

Lean Manufacturing, Positive Business Results Continue

Commitment to lean practices leads to broad and deep benefits for a ResourceMFG manufacturing client

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ResourceMFG[®]
Manufacturing Workforce Specialists

“We didn’t know how transformative lean manufacturing would be. Lean is much more than productivity improvements—the benefits are a mile wide.
— Carey Ryerson, Magpul Vice President of Manufacturing”

lean manufacturing — doing more with less, by systematically reducing waste within a manufacturing system without sacrificing productivity

Sequel to Success

Last year, Magpul Industries successfully managed a transition to a new, larger facility, and to a new lean manufacturing culture. The American producer of high-tech firearms accessories enacted this success story at their manufacturing and distribution center in Cheyenne, Wyoming. ResourceMFG partnered with Magpul to support this change, providing expertise and training in lean practices. **But last year’s story was only the beginning. Magpul reached out to share this updated success sequel—the ongoing rewards of working lean.**

Productivity Surge

Productivity challenges were the initial impetus for the shift to lean manufacturing. Employee training in lean practices and application of lessons learned quickly resulted in productivity benefits. Daily build rates increased along with capacity. Other improvements signaled that long-term benefits would not be limited strictly to productivity: the workforce became more skilled and engaged, labor turnover was cut in half, customer confidence resulted in increased orders, and jobs were created. **Magpul and ResourceMFG celebrated these successes—but the commitment to lean practices was like a train just gaining momentum.**

Transformation

Lean manufacturing has a transformative effect. Productivity continued to improve at Magpul: the workforce is now 2 ½ times more productive than it was. Unapplied labor has dropped from 25% to an astonishing 2%. But as Magpul continued to apply lean practices to various aspects of their operations, other impressive metrics reinforced their commitment to lean and its one-piece flow philosophy.

Increased Delivery Consistency: The variance in the number of units delivered decreased as *delivery volume increased*, consistently hitting the high end of the range. This represents an 87.5 % improvement in consistency.

Units Delivered / Day

	Low End of Range	High End of Range	Variance
Initial	450	850	400
Ending	800	850	50

Inventory Variance Improvement: Related to delivery consistency is inventory consistency. Inventory variance has improved a whopping 94.6% year over year.

BENEFITS A MILE WIDE



Unapplied Labor: 2%



Delivery Consistency: Up 87.5%



Inventory Variance: Down 94.6%



WIP: Down 75%



Downtime: Down 55%

one piece flow — ideal continuous flow of single units through the manufacturing and supply chain based on customer orders

SESSIONS IN LEAN FROM RESOURCEMFG

- 1 Introduction to Lean
- 2 The 8 Wastes of Lean
- 3 6S
- 4 Value Stream Mapping
- 5 Standardized Work
- 6 Pull Systems
- 7 Visual Management
- 8 Lean Plant Layout

Less Work In Progress: WIP product dropped from 200 to 1–2, a 99% improvement. Internal rejects or returns reports dropped by 75%, representing significant reduction in administrative costs.

Decreased Downtime: Average minutes down per line stoppage went from 22 minutes to 10, a 55% improvement. Magpul feels confident they can reach their new goal of 5–8 minutes per incident.

Pick Order Accuracy: This metric has risen to 99.8%, an inspiring achievement given the 5.5 million parts pulled per month, from an inventory of over 10,000 different component parts and 8,000 SKUs.

Setting New Targets

Magpul keeps setting new goals. **According to Cary Ryerson, Magpul Vice President of Manufacturing, their “best next opportunity” is a big one: standardized work practices and ISO certification.** This requires documentation of procedures and compliance with these best practices throughout the operation, from purchasing to payroll, and from customer service to delivery. Certification through the International Organization for Standardization assures customers of consistent product quality—and opens the door to opportunities with international customers. Magpul’s ongoing success with lean manufacturing gives them confidence they’ll meet their goals.

With lean, the journey never ends. **ResourceMFG is proud of their commitment to Magpul’s workforce development and to supporting Magpul’s ongoing success through lean manufacturing.**

ResourceMFG is a manufacturing workforce specialist. It is the first—and, with more than 145 locations in 25 states and over 19,000 workers on assignment—the largest national staffing company to specialize in manufacturing. ResourceMFG recruits and screens for more than 200 manufacturing-specific skills and has developed more than 30 proprietary screening tools. See www.resourcemfg.com.