The following report summarizes typical cost savings and productivity gains addressed by the work plan:

Category	"Non-Value Add", Costs and Symptoms	Value	Action
Resource Utilization	• Overtime; large period of wait time. • Machines not scheduled to capacity. • Hot jobs push competing orders and increase changeover costs. • Inventory carry/hold liabilities.	• Variable cost and resource savings. • Enhance revenue from increased turnover. • Resources no longer used for worst-case scenario.	• Use optimized lead times to schedule resources, operations and processes to capacity. Control variation in performance of employee and machine.
Process Visibility	• Order processing issues with MRP results in delivery of partial orders. • Missed picks when material issued onto production floor.	• Increase business throughput by corrective action on root cause of production delays and target misses. • Place corrective action at the failure source in inventory, production, order processing.	• Identify events that cause low resource utilization and low business velocity. • Improve upon baseline.
Inventory Control	• Inventory, WIP, finished goods are lost in transit between operations. • Slow/No visibility into order status. • Slow/No visibility into product staging for production and load/pack at shipping.	• Decrease stock outs, late material issue, late material reorder, lost material. • Increase value add at staging of material with increased inventory accuracy.	• Integrate electronic barcoding into inventory exchange between operations and process steps. • Material order based on yield and scrap rates.
Process Engineering	• Start/Stop of production, waiting on supervisor resolution.	• Decrease reliance on tribal knowledge to fill blind spots. • Optimized process/production allows flexibility to absorb process issues.	• Standardize exception handling with updated setup/plan checklist.
Customer Relationship	• Customer demands earlier delivery times and strains schedule.	• Avoid customer discounts and freight bills due to late shipment	• Use visibility into status of orders to set and control customer expectations.
Maintenance	• When machines are underutilized the cost of productivity loss is $100's/hour at a single machine.	• Increase machine uptime.	• Capture precise maintenance problems and solution notes. • Prioritize downtime turnaround by solving the most expensive downtime reasons first.