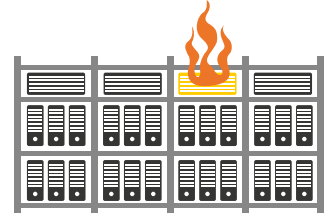




Transportation

Refers to the displacement of finished or semi-finished products which are subjected to risks of deterioration, loss, additional time or additional workload.



Defects

Each time there are defects in and rejections of finished or semi-finished products, additional costs are necessary to restore the products, destroy the faulty ones and restart production.



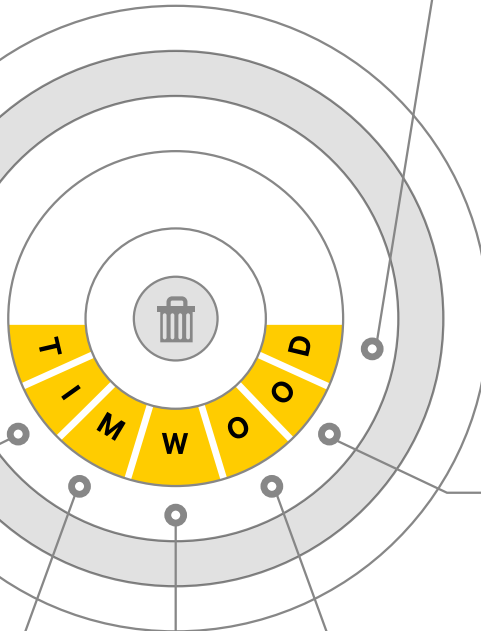
Inventories

Refers to intermediate storage and inventories created during a process. These do not contribute to product transformation and generate more expense without adding value.



Motion

Refers to the ineffective movement of human or material resources over the course of a manufacturing process, which could cause unnecessary deterioration, wear and tear of products and security risks.



Over-processing

Refers to unnecessary activities and jobs or those that do not add value to the customer, as well as tools (such as software, procedures or working instructions) that are too precise, complex or more expensive than necessary.



Over-production

Overproduction occurs when more products are made than are deemed necessary by customer demands or orders. Underproduction is also an issue for IT Operations.

Waiting
When products and services are not being transported or included in the manufacturing process, they are left waiting for the next activity or job.

