

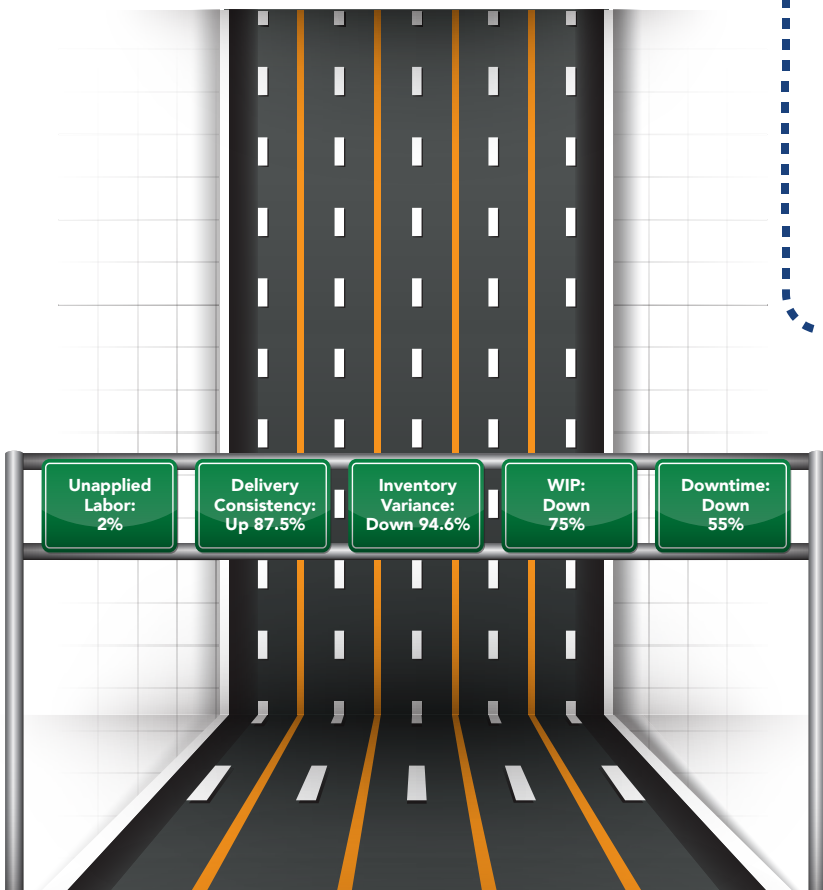
LEAN MANUFACTURING, POSITIVE BUSINESS RESULTS CONTINUE

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

"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

BENEFITS A MILE WIDE



SEQUEL TO SUCCESS

In 2017, 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, sister brand of Westaff, 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.**

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

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.



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.



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

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.**



INVENTORY VARIANCE IMPROVEMENT:

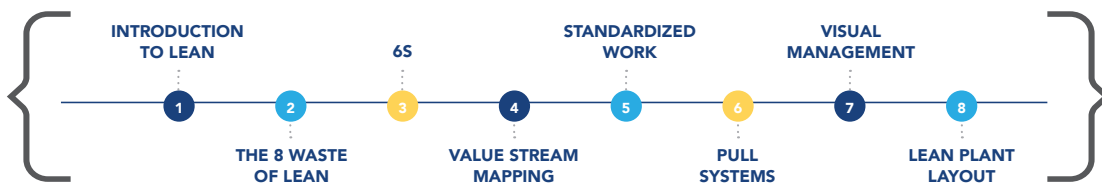
Related to delivery consistency is inventory consistency. Inventory variance has improved a whopping 94.6% year over year.



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.

SESSIONS IN LEAN FROM ResourceMFG



ONE PIECE FLOW — ideal continuous flow of single units through the manufacturing and supply chain based on customer orders.

Presented by Keith Wisner, Vice President, Customer & Workforce Insights.



Westaff, one of the leading staffing firms in the country, is part of the EmployBridge portfolio of companies. Combined, they are ranked by Staffing Industry Consultants as the 10th largest staffing firm in the world.