

# **Six Sigma Tack Time simple counting to control flow.**

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### **Introduction**

It's know that to control processes the very basic principle of counting is needed like in statistics. So in this document we explore in a easy way terms frequently used in corporations and manufacturing plants. Then we will see why tools to count and register are needed and finally will see how this six sigma concepts, together of course with the best approach of landing the methodology to specific situations can help to make better decisions and best productions.

So let's start to know about the easy terms used in lean manufacture.

## **1. Lean manufacturing and six sigma terms**

### **a) Flow**

The flow since the lean manufacture point of view is the progressive way to achive different activities that are part of the value flow, so the product progress from desing to to its launch, from its purchase order to its delivery an from its prime materials to the hands of the client without having stops, scrap and reworks.

### **b) Pull**

Pull is a system that connects the work orders and the delivery information from the final operations to the starter ones. In this system nothing is produced at the starting operations until a specific Kanban signal of requirement is sent from the finals operations.

### **c) Standard job**

A precise description all and every task that from a job including CYCLE TIME and TACK TIME, the sequence of every activity and the minimum quantity of pieces from warehouse at the hand to do the operation. Defining the standard job is considered a very important activity in clean manufacture.

### **d) Tack Time**

Tack time is the result from dividing the time available to produce by the customer demand in that period of time.

### **e) Just In Time JIT**

Its a system to produce and deliver the right items at the right time in the right quantities. So the key elements in JIT are FLOW, PULL, STANDARD WORK and TACK TIME.

### **f) Cycle Time CT**

CT is the time required to finish a operation cycle . A goal to in clean manufacture is to make equal the CT to the TACK TIME in order to have the “flow of a unitary piece”.

## **2. Tack time on line, not just display else registering.**

So we need to start counting on the lines to start applying six sigma concepts , the comes the idea to put a display in the lines so they can know what is the production target of the day, what is the tack time the line have to finish a product , how many products are ready according the tack times, how many were not ready, and how many were rejected, so we need computational tools in order to start to count what events are happening on the line.

### **a) Why displaying it?**

The dashboards, screen boards, LCD displays or simple boards always states simple things: This is what the line need to accomplish, this is how the line is doing it, and this is what the line still is missing or leaking. So its very important a supervisor and all the people that is working on the line can see constantly what is happening with the production. Then it's important to display tack time because a display give sense to every one involved of how things goes and what are the goals.

### **b) Why register it?**

Well if everybody knows what is happening today in the line but tomorrow a new history is happening but never written, anyone won't be able see historical behaviours , and of course any good decision could be made because there is no information that can back opinions nor facts.

### **c) Why on line?**

With the Internet is possible to have at the hand web applications that helps manufacture plants to have displays on their lines, register the events happening on the lines, and store info in database so that supervisor, administrators and people with provedges on the application can see the information needed to take decisions or to feed other task of the six sigma methodology.

Also a web application minimizes software property and can see all over the world. So a good outsourcing service of tack time like [etacktime.com](http://etacktime.com) can be a clean solution in the tack time area.

## **3. Looking forward.**

Applications like tack time can provide the informations of events in lines, so having for

example a comma separated value file, a manufacture plant can easily upload the info to their ERP systems or the CSV file can be opened in Excel and have charts, and of course the info can be used to have stats , thats why its very important to register the information, etacktime.com also protect the information of the line by signing disclousere agreements of confidentiality.

Please visit <http://www.etacktime.com>

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