

SCORE CASE STUDY

WORKSHOP IMPROVEMENT WITH 5S AT MIFACO CO., LTD.

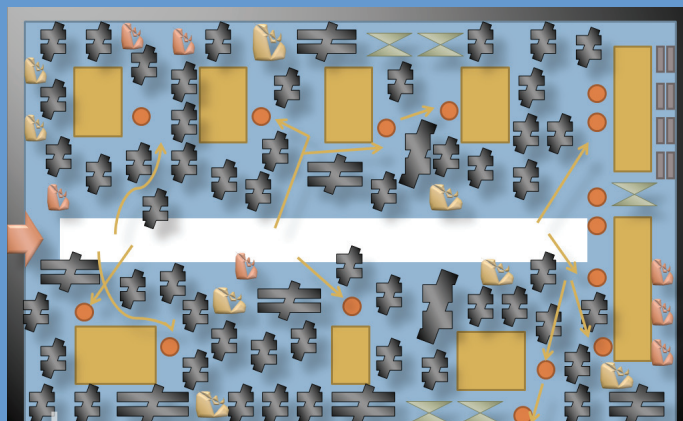
Mifaco Co., Ltd. was established in 2013. The company locates in Binh Duong province and employs 750 employees. Mifaco participated in SCORE from Mar 2012 and implemented module 1: Workplace cooperation and module 2: Quality management. The Enterprise Improvement Team (EIT) was established with 8 members including 4 managers and 4 line workers.







Workshop re-arrangement following 5S was a key improvement of the company. The EIT implemented the re-arrangement in 5 steps: 1- Sorting ; 2- Straightening; 3- Sweeping; 4- Standardizing; 5- Sustaining. Prior to the implementation, 5S planning and trainings were conducted with the involvement of the workers.

Before improvement, unused items and work-in-process reduce the usable space of the workshop floor, block the walkway, create risks and waste of time in transportation inside the workshop.

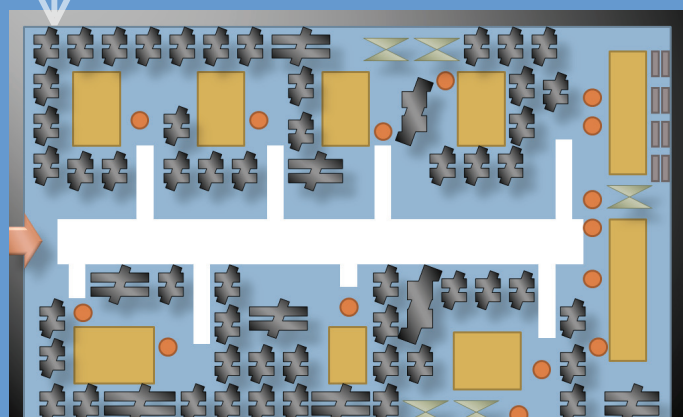
At step 1, all unused items and waste materials were removed from the workshop. At step 2, as the positions of machines were fixed, all work-in-process and raw materials were re-arranged to utilize all available space. Each pallet with standard size 1mx1m was used as a space unit for the new workshop layout. At step 3, the whole area and all items stay within went through a careful cleaning process. Upon the completion of step 3, a new standard was set for workshop arrangement. A monitoring and evaluation process was also developed for continuous improvement.

Workshop layout before improvement

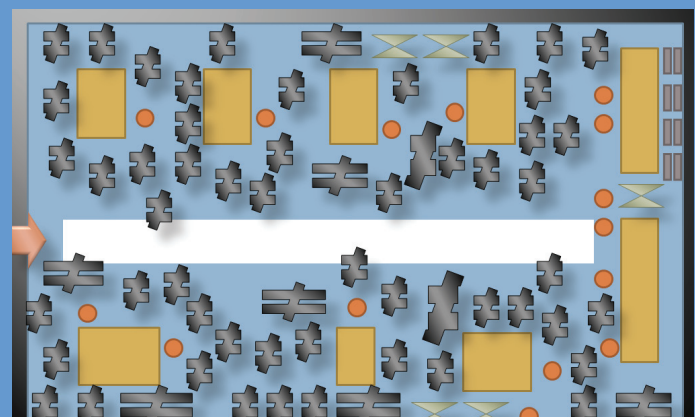


-  unused items/ waste materials
-  work-in-process/ raw materials
-  machine
-  worker
-  movement toward working position
-  supporting area

Workshop layout after "Straightening"



Workshop layout after "Sorting"



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