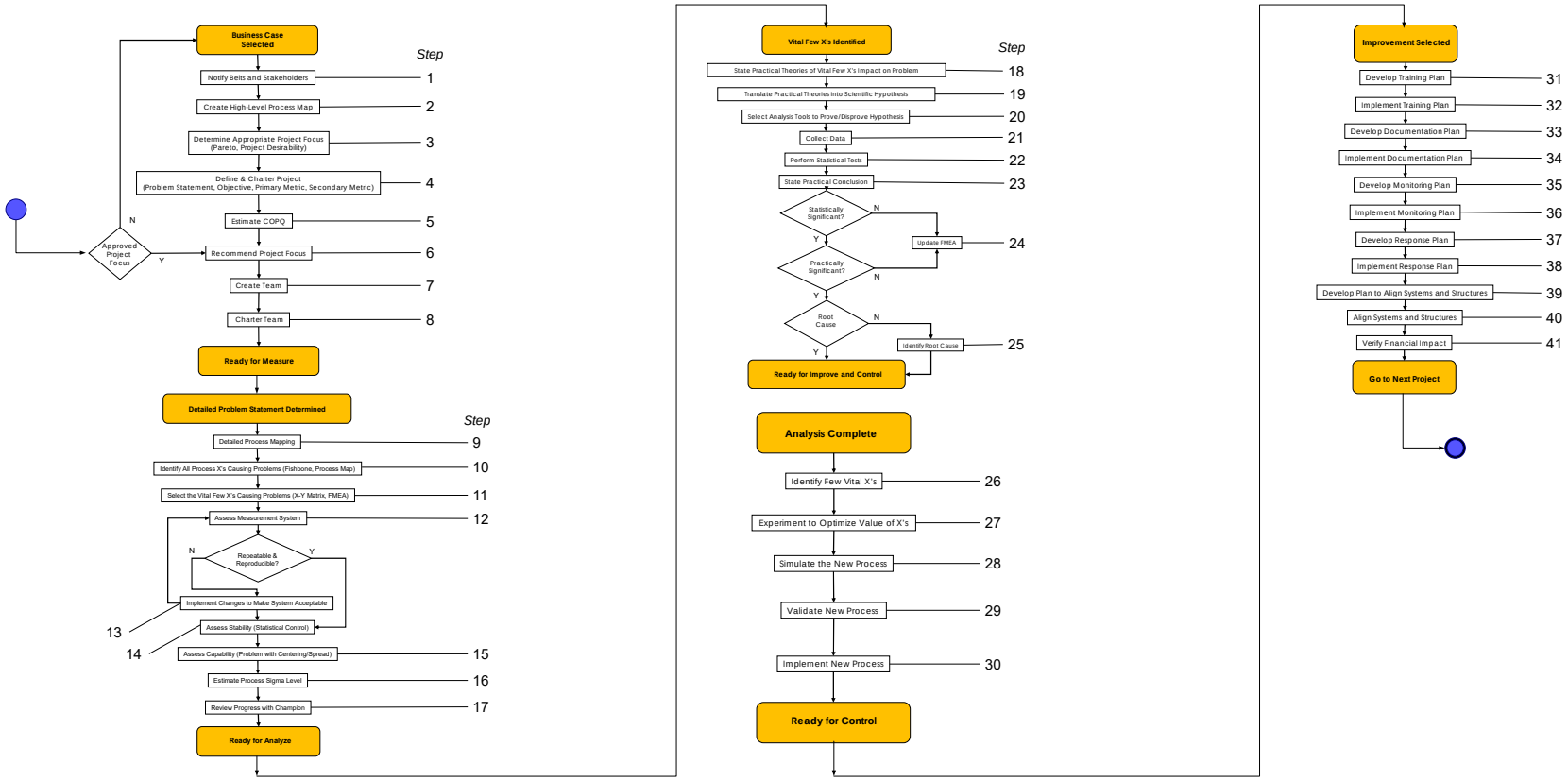
Business Case Selected
Step
Notify Belts and Stakeholders
1
Create High-Level Process Map
2
Determine Appropriate Project Focus (Pareto, Project Desirability)
3
Define & Charter Project (Problem Statement, Objective, Primary Metric, Secondary Metric)
4
Estimate COPQ
5
Approved Project Focus
N
Y
Recommend Project Focus
6
Create Team
7
Charter Team
8
Ready for Measure
Detailed Problem Statement Determined
Step
Detailed Process Mapping
9
Identify All Process X's Causing Problems (Fishbone, Process Map)
10
Select the Vital Few X's Causing Problems (X-Y Matrix, FMEA)
11
Assess Measurement System
12
Repeatable & Reproducible?
N
Y
Implement Changes to Make System Acceptable
13
Assess Stability (Statistical Control)
14
Assess Capability (Problem with Centering/Spread)
15
Estimate Process Sigma Level
16
Review Progress with Champion
17
Ready for Analyze
Vital Few X's Identified
Step
State Practical Theories of Vital Few X's Impact on Problem
18
Translate Practical Theories into Scientific Hypothesis
19
Select Analysis Tools to Prove/Disprove Hypothesis
20
Collect Data
21
Perform Statistical Tests
22
State Practical Conclusion
23
Statistically Significant?
N
Y
Update FMEA
24
Practically Significant?
N
Y
Root Cause
N
Y
Identify Root Cause
25
Ready for Improve and Control
Analysis Complete
Identify Few Vital X's
26
Experiment to Optimize Value of X's
27
Simulate the New Process
28
Validate New Process
29
Implement New Process
30
Ready for Control
Improvement Selected
Develop Training Plan
31
Implement Training Plan
32
Develop Documentation Plan
33
Implement Documentation Plan
34
Develop Monitoring Plan
35
Implement Monitoring Plan
36
Develop Response Plan
37
Implement Response Plan
38
Develop Plan to Align Systems and Structures
39
Align Systems and Structures
40
Verify Financial Impact
41
Go to Next Project