

Cellular/flow manufacturing links manual and machine operations in the most efficient combination to maximize value-added content and minimize waste. Five Step Cell Design Process

- Group Products
- Establish Takt Time
- Review the Work Sequence
- Balance the Process
- Design the Cell Layout

Standard Work is defined to assign work to each person in a specific boundary within the required Takt Time by flowing minimum number of work in process items between operations. Main elements of standard work are:

- Takt time - (Demand rate)
- Work sequence - (Assigned work to each person)
- Standard work in process - (Minimum required) work in process to satisfy the work sequence.

Cell Construction

- Simplify Flows
 - Integrate process operations
 - Materials flow one way
- Minimize Material Handling
 - Concentrate on value added motion
 - Establish material replenishment procedure
- Make Use of People 100 Percent
 - Promote visibility and flexibility
 - U-shape offers most flexibility