

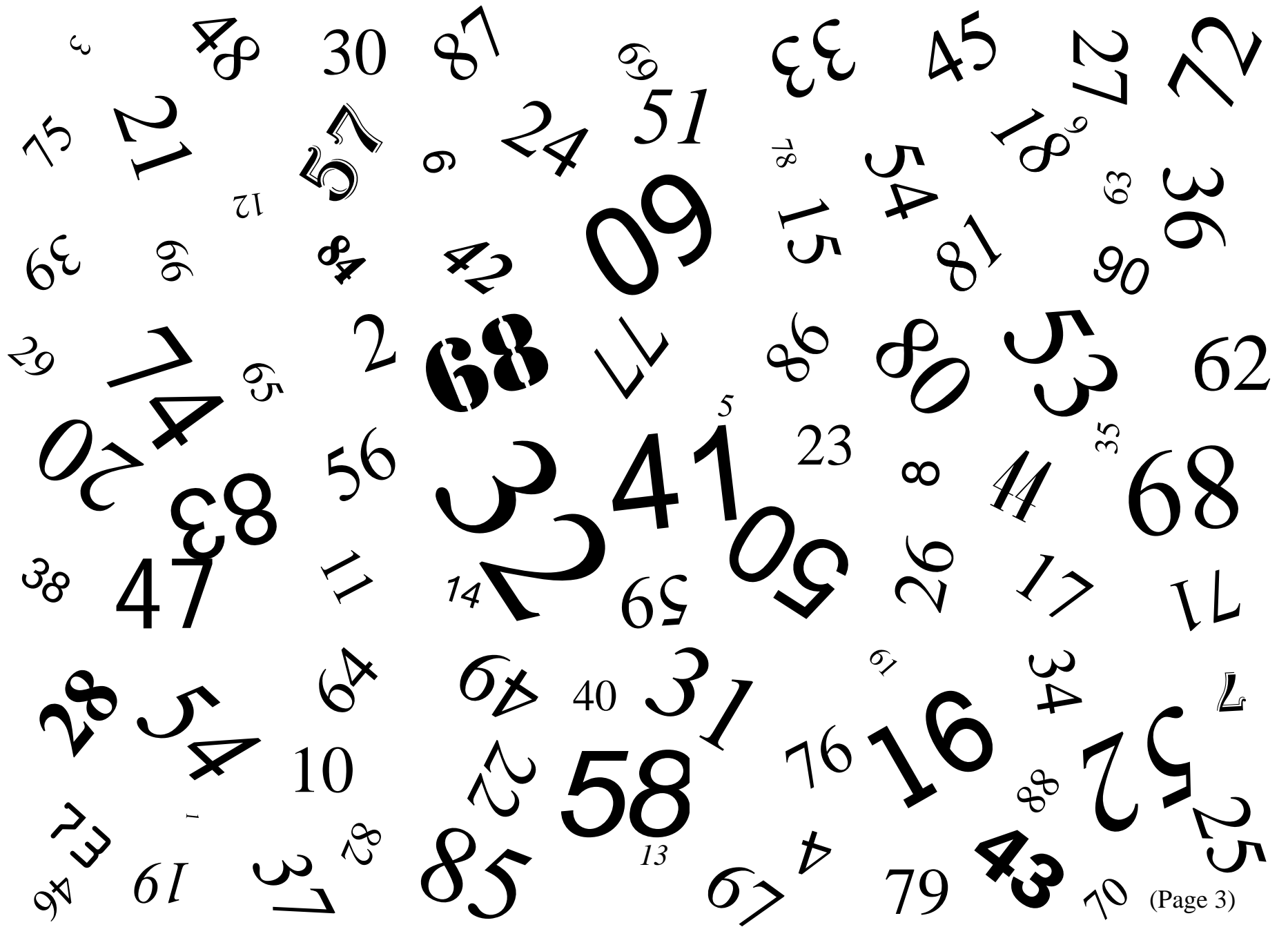
The 5S Numbers Game.

Sort ▪ Set in Order ▪ Shine ▪ Standardize ▪ Sustain

This exercise is adapted from a version I found on the web
created by Kirt Tassmer, Stanley Fastening Systems.
The original game was developed by RWD Technologies Ltd.

**The Worksheet on the following page represents the
Current State of our Work Place.** *[no peeking !]*

- Your Job is to use a pen or pencil to Strike Out the numbers 1 to 49 in Correct Sequence. **Example:** ~~1~~ ~~2~~ ~~3~~
- You will have 30 seconds to complete this task.
- The designated time keeper will tell you when to start and announce the end of your task at the 30 second mark.
- When time has been called, ask each person to call out the highest number they crossed out and record these individual scores on an easel chart.
- Circle the Lowest Score – this is the Team’s Official Score for this round. *[You will have more chances! ... Soon]*



“How do you feel about your score ?”

“What appeared to get in the way of achieving a higher score ?”

5S Step #1:
SORT

We are going to implement 5S in this work area.
The first step is “Sort”

- Our Initial Analysis shows numbers 50 to 90 are not essential to our daily tasks ... they have been removed from the work area
- In a moment, you will repeat the “Strike Out” task in the Sorted Work Place on the following page.
- Same rules apply: Use a pen to strike out numbers 1 to 49 in sequence during a 30 second shift
- Record your individual scores and circle the lowest as your Official Team Score for the round

36
27⁹
18
45
33
15
23
8
44
53
7
25
43
16
91
34
26
8
41⁵
31
40
13
4
37
30
2
42
14
6
7
22
11
10
37
47
4
21
39
29
20
38
28
46
19
3
12
24
6
2
11
10
37
47
4
21
39
29
20
38
28
46
19

“How do you feel about your score this time ?”

“What appeared to get in the way of achieving a higher score ?”

5S Step #2:
SET IN ORDER*

* Also referred to as
“Straighten”

Having achieved some improvement, we will now move to the next 5S step “**Set In Order**”

- We have installed some racking on the job site using a 3 X 3 grid.
- We have organized the numbers so that Number 1 is located in the bottom left hand corner and the numbers are sequenced from bottom to top and left to right
Example: #1 in the bottom left, 2 in the middle left, and 3 in the top left, then 4 in bottom middle, 5 in middle middle ... and so on
- Same rules apply: Strike out numbers 1 to 49 in sequence during a 30 second shift. Lowest individual score is your Official Team Score.

36

27⁹

18

45

33

15

24

6

42

30

48

3

21

12

39

7

25

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53

44

8

23

5

41

32

14

2

11

20

47

38

29

34

91

43

31

40

64

22

13

4

10

37

19

28

46

“How do you feel about your score this time ?”

“What appeared to get in the way of achieving a higher score ?”

5S Step #4:
STANDARDIZE

[NOTE: We will skip the third “S” - “Shine” in this game]

Next is the fourth “S” - **“Standardize”**

- After in-depth Work Flow Analysis, we have installed the more detailed racking system on the next page.

[NO peeking !]

- This allows us to re-organize the numbers in a standard fashion which will ease the completion of your task.
- Same rules apply: When you turn the page, strike out numbers 1 to 49 in sequence during a 30 second shift. , lowest individual score equals Official Team Score.

1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17	18	19	20
21	22	23	24	25	26	27	28	29	30
31	32	33	34	35	36	37	38	39	40
41	42	43	44	45	46	47	48	49	

“How do you feel about your score this time ?”

“What appeared to get in the way of achieving a higher score ?”

The 5S Quality Dividend

What benefits can you expect from application of 5S to this workplace ? Let's See.

[Note: technically, we have only worked with 3 of the "S's" to this point]

Quality Audit Alert:

- We have recently discovered two numbers are missing! We cannot finish our job without these numbers - so first we have to find them.
- Your Team Task: Identify the two missing numbers as quickly as possible.

The 5S Quality Dividend

In a moment you will

- Start the timer
- Flip to the next page
- Find the two missing numbers as a team– call them out as you identify them
- Every 30 seconds is a “Shift” of work.
- Timer, please announce the number of shifts out loud as the Team works to find the missing numbers.
- Stop the timer when the numbers are found and announce the total shifts required to complete the task.



“How do you feel about your score ?”

“What appeared to get in the way of achieving a lower score ?”

The 5S Quality Dividend

Let's try that again in the Workplace
that has experienced your “Sort”, “Set in Order”
and “Standardize ” Steps of 5S

In a moment you will ...

- Turn the page
- Start the timer
- Find the two missing numbers
- Count the number of 30 second shifts the task requires
this time

1	2	3	4	5	6	7	8	9	10
11	12	13	14	15	16	17		19	20
21	22	23	24	25	26	27	28	29	30
31	32	33	34	35	36	37	38	39	40
41		43	44	45	46	47	48	49	

“How do you feel about your score this time ?”

“What appeared to get in the way of achieving a lower score ?”

Payoff Questions

- What did you learn in this 5S Numbers Game?
- What else?
- How might you incorporate the 5S process into your current workplace?
- What difference would you expect it to make?

The Fifth “S” is “SUSTAIN”

Imagine you have applied the 5S process to your current workplace and seen improvements as you did in this exercise.

**What would you have to do
– or have to stop doing –
to SUSTAIN these changes ?**