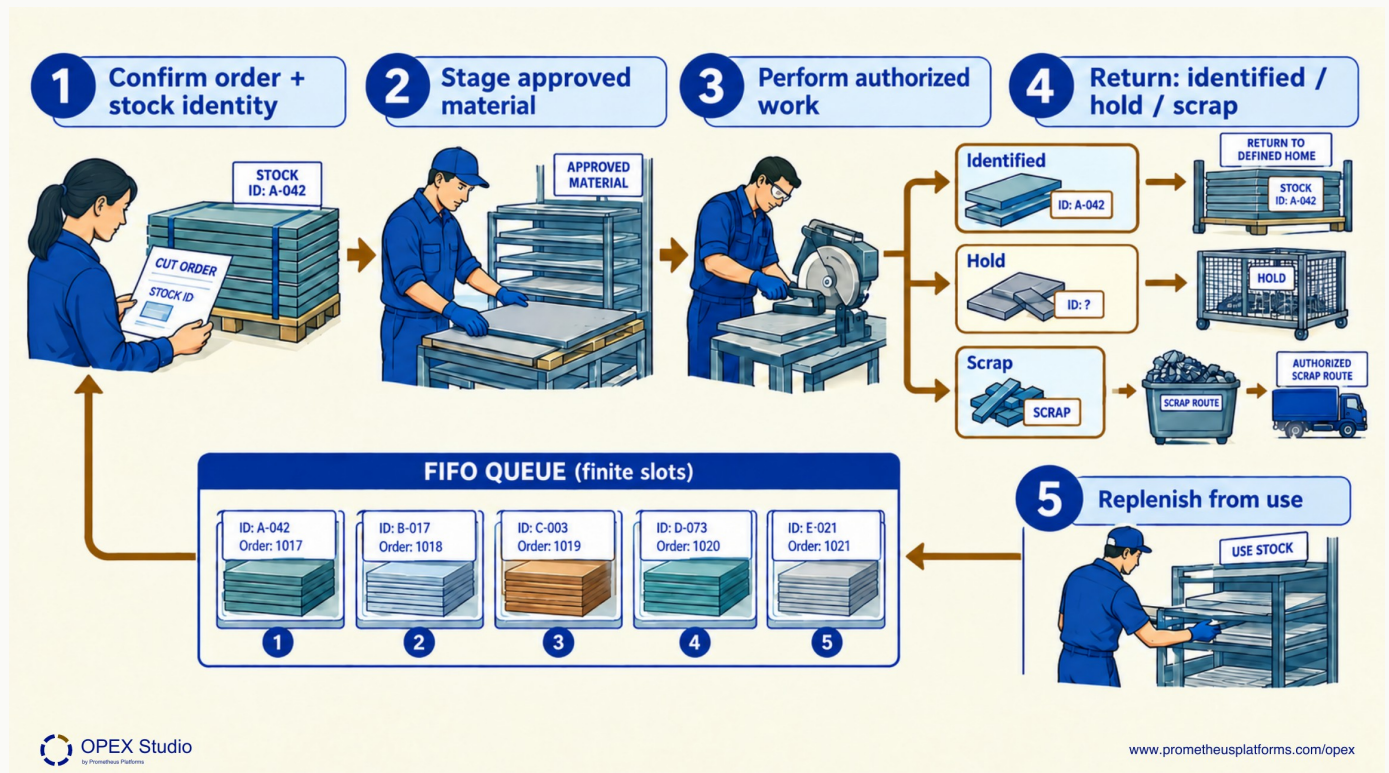
PROPOSED CONCEPT / A-GRADE TARGET



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

Keep stock identity through the whole route

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GENERATED TEACHING ILLUSTRATION / FICTIONAL WORKPLACE

01	02	03	04	05
Confirm order + stock identity	Stage approved material	Perform authorized work	Return: identified / hold / scrap	Replenish from use

Retained order-preparation search: 15 observations, median 4.8 minutes; proposed goal 2 minutes. It runs from released order to readiness of identified stock and verified preparation items.

The retained fifteen order-preparation search observations have a 4.8-minute median and 2-minute goal. Preserve grade, identity and traceability through preparation and return. A FIFO lane controls sequence only when entry, exit, capacity and exception rules are defined. Unknown material must not be made usable by a new label alone. The clean floor and stock layout cannot prove coolant source correction or a safe cutting method.

TRY IT / DISCUSS

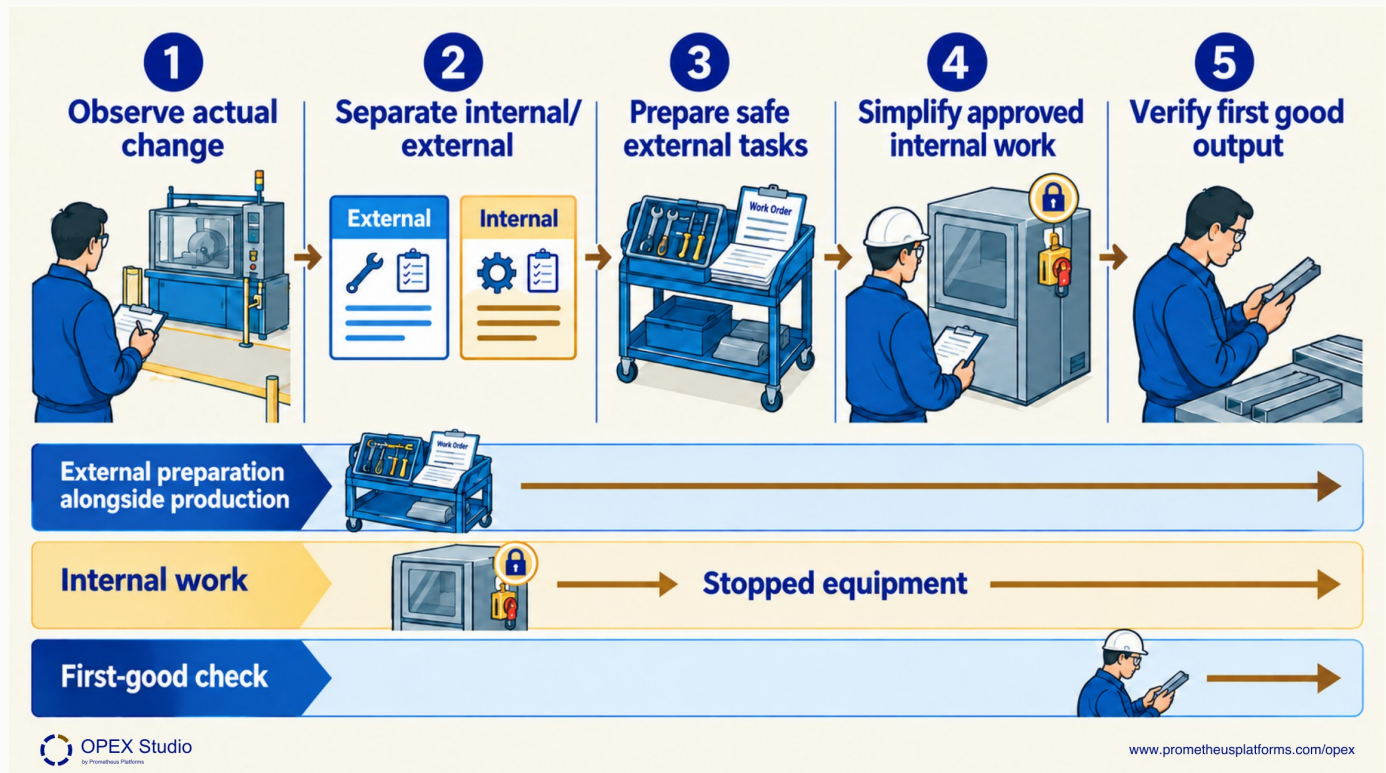
What happens when the FIFO lane is full?

Check your reasoning: Use the agreed stop/escalation rule; do not add an untracked overflow pile.

METHOD SOURCES / F06: First In, First Out (FIFO) | F12: Single Minute Exchange of Die | S04: OSHA: Control of Hazardous Energy

Prepare externally; protect the controlled change

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GENERATED TEACHING ILLUSTRATION / FICTIONAL WORKPLACE

01 Observe actual change	02 Separate internal/external	03 Prepare safe external tasks	04 Simplify approved internal work	05 Verify first good output
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SMED studies changeover so suitable preparation can happen outside the machine-stopped period and necessary internal work can be simplified safely. It does not mean every setup must take one minute. Observe the actual change from last good output to first good output using a consistent definition. The saw case has no measured changeover dataset, so this page is an introductory teaching extension. Never reclassify a task as external if it needs isolation or another controlled state.

TRY IT / DISCUSS

Can all cleaning or adjustment be moved to while the machine runs to shorten downtime?

Check your reasoning: No. Follow task-specific authorization and energy controls; only genuinely safe, approved external preparation can move.

METHOD SOURCES / F06: First In, First Out (FIFO) | F12: Single Minute Exchange of Die | S04: OSHA: Control of Hazardous Energy

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	31.3%	87.5%	4/4	100%
Shine	18.8%	100%	4/4	100%
Standardize	25%	100%	3/4	75%
Sustain	Unknown	Unknown	0/3	0%
Safety	25%	100%	3/5	60%

Start: $20 / 76 = 26.3\%$. Target: $69 / 76 = 90.8\%$. Unknown criteria remain outside both scores.

Priority work and accountable owners

Due	Action / sample owner	What must be checked
Day 7	Define ready stock Nia / Line lead	Separate identified stock, awaiting-review lengths and approved scrap decisions.
Day 14	Restore the work zone Leo / Maintenance lead	Leo records the residue-source investigation, authorized correction and real recurrence check; verify the storage arrangement too.
Day 21	Practice the return Riya / Shift trainer	Two shifts demonstrate stock identification, return and a missing-label response.
Day 30	Check the next orders Sam / Quality lead	Repeat fifteen comparable order preparations and retain the complete result set.

Correct the source, then check the condition

Leo / Maintenance lead / day 14: Investigate the fluid-residue source through the authorized maintenance process and check the same location after normal approved operation.

- Do not infer guard, blade, workholding or control suitability from the concept image.
- Preserve stock grade and job identification when moving long lengths or offcuts.
- Chip and residue removal must follow the authorized local machine and cleaning process.

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 cut-order stock is mixed with lengths awaiting identification.	1/4 3/4
Tool selection production-02	Required measuring tools sit among unused accessories.	1/4 3/4
Inactive equipment production-03	An unused support stand is separated but still constrains the work zone.	2/4 3/4
Scrap separation production-04	Reusable lengths and scrap offcuts share one holding space.	1/4 3/4
Working surface production-05	Loose stock and tools restrict the preparation surface.	1/4 3/4
Tool locations production-06	Measuring tools have no consistent return position.	1/4 3/4
Material locations production-07	Stock positions do not clearly distinguish identified and awaiting-review material.	1/4 3/4
Travel paths production-08	Offcuts and a cart narrow the visible movement route.	1/4 4/4
Work sequence production-09	The receive-cut-return sequence exists, with a conflict at offcut return.	2/4 4/4
Floor condition production-10	The sample notes record oily residue and loose chips at the station approach.	0/4 4/4
Equipment exterior production-11	Exterior buildup makes a new leak or damage harder to notice.	1/4 4/4
Waste containers production-12	The scrap bin is near capacity with pieces beside it.	1/4 4/4
Cleaning access production-13	Access to the cleaning position is narrowed by a spare stand.	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.

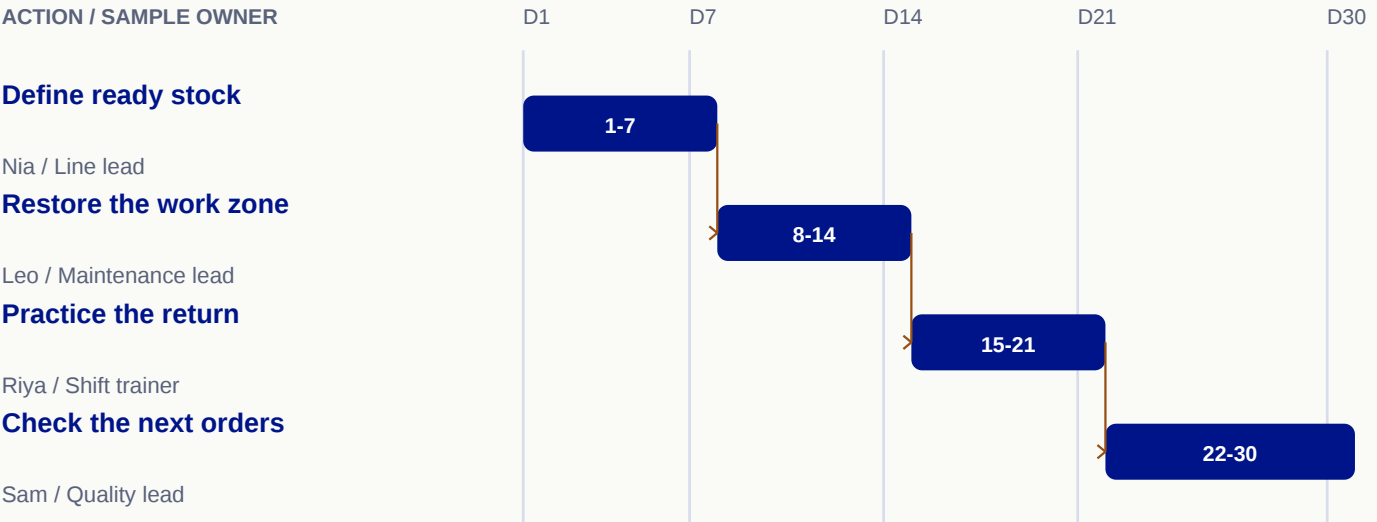
All notes are authored examples. Levels describe the sample starting condition; targets require later verification.

Existing production criterion	Sample inspection note	Start / target
Location labels production-14	The sample stock-location labels are incomplete.	1/4 4/4
Visual instructions production-15	The local instruction is not easily read from the preparation position.	1/4 4/4
Condition reference production-16	No current arrangement-reference evidence is supplied.	Unknown Unknown
Inspection prompts production-17	A draft check prompt does not identify a clear exception response.	1/4 4/4
Recorded checks production-18	No repeated check record is supplied.	Unknown Unknown
Issue follow-through production-19	No issue-closure history is supplied.	Unknown Unknown
Ownership cues production-20	No retained reset-owner record is supplied.	Unknown Unknown
Emergency route production-21	The sample local walk records stock narrowing an emergency approach.	1/4 4/4
Guarding visibility production-22	Saw guards, workholding and control effectiveness require authorized verification.	Unknown Unknown
Trip exposure production-23	Chips, offcuts and a hose loop interrupt walking space.	1/4 4/4
Emergency equipment access production-24	Emergency-device approach evidence is not supplied.	Unknown Unknown
Hazardous material containment production-25	The sample notes flag one fluid container needing identification and local 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.

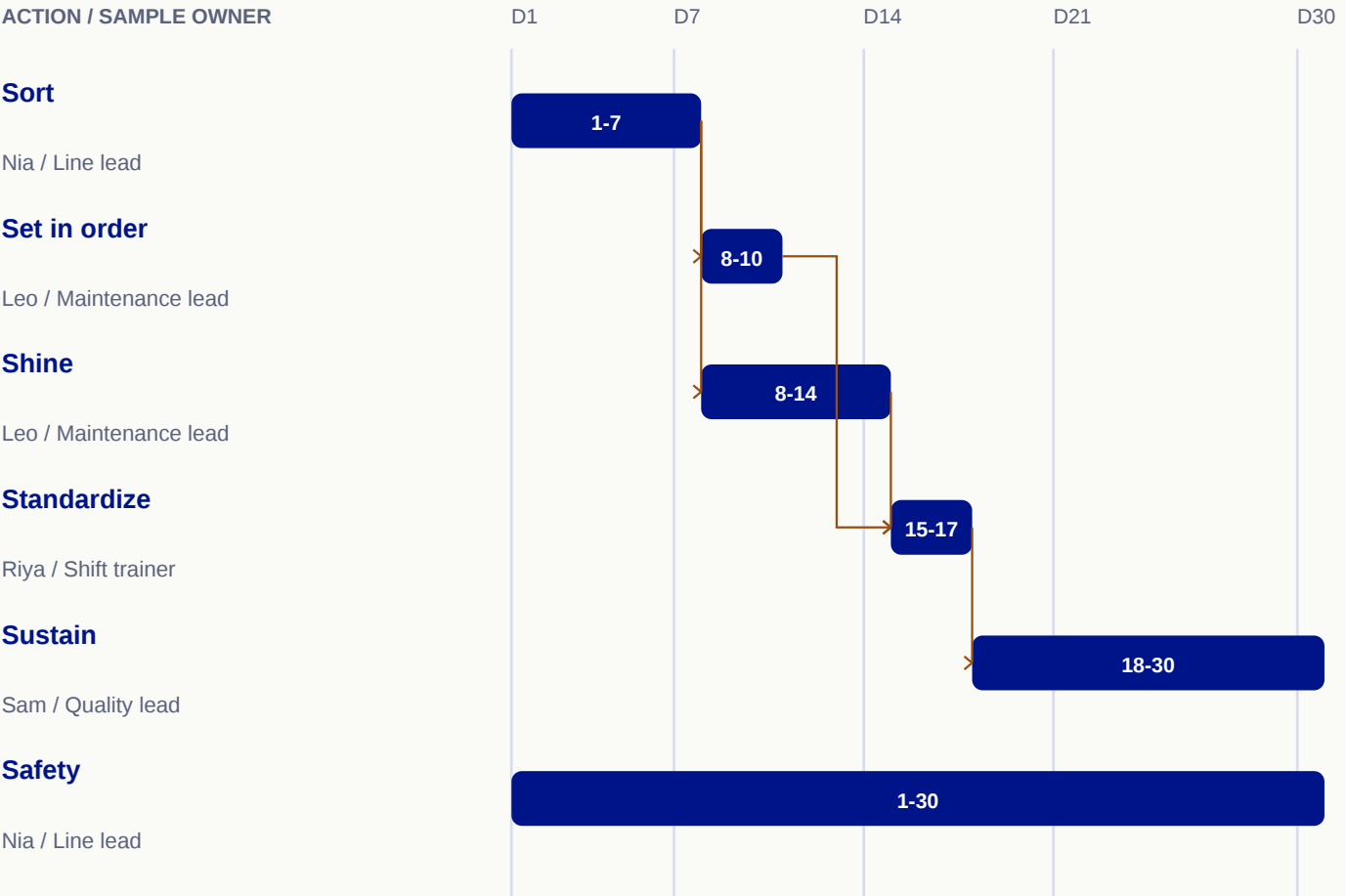


Day	Decision / owner	Evidence to bring
1	Agree scope and local controls Nia / Line lead	Do not infer guard, blade, workholding or control suitability from the concept image.
3	Record the starting condition Nia / Line lead	Retain the item register, sample observations and full timing definition.
7	Accept one bounded trial Nia / Line lead	Separate identified stock, awaiting-review lengths and approved scrap decisions.
10	Check the proposed arrangement Leo / Maintenance lead	Ask a second practitioner to demonstrate the correct selection and return route.
14	Keep, adapt or reverse the trial Leo / Maintenance lead	Leo records the residue-source investigation, authorized correction and real recurrence check; verify the storage arrangement too.
21	Review both shifts and exceptions Riya / Shift trainer	Two shifts demonstrate stock identification, return and a missing-label response.
25	Collect the complete recheck Sam / Quality lead	Repeat fifteen comparable order preparations and retain the complete result set.
30	Decide and assign the next review Sam / 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 Nia / Line lead Days 1-7	Separate stock and offcuts Identify required stock, reusable offcuts and scrap through the line lead; preserve stock grade and traceability.	Every retained length has an identity and intended use; scrap cannot be mistaken for released material.
Set in order Leo / Maintenance lead Days 8-10	Arrange supported stock Trial clear stock and offcut positions while preserving the saw, guards, roller support and outfeed geometry.	The next order can be prepared with the correct stock and existing support throughout handling.
Shine Leo / Maintenance lead Days 8-14	Correct coolant recurrence Maintenance investigates coolant and oil at the base, makes the approved correction and checks following operating cycles.	The source and follow-up check are recorded; wiping away coolant alone does not close the issue.
Standardize Riya / Shift trainer Days 15-17	Agree the order-ready reset Document accepted stock identity, offcut return and area-reset checks with the line lead.	The receiving shift uses the same ready condition and reports missing identity or an abnormal condition.
Sustain Sam / Quality lead Days 18-30	Review the next cut orders Track stock-ready time, offcut returns and recurring coolant across comparable orders through day 30.	The final review includes preparation time, quality checks and unresolved actions.
Safety Nia / Line lead Days 1-30	Keep saw controls effective The competent line lead reviews guarding, stock support, handling and required isolation before any rearrangement.	Approved saw controls and material support remain in place; the concept cannot authorize operating changes.

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
Order preparation search	4.8 minutes	2 minutes	Not measured

Median of 15 authored sample observations. Start with the released cut order; finish when correct identified stock and verified preparation items are ready.

Also protect: Every sampled order retains correct stock grade, length identification and required approval.

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 15-observation timing sample using the same start/end rules.
4. Every sampled order retains correct stock grade, length identification and required approval.
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	Riya / Shift trainer	Record a missed check or recurring concern and assign the next action.
Comparable process sample	Sam / Quality lead	Review the complete sample and any quality or workload tradeoff.
Day-60 review	Nia / Line 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.