

OWNER

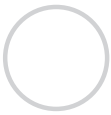
DEPT

DATE

/ /

**KAI  
ZEN**  
CHANGE GOOD

FEELS



DESCRIBE THE PROBLEM

OVERPRODUCTION

TRANSPORTATION

MOTION

WAITING

PROCESSING

INVENTORY

DEFECTS

IDENTIFY/QUANTIFY WASTE

EFFORT  
(@ \$1 per min)



MATERIALS  
(Cost + 15%)

TOTAL WASTE

POSSIBLE ROOT CAUSES

WE AGREE TO WORK ON THIS PROBLEM



Owner

Mentor

TODAY'S FIX

PREVENTATIVE ACTION

COUNTERMEASURES WHICH CAN BE TAKEN

TRUTH • BIT • PULL

COUNTERMEASURES WHICH WILL BE TAKEN



ESTIMATED SAVINGS



KNOW & SHOW THE TRUTH

WE AGREE TO WORK ON THIS PLAN



IMPROVE EVERYDAY

Owner \_\_\_\_\_



BEST FOR OUR BEST

Mentor \_\_\_\_\_

Walked on mm / dd / yy

FEELS

Owner \_\_\_\_\_

Mentor \_\_\_\_\_

