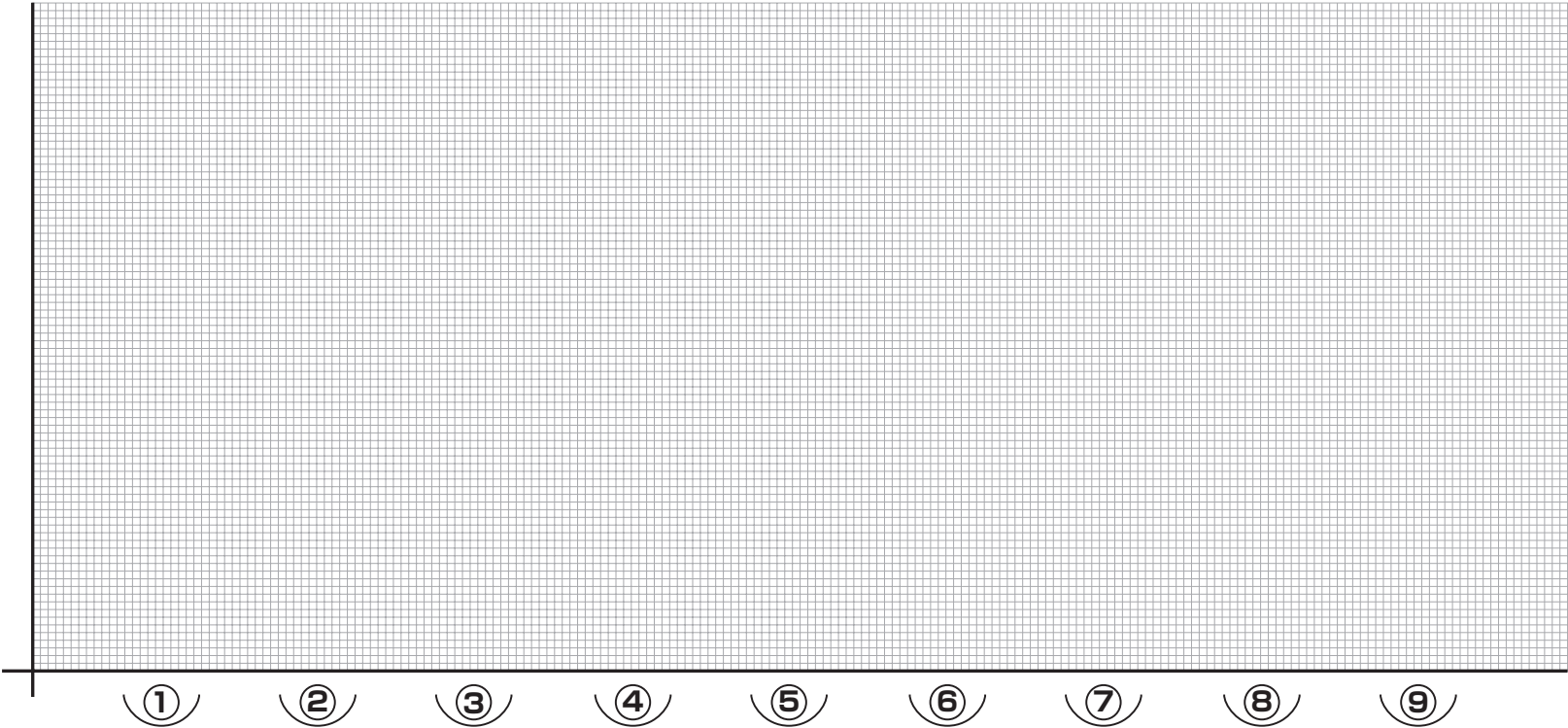


Operator Balance Chart (OBC)

Process:	Product:	Takt Time:	Date/Time:	Notes
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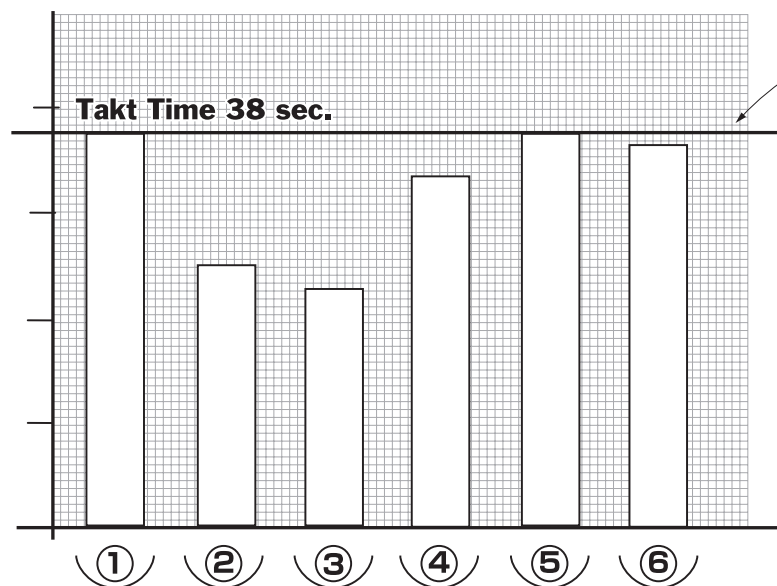


Process										
Time										

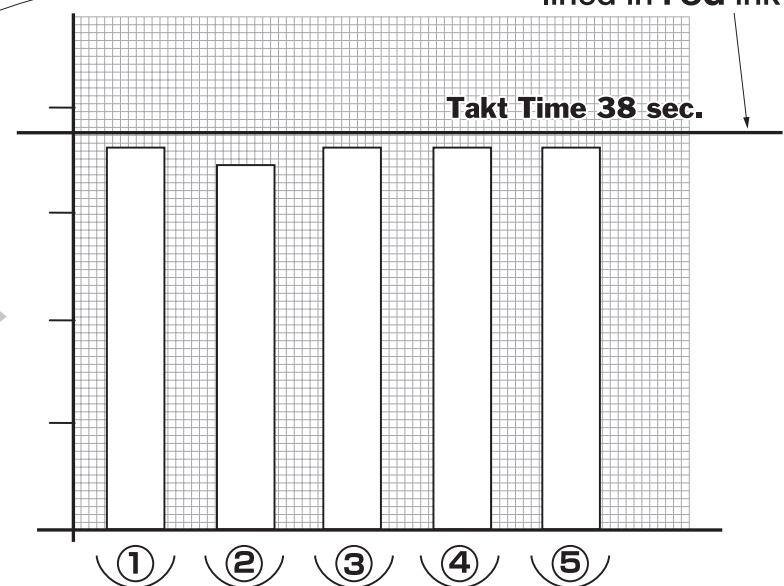
Example of Operator Balance Chart (OBC) (作業者バランスチャートの例)

Process: <i>Final Assembly #7</i>	Product: <i>AB010</i>	Takt Time: <i>38</i>	Date/Time: <i>Mar. 20, 2007</i>	Notes: <i>Kaizen Workshop #10</i> <i>Operator Saving: 1</i>
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Current Situation



After Kaizen



Process	<i>Assemble 1</i>	<i>Assemble 2</i>	<i>Forming</i>	<i>Assemble 3</i>	<i>Tester</i>	<i>Appr.</i>	<i>Total</i>
Time	38	25	22	33	38	37	193

<i>Assemble 1</i>	<i>Forming</i>	<i>Assemble 2</i>	<i>Tester</i>	<i>Appr.</i>	<i>Total</i>
37	36	37	37	37	184