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TPT 5s Project Example

The five stages or “pillars” of 5S

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1	**SORT**	From the Japanese phrase: “Seiri”
2	**SET IN ORDER**	From the Japanese phrase: “Seiton”
3	**SHINE**	From the Japanese phrase: “Seiso”
4	**STANDARDIZE**	From the Japanese phrase: “Seiketsu”
5	**SUSTAIN**	From the Japanese phrase: “Shitsuke”

Overall Before And Afters

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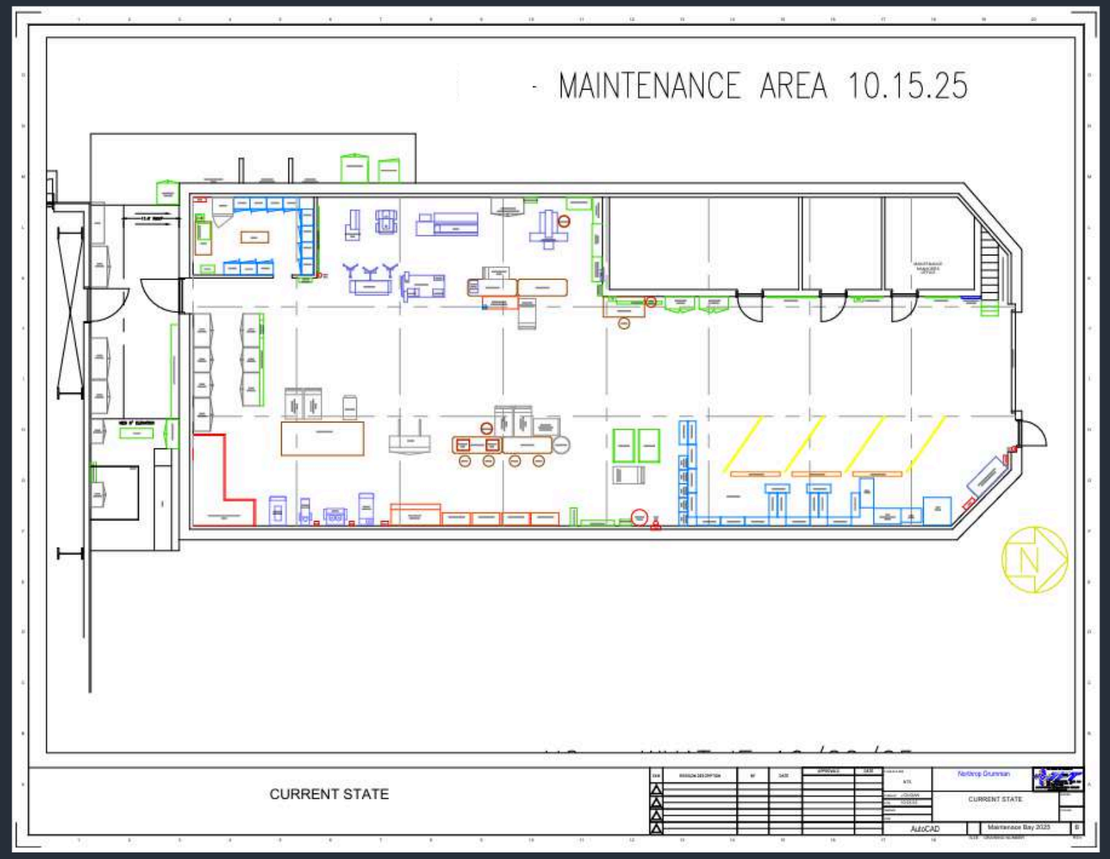

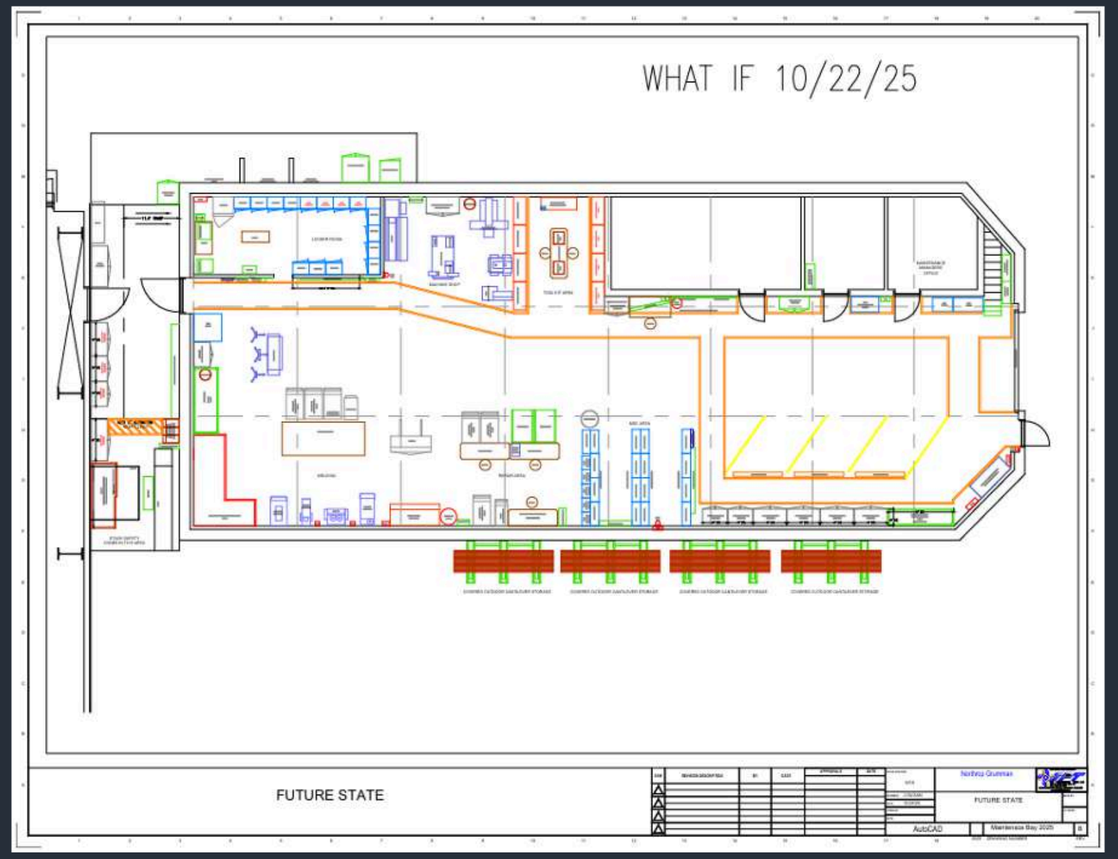

Front Of Office Area Current And Future State

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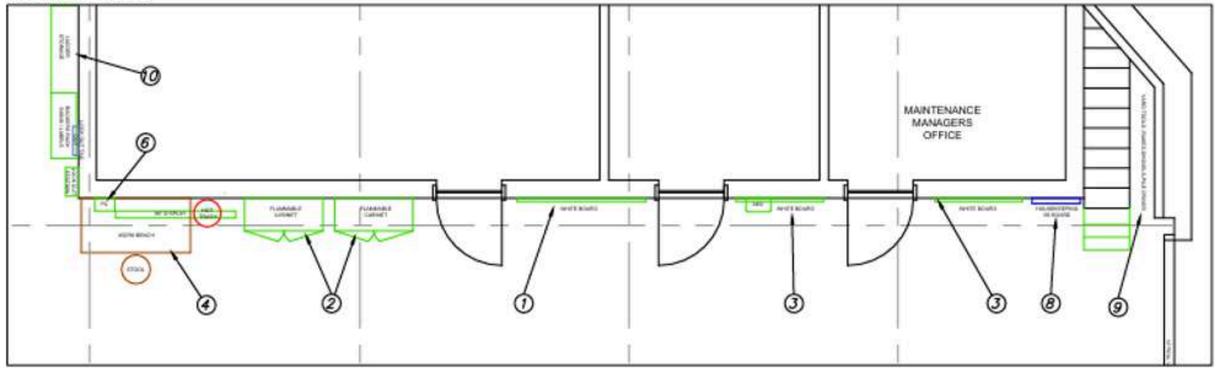
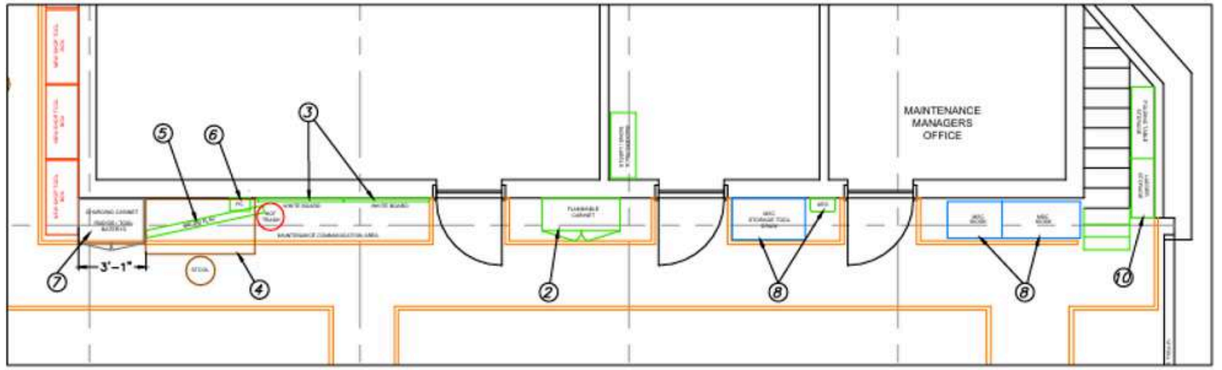
ITEM	DESCRIPTION	ITEM	DESCRIPTION
1	OMIT LARGE WHITE BOARD THAT IS NO LONGER IN USE	7	INSTALL U-LINE CHARGING CABINET (CABINET IS POWERED FOR ALL RADIOS AND HAND TOOL BATTERY'S)
2	RELOCATE ONE FLAMMABLE CABINET TO BUILDING 1051 / RELOCATE ONE BETWEEN OFFICE DOORS	8	THESE ITEMS ARE COVERED ON THE "MSC AREA DRAWING"
3	RELOCATE 2 WHITE BOARDS NEXT TO DISPLAY MONITOR	9	MOVE ALL YARD TOOL ITEMS IN THIS CORNER TO NEW CAGE IN VESTIBULE
4	RELOCATE DESK AS SHOWN	10	RELOCATE FOLDING TABLE STORAGE AND LADDER STORAGE TO THIS CORNER
5	PIVOT DISPLAY MONITOR TO CREATE 3' CLEAR FROM END OF WALL	11	X
6	REMOVE PC MOUNT – RELOCATE PC TO TOP DESK (REMOUNT IT TO THE WALL IF YOU NEED TO)	12	X

CURRENT SATE



FUTURE STATE



Front of Office Area

AutoCAD

Maintenance Bay 2025

MSC Area Current And Future State

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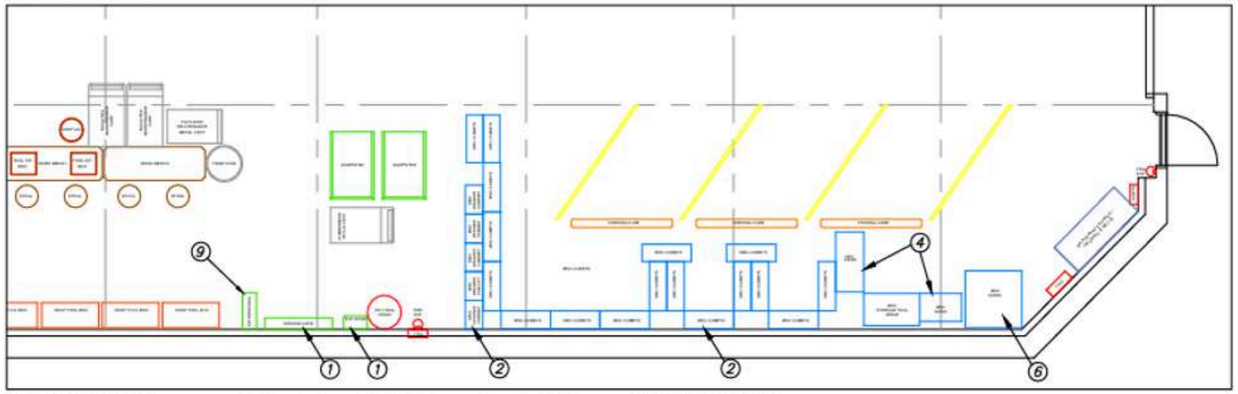
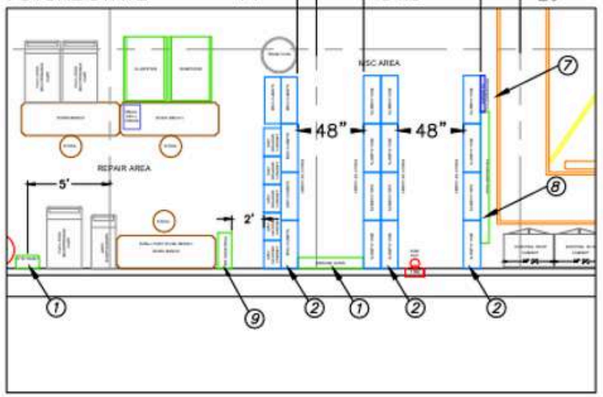
ITEM	DESCRIPTION	ITEM	DESCRIPTION
1	REMOVE EYE WASH STATION AND GREASE GUNS – REINSTALL AS SHOWN AFTER MOVING MSC CABS.	7	RE-INSTALL 5S HOUSEKEEPING BAORD
2	RELOCATE ALL MSC CUBBY'S AND DRAWERS AS SHOWN	8	RELOCATE THE 4' X 8' PEG BOARD THAT HAS THE PIPE WRENCHES ON IT TO THE BACK OF THE MSC CABS
3	REMOVE THE HOUSEKEEPING 5S BOARD AND THE WHITE BOARD FROM OFFICE WALL	9	RELOCATE BOTH AIR HOSE REELS (YOU NEED 24" TO OPEN MSC CABINET DRAWERS)
4	RUN 110 POWER AND CAT 6 IF NEEDED TO RELOCATE THE 2 SMALLER MSC KIOSK AS SHOWN	10	X
5	RELOCATE EAD AS SHOWN AND REMOVE WHITE BOARD	11	X
6	LARGE MSC KIOSK IS BEING RELOCATED DOWN BY THE LOCKER ROOM	12	X

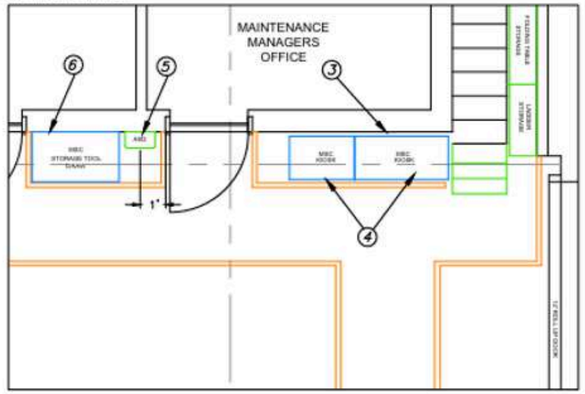
CURRENT SATE



FUTURE STATE



FUTURE STATE



MSC AREA - all dimensions are taken from the stress relief's in floor

						Northrop Grumman	
						MSC AREA MOVE REV-A	
						AutoCAD	Maintenance Bay 2025 B

Receiving Area Current And Future State

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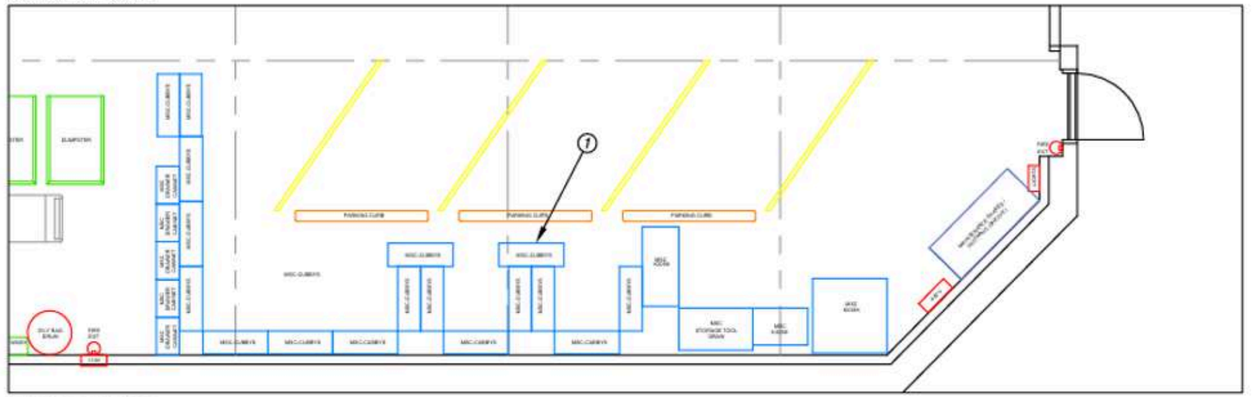
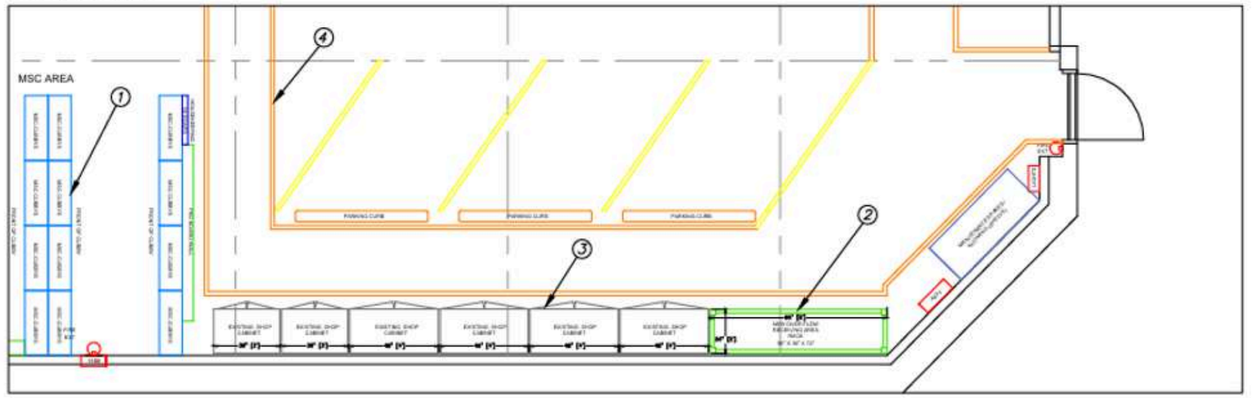
ITEM	DESCRIPTION	ITEM	DESCRIPTION
1	AFTER MOVING ALL OF THE MSC CABINETS BRING THE 6 GREY SHOP CABINETS DOWN TO THIS AREA	7	X
2	INSTALL NEW U-LINE 8' X 3' X 8" TALL SHELF	8	X
3	ARRANGE GRAY SHOP CABINETS AS SHOWN	9	X
4	TPT WILL ADD THE NEW FLOOR TAPE	10	X
5	X	11	X
6	X	12	X

CURRENT SATE



FUTURE STATE



Receiving Area- all dimensions are taken from the stress relief's in floor

Northrop Grumman

Receiving Area

AutoCAD

Maintenance Bay 2025

Repair Area Current And Future State

THE PRODUCTIVITY TEAM, LLC
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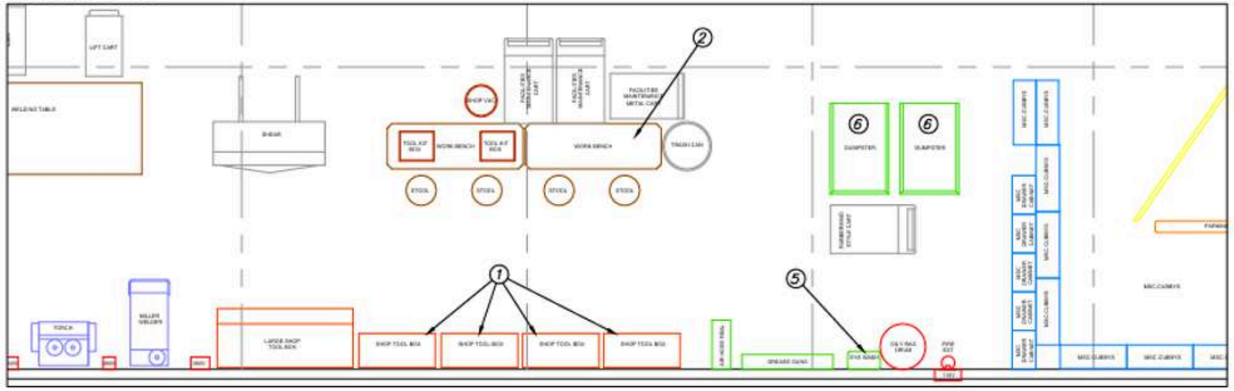
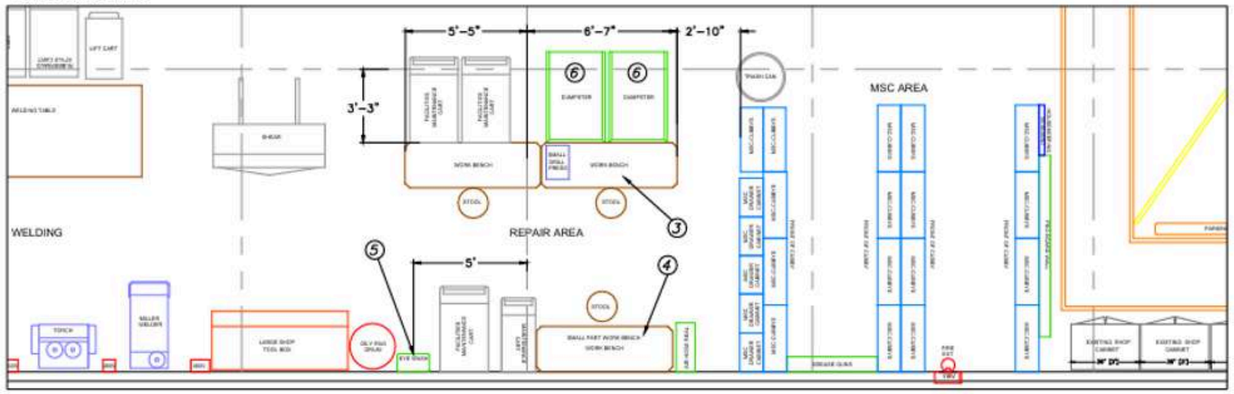
ITEM	DESCRIPTION	ITEM	DESCRIPTION
1	RELOCATE 4 TOOL BOXES TO THE TOOL KIT AREA NEXT TO MACHINE SHOP	7	X
2	RELOCATE ONE WORK BENCH TO THE TOOL KIT AREA NEXT TO MACHINE SHOP	8	X
3	RELOCATE THE WORK BENCH WITH THE SMALL DRILL PRESS FROM MACHINE SHOP TO REPAIR AREA AS SHOWN	9	X
4	RELOCATE THE SMALL PART REPAIR BENCH FROM THE MACHINE SHOP TO AGAINST THE WALL	10	X
5	RELOCATE EYE WAS STATION AS SHOWN	11	X
6	RELOCATE CARTS AND DUMPSTER'S, TRASH CAN, OILY RAG DRUM AS SHOWN	12	X

CURRENT SATE



FUTURE STATE



Repair Area- all dimensions are taken from the stress relief's in floor

Northrop Grumman

Repair Area

AutoCAD

Maintenance Bay 2025

Machine Shop Area Current And Future State

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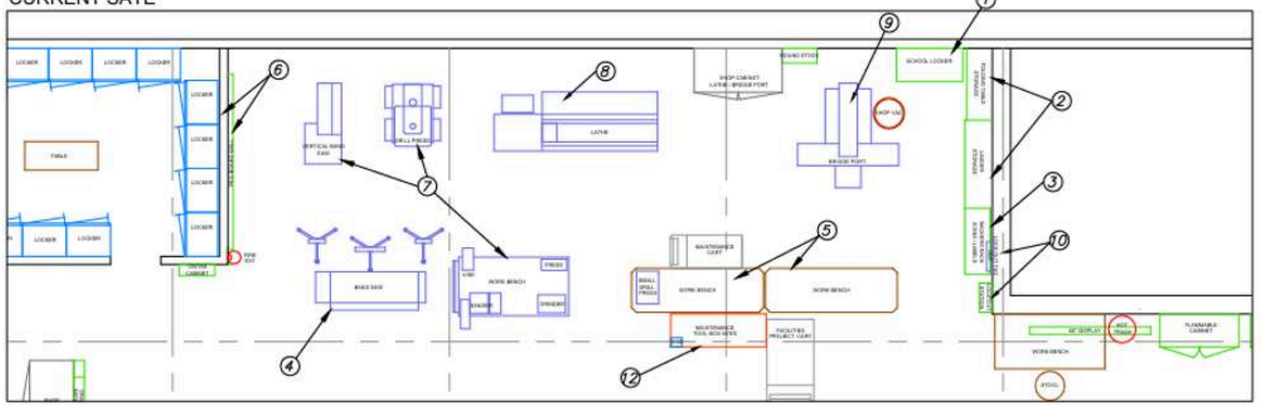
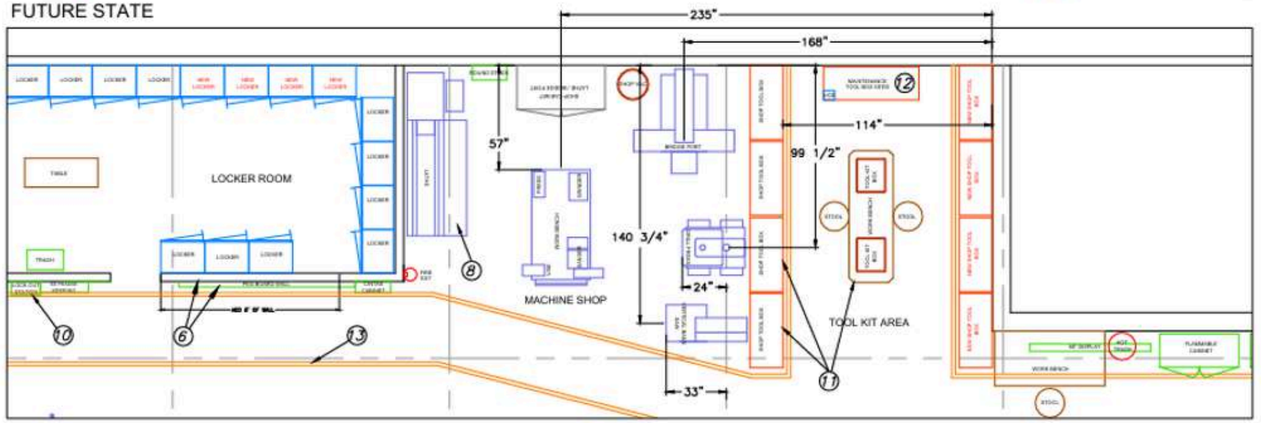
ITEM	DESCRIPTION
1	TAKE SCHOOL STYLE LOCKER TO THE WAREHOUSE
2	THE TABLE AND LADDER STORAGE WILL BE NEXT TO THE ROLL UP DOOR AFTER WE MOVE THE YARD TOOLS
3	TAKE THE BAKERS RACK INTO THE OFFICE NEXT TO THE MANAGERS OFFICE
4	RELOCATE THE BAND SAW TO WHERE THE GRAY STORAGE CABINETS WHERE
5	RELOCATE BOTH WORK BENCHES TO WHERE THE TOOL BOXES WERE ON EAST WALL
6	EXTEND THE LOCKER ROOM X 8' MOVE THE 4' X 8' PEG BOARD TO THE NEW WALL

ITEM	DESCRIPTION
7	RELOCATE THE DRILL PRESS, VERTICAL BAND SAW AND SANDING TABLE
8	RELOCATE THE LATHE AFTER EXTENDING THE WALL
9	RELOCATE THE BRIDGEPORT / CABINET AND ROUND STOCK RACK
10	RELOCATE THE LOCK OUT TAG OUTS TO THE SIDE OF THE LOCKER ROOM
11	MOVER THE 4 TOOL BOXES AND THE ONE OPEN WORK BENCH TO THIS AREA
12	MOVE THE TOOL BOX WITH THE VICE AGAINST THE WALL AS SHOWN
13	TPT WILL TAPE THE FLOOR

CURRENT SATE



FUTURE STATE



Machine Shop Area- all dimensions are taken from the stress relief's in floor

Northrop Grumman

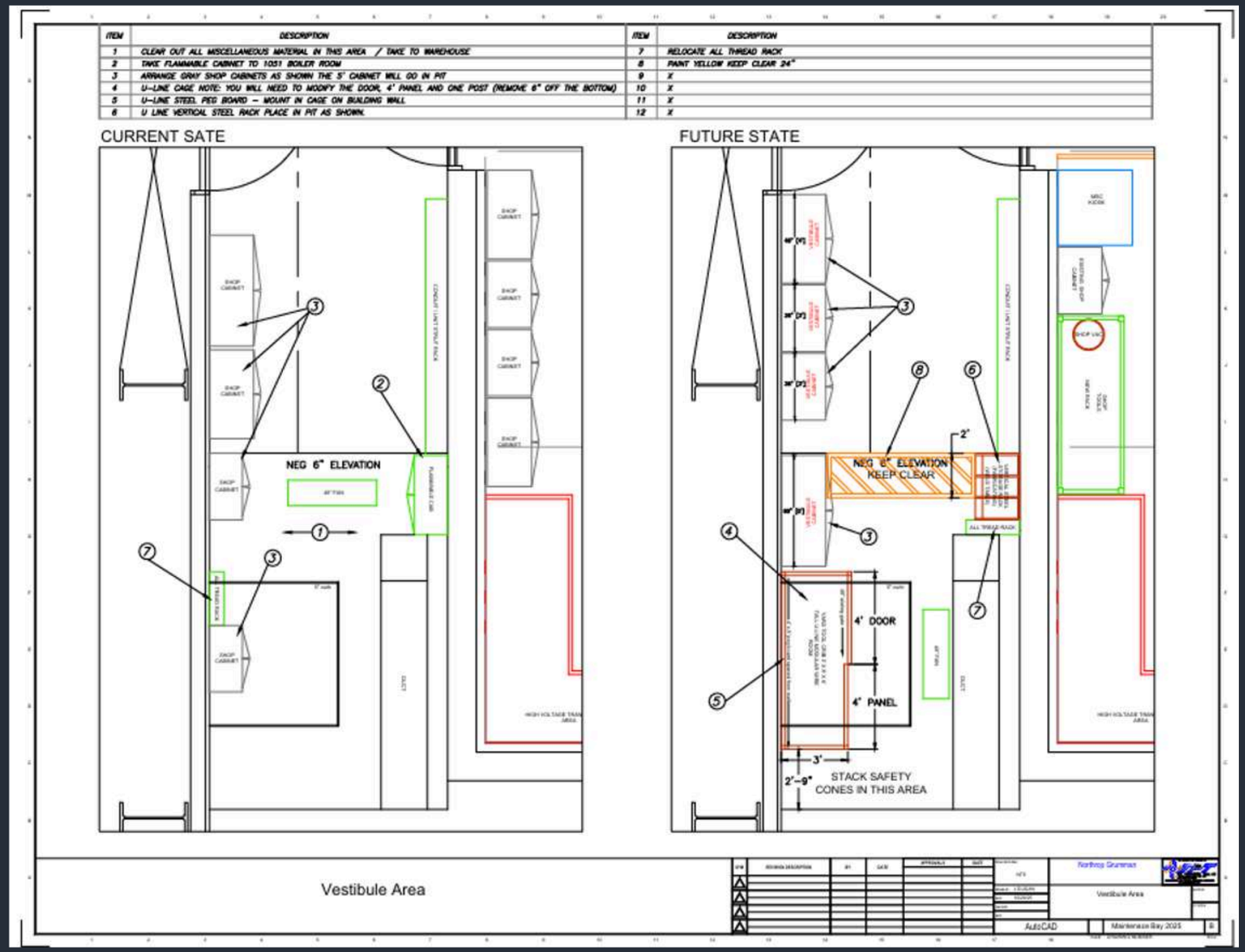
Machine Shop

AutoCAD

Maintenace Bay 2025

Vestibule Area Current And Future State

THE PRODUCTIVITY TEAM, LLC
Engineering Services

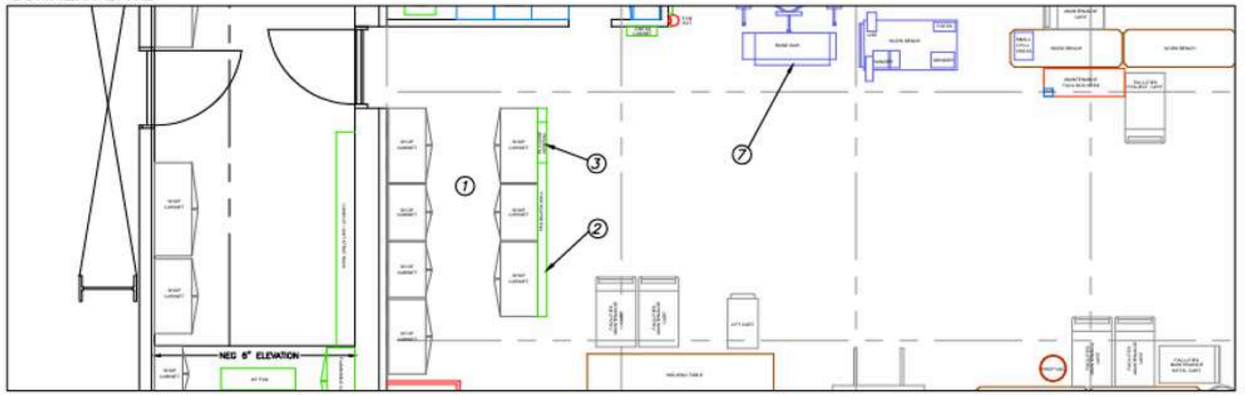


Welding Area Current And Future State

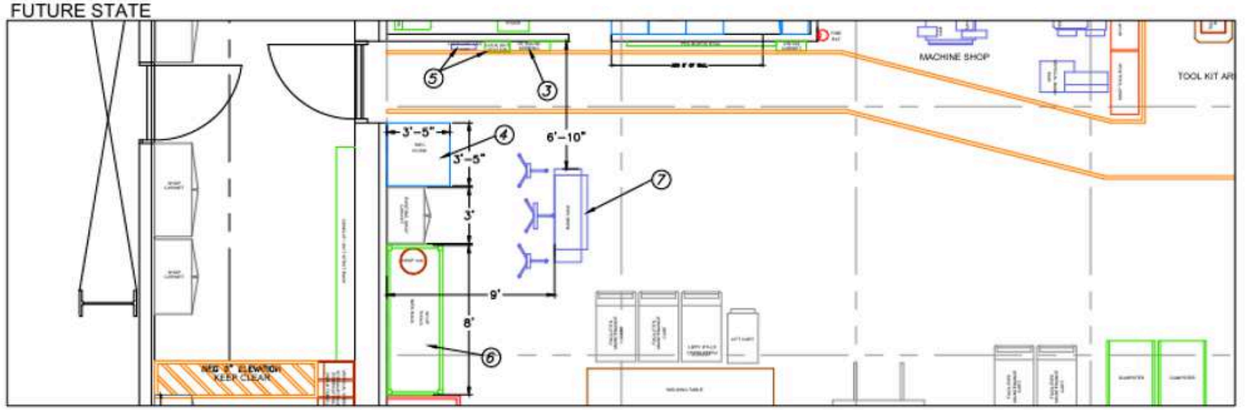
THE PRODUCTIVITY TEAM, LLC
Engineering Services

ITEM	DESCRIPTION	ITEM	DESCRIPTION
1	RELOCATE 6 OF THE 7 GRAY STORAGE CABINETS TO THE RECEIVING AREA NEAR BUGGY PARKING, HOLD A 36"CAB BACK	7	RELOCATE BAND SAW
2	RELOCATE PEG BOARD TO MSC ARE –MOUNT IT TO THE BACK OF THE MSC CABINETS	8	X
3	RELOCATE 5S HOUSE KEEPING SHADOW BOARD TO THE LOCKER ROOM WALL	9	X
4	RELOCATE LARGE MSC KIOSK FROM THE MSC AREA – AS SHOWN	10	X
5	MOUNT BOTH LOCK–OUT TAG OUT CASES FROM OFFICE WALL TO THE LOCKER ROOM WALL AS SHOWN	11	X
6	INSTALL NEW U–LINE 8' X 3' X 8' RACK (ADD A SHELF–ORDERED WITH RACK)	12	X

CURRENT SATE



FUTURE STATE



Welding Area - all dimensions are taken from the stress relief's in floor

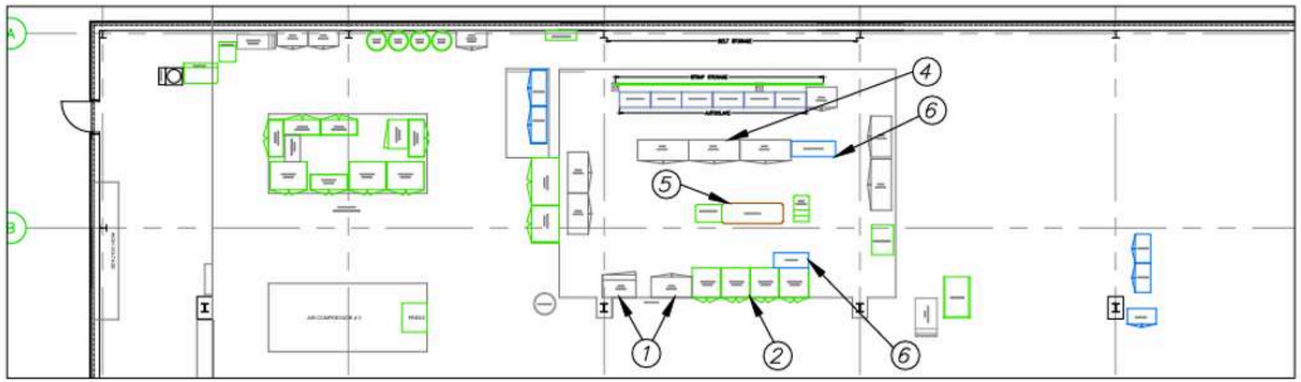
Northrop Grumman
Welding Area
AutoCAD
Maintenance Bay 2025

Building Current And Future State

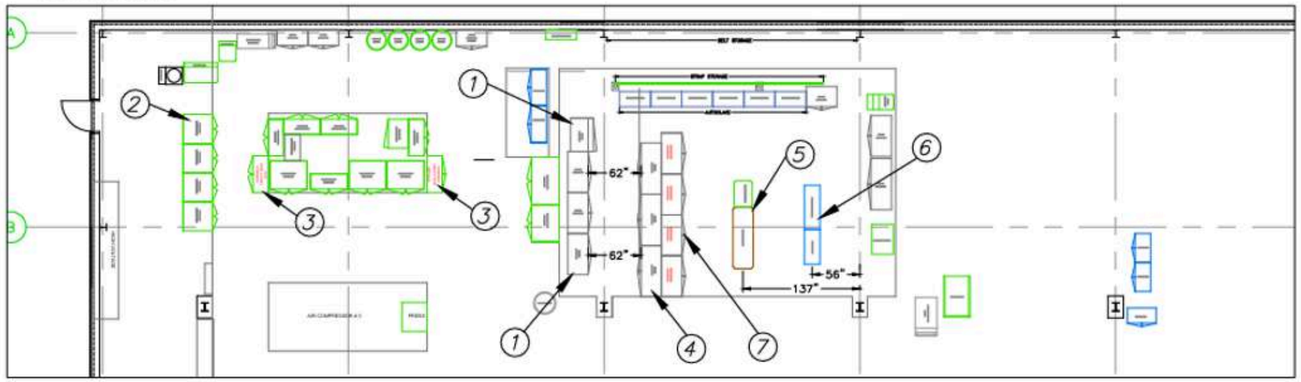
THE PRODUCTIVITY TEAM, LLC
Engineering Services

ITEM	DESCRIPTION	ITEM	DESCRIPTION
1	RELOCATE 2 SHOP CABINETS AS SHOWN	7	LOCATION OF 4 NEW SHOP CABINETS ARE BEING ORDERED TO ORGANIZE THE OVER FLOW OF SPARE PARTS
2	RELOCATE 4 FLAMMABLE CABINETS AS SHOWN	8	X
3	2 FLAMMABLE CABINETS COMING FROM THE MAINTENANCE BAY (LOCATE THEM HERE AS SHOWN)	9	X
4	RELOCATE 3 SHOP CABINETS AS SHOWN	10	X
5	RELOCATE WORK BENCH AND PART WASHER	11	X
6	RELOCATE 2 TOOL BOXES	12	X

CURRENT STATE



FUTURE STATE



Building 1051

Northrop Grumman

Building 1051 Rev-A

AutoCAD

Warehouse Current And Future State

THE PRODUCTIVITY TEAM, LLC
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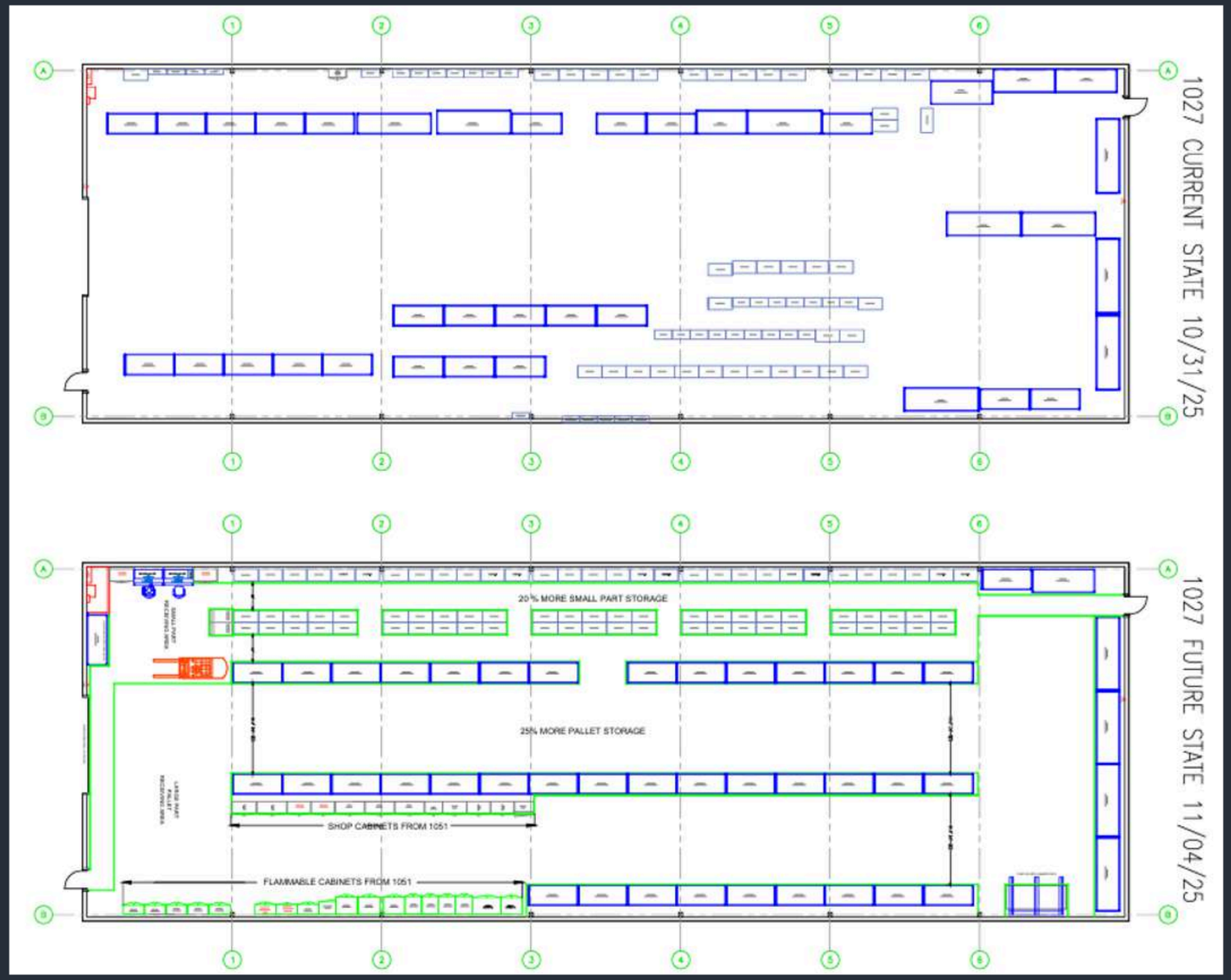

5s Pictures: Front Of Office – Yard Tools

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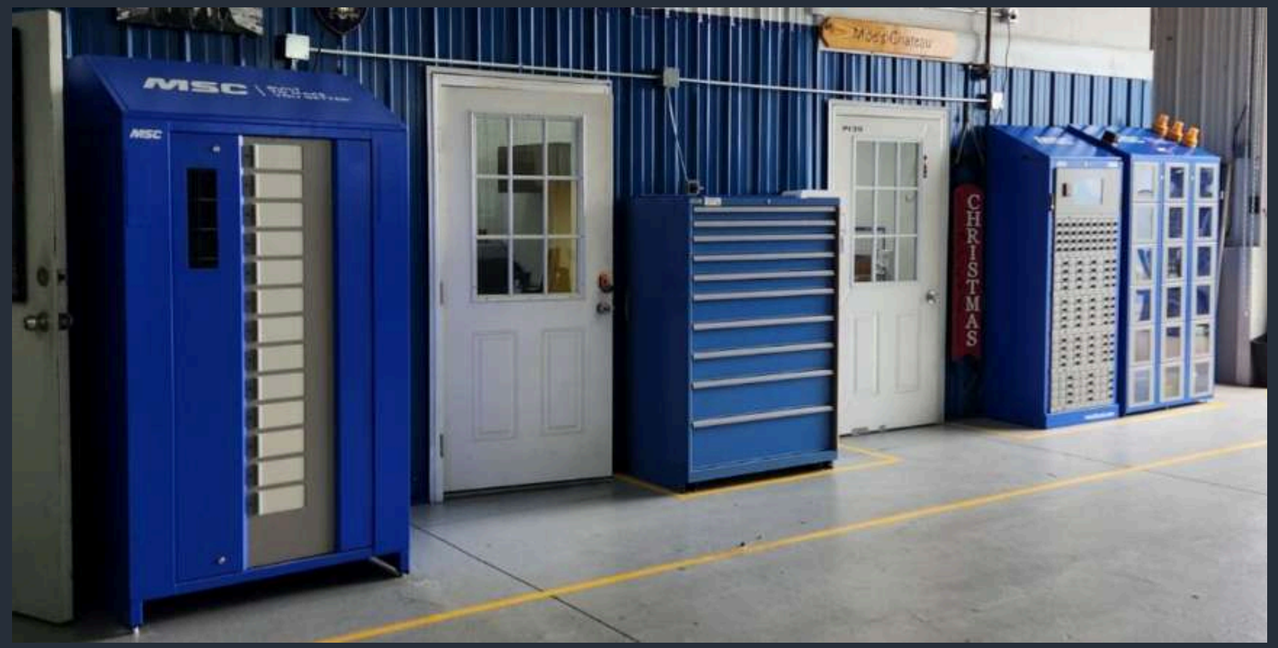
Before – No Organization, No 5S Hard to access

After - Constructed Maintenance Cage in Vestibule
Organized all Tools on Peg Board

5s Pictures: MSC Area

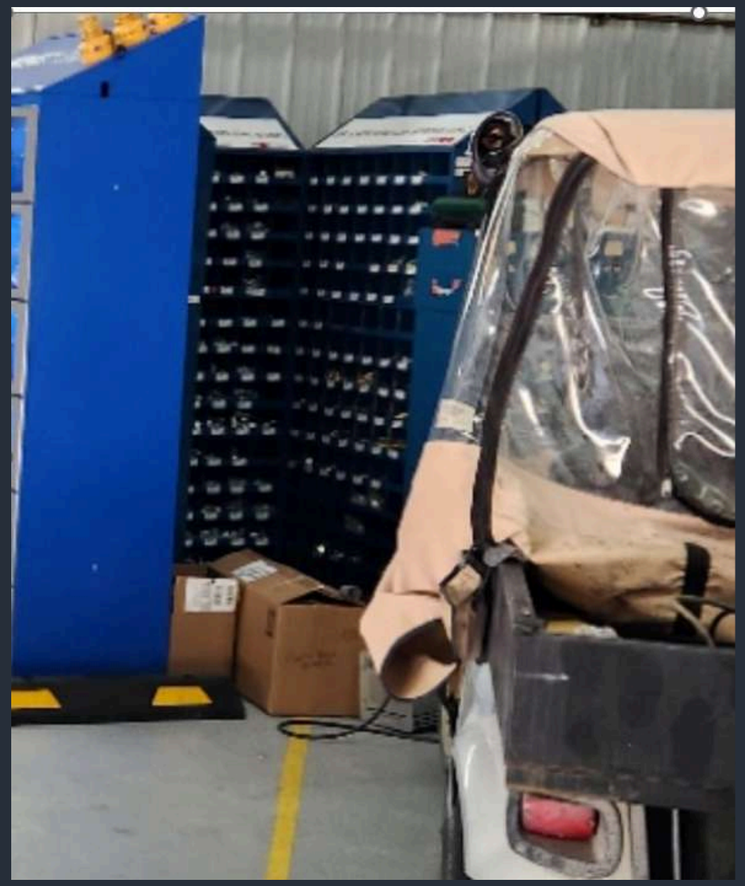
Before – Access blocked by receiving and buggy parking

After – Relocated for full accessibility
pedestaling walkway added



5s Pictures: MSC Area

Before – Access blocked by buggy parking
No pedestrian access to stock



After –Relocated away from buggy Charging
Full access to inventory. 5S Trash can placement

5s Pictures: Receiving Area

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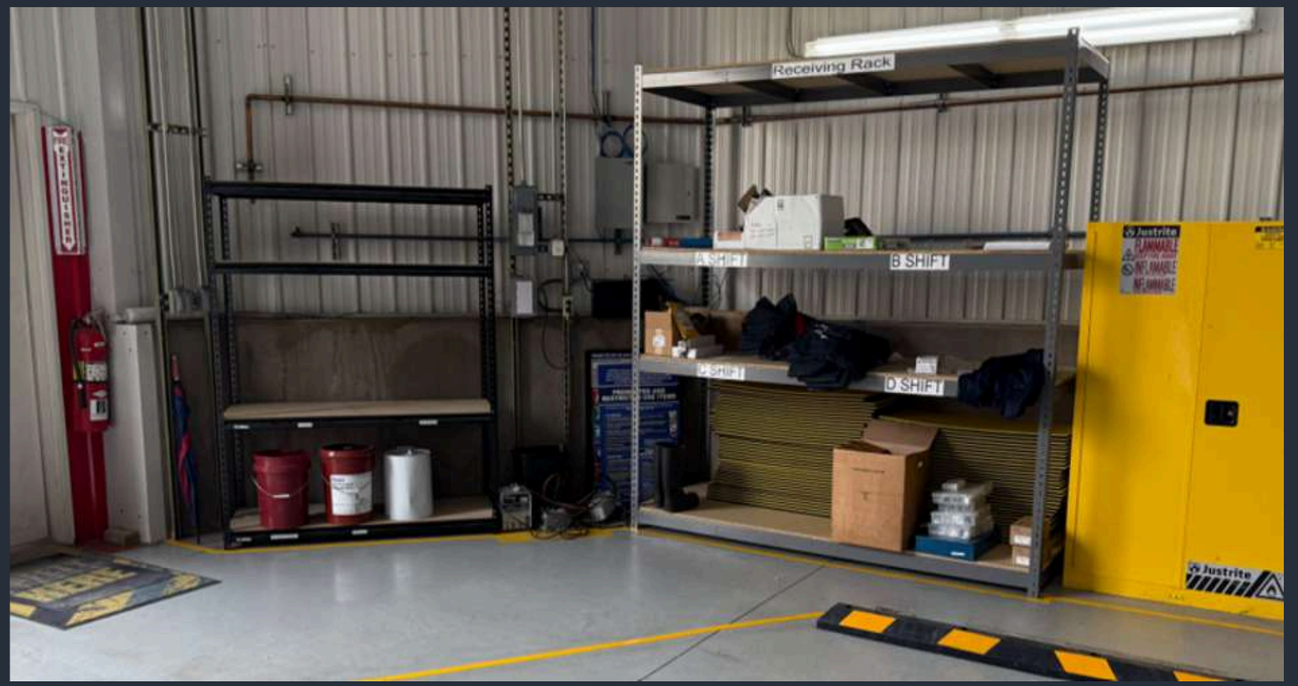
Before – Overflowing

After – Added 2nd rack for sorting
Added Pedestrian Walkway Lines



5s Pictures: Tool Kitting

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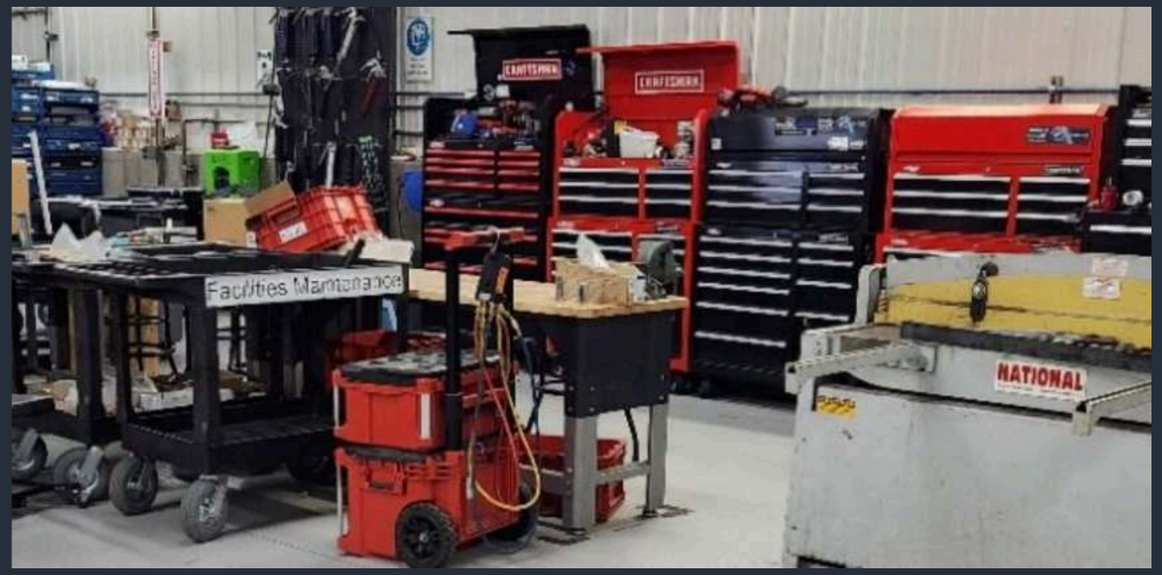
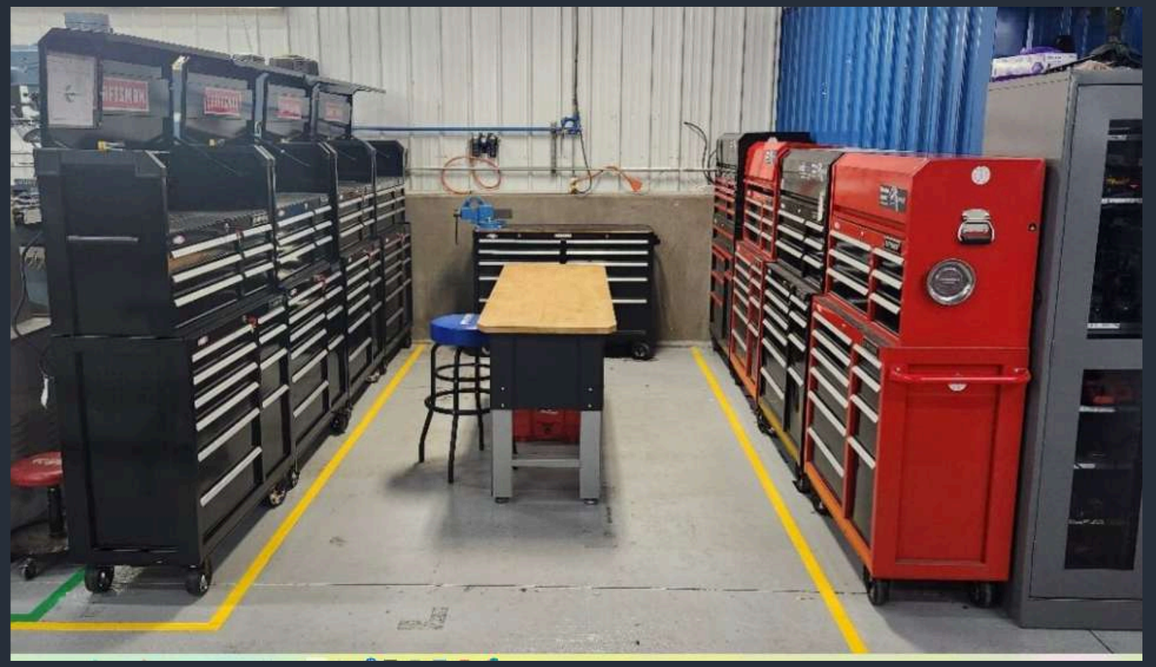
Before – Needed to add 4 more toolboxes



After – Relocated and added 4 boxes –designated area for kitting tools for plant use



5s Pictures: Machine Shop

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Before – Unorganized and cluttered

After – Relocated in a more efficient U-Shape
5S floor tape added – Green safety glasses required

5s Pictures: Tools On Floor And On Top Of Cabinets

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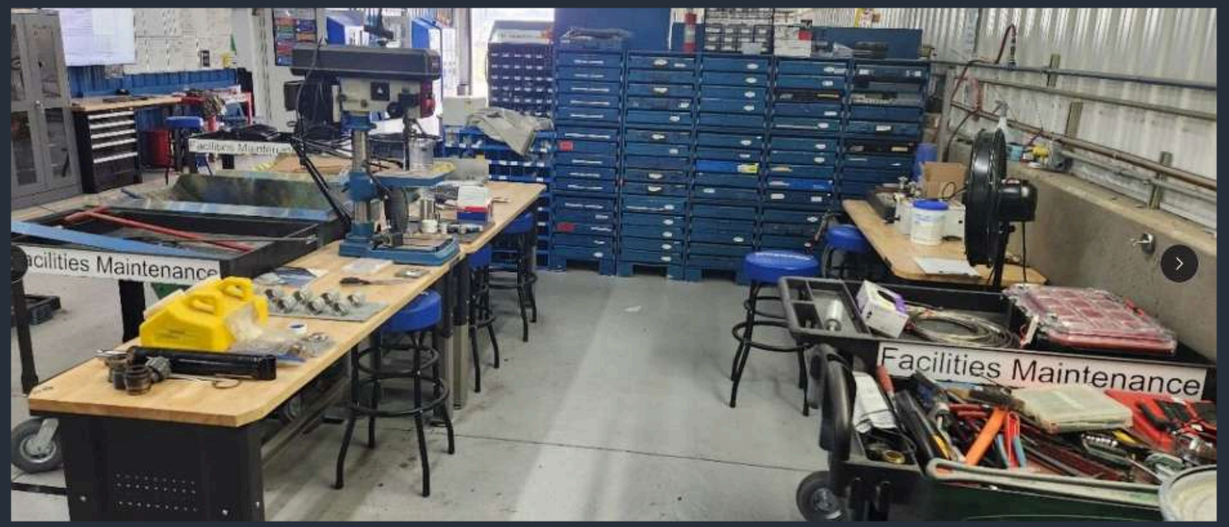
Before – Unorganized and cluttered

After – added rack for origination. Everything has a place and labeled

5s Pictures: Small Part Repair Area

Before – Small part repair area overflowing and cluttered

After – relocated and combined with repair area against wall where toolboxes used to be



5s Pictures: General Over All Improvement

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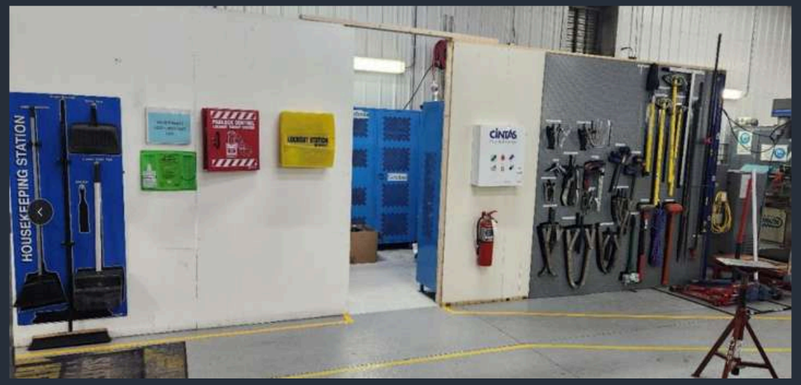
Extended looker room by 8’



5s Cost Savings

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Reduced Waste and Inventory Costs:

- "Sort" removes unnecessary items, freeing up valuable space and reducing the need to heat, light, or rent unused storage areas.
- It minimizes the risk of materials and chemicals expiring or becoming obsolete, leading to lower inventory costs and less waste disposal expense.

Lower Operating and Maintenance Costs:

- The "Shine" step involves cleaning and inspection, which helps detect equipment malfunctions (leaks, wear, etc.) early. This allows for preventive maintenance, reducing the likelihood of costly major breakdowns, repairs, and associated unplanned downtime.
- Optimized space utilization can lead to a significant reduction in required square footage for operations.

Improved Quality and Reduced Rework:

- "Standardize" establishes clear procedures, which reduces variability and errors, leading to fewer defects and less material waste from rejected products.
- A clean, organized environment minimizes the chance of using the wrong tool or material, further reducing costly mistakes and rework.

Lower Safety and Incident Costs:

- By removing clutter and clearly marking pathways, 5S activities, particularly "Sort" and "Set in Order," reduce the potential for accidents like slips, trips, and falls, thereby lowering injury-related costs, insurance claims, and lost workdays.

5s Time Savings

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Reduced Search Time:

- "Set in Order" (a place for everything, and everything in its place) ensures that tools, equipment, and information are clearly identified, labeled, and placed at the point of use. This can drastically reduce the time employees spend looking for what they need. In some documented cases, time spent searching has been reduced by 30% or more.

Increased Productivity and Efficiency:

- Minimizing wasted motion and effort through optimized workstation layouts and easy access to materials directly improves worker productivity. Some organizations report productivity increases of up to 60%.
- Standardized processes ("Standardize") eliminate confusion and guesswork, allowing work to flow more smoothly and consistently.

Less Downtime and Delays:

- Regular inspection and maintenance from the "Shine" step prevent machine breakdowns and production delays, keeping the process running efficiently.
- The elimination of clutter and clear organization (Sort and Set in Order) reduces the time lost due to congestion or waiting for misplaced items.

5s Project Summary

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Sort (Seiri):

- Areas went from shared to separate by class of work being performed

Set in Order (Seiton):

- Each new area arranged for efficiency and performance
- All ancillary items allocated to the corresponding area of use and clearly labeled

Shine (Seiso):

- Each new area cleaned and organized
- Trip hazards removed, power cables covered, clutter removed

Standardize (Seiketsu):

- Visual controls to maintain the cleanliness and organization
- Pedestrian walkways, Safety glasses required, High Voltage clearly identified.

Sustain (Shitsuke):

- Make the 5S practices a routine habit through regular communication, training, and ongoing commitment to continuous improvement.

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Thank You