

TIME STUDY

How long does it really take?

LEAN DAY TOOLKIT



Not what the system says. Not what anyone remembers. Stand at the job, time real cycles, and compare the honest average against takt — the pace the customer actually needs.



PICK ONE JOB

One task, one place, real work



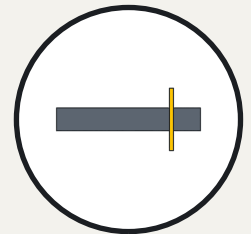
TIME THE CYCLES

Ten laps beat one guess



THE SPREAD

Average, best, worst - all true



AGAINST TAKT

Under it or over it, now you know

WATCH FIRST

Watch two full cycles before timing. Know where the job starts and ends.

LAP EVERY CYCLE

One big button. Miss one? Undo exists. Keep the numbers honest.

READ THE SPREAD

A wide spread IS the finding - the job is not stable yet.

COMPARE

Green means under takt. Red means the customer is waiting.

You cannot improve a time you have never measured.