

◆ FREE RESOURCE ◆

MANUFACTURING EFFICIENCY AUDIT CHECKLIST

The complete 50-point operational audit used by MaxYield analysts — adapted for self-directed assessment. Find where your facility is losing money.

50

AUDIT POINTS

5

EFFICIENCY CATEGORIES

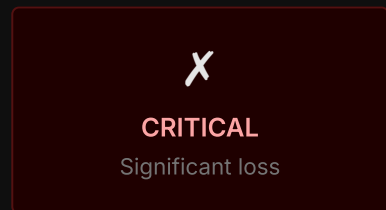
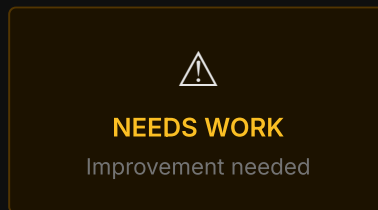
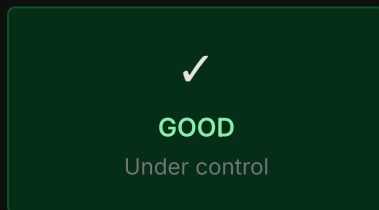
\$80K

AVG. WASTE FOUND

BEFORE YOU BEGIN

HOW TO USE THIS CHECKLIST

This checklist covers five core efficiency categories used in every MaxYield audit. Work through each section honestly. For each item, mark:



Scoring: Count your ✗ marks. 0–3: you're running lean. 4–8: significant recoverable waste. 9+: a formal audit will almost certainly find 6-figure savings. Every ✗ represents a quantifiable dollar loss — the MaxYield Full Report puts a specific number on each one.

```
{[ ["We have a documented, standardized changeover procedure for every product transition.", "Most facilities don't. Each operator improvises."], ["Changeover times are tracked and recorded for every run.", "You can't improve what you don't measure."], ["We've timed our changeovers in the last 90 days and the numbers are accurate.", "Managers usually underestimate by 20–35%."], ["All tooling and materials are staged before shutdown — not fetched during downtime.", "Tool hunts are the #1 hidden changeover cost."], ["Changeover times have improved year-over-year for the past 2 years.", "Flat or worsening changeover = systemic problem."], ["External tasks (pre-staging, paperwork) are completed before the line stops.", "SMED principle — if you're not using it, you're losing."], ["We track the delta between planned and actual changeover time.", "The gap reveals your actual loss per event."], ["Changeover data is reviewed in weekly operations meetings.", "Unreviewed data drives zero improvement."], ["Our fastest changeover operator has documented their method for others to follow.", "Best-practice capture is rare — and valuable."], ["We've run a formal SMED or changeover reduction project in the last 24 months.", "One project typically yields 30–40% time reduction."].map(([item, insight], i) => (
```

```
  □ □ □  `${item}`  
    `${insight}`
```

```
  )}]
```

```
{ [ ["We calculate OEE (Availability × Performance × Quality) for each major piece of equipment.", "60%+ of facilities don't track OEE at all."], ["Our OEE is above 75% for all critical path equipment.", "Below 75% = significant recoverable capacity."], ["We have a formal preventive maintenance (PM) schedule that is followed consistently.", "Reactive maintenance costs 3–5x more than planned PM."], ["Unplanned downtime events are logged with root cause within 24 hours.", "Without root cause data, you'll solve the same problem repeatedly."], ["Mean Time Between Failures (MTBF) is tracked for critical equipment.", "MTBF trends predict failures before they happen."], ["Operators are trained and empowered to perform basic maintenance tasks (autonomous maintenance).", "Operator-led maintenance catches 70% of issues early."], ["We have a spare parts inventory for the 20 most failure-prone components.", "Waiting for parts is the most avoidable downtime."], ["Equipment performance (speed, cycle time) is tracked vs. rated capacity.", "Most facilities run at 70–80% of rated speed without knowing it."], ["Our PM compliance rate (% of PMs completed on schedule) is above 90%.", "Below 90% PM compliance predicts rising unplanned downtime."], ["We review OEE data monthly and set improvement targets.", "What gets measured and reviewed gets improved." ] ].map(([item, insight]) => (
```

```
  □ □ □  `${item}`  
    `${insight}`
```

```
  )}
```

```
{[ ["We measure value-added time vs. total time for production workers.", "Activity ≠ productivity. Most facilities measure hours, not value."], ["We've completed a value-stream map of our primary production flow in the last 2 years.", "VSM reveals the invisible — waiting, transport, over-processing."], ["Workstation layouts are designed to minimize walking and material handling.", "The average production worker walks 5–8 miles/day — most of it wasted."], ["Shift handoffs are structured and take less than 10 minutes.", "Unstructured handoffs typically waste 20–30 min/shift."], ["Labor standards (cycle times per operation) are documented and current.", "Without standards, you can't identify and address underperformance."], ["We track labor productivity by shift and by operator.", "Shift-level variance often reveals scheduling and supervision gaps."], ["We have a formal cross-training program so operators can flex across lines.", "Single-skilled operators create bottlenecks at every absence."], ["Overtime hours are tracked against specific root causes.", "Chronic overtime is almost always a process problem, not a volume problem."], ["We've analyzed which products have the highest labor cost per unit produced.", "High-labor SKUs often have fixable process problems driving the cost."], ["Worker wait time (waiting for materials, equipment, instructions) is below 5% of shift time.", "Wait time above 5% represents direct labor dollars with zero output." ]].map(([item, insight]) => (
```

```
  □ □ □  `${item}`  
    `${insight}`
```

```
  )}
```

```
{[ ["We track first-pass yield (FPY) by product line and by shift.", "FPY is the single most telling quality metric. Most facilities don't track it."], ["Our internal defect rate is below 1% by unit.", "Above 1% typically means $50K-$200K in hidden rework cost."], ["We track the total cost of quality (scrap + rework + warranty + inspection).", "Most facilities track scrap only — the visible tip of the iceberg."], ["When a defect occurs, root cause analysis is completed within 48 hours.", "Without fast RCA, defects recur indefinitely."], ["We use statistical process control (SPC) or control charts at critical quality points.", "SPC catches drift before it becomes a defect. Most facilities react after."], ["Our warranty claim rate has declined year-over-year for the past 2 years.", "Rising warranty = systemic quality problem, not bad luck."], ["Inspection is performed at the source, not just at final QC.", "End-of-line inspection is too late and too expensive."], ["We have a customer complaint tracking system with trend analysis.", "Complaints without trends drive no improvement."], ["Rework hours are tracked separately from production hours.", "Invisible rework is one of the most common hidden cost centers."], ["We've done a formal cost-of-quality study in the last 3 years.", "Most manufacturers are shocked by what this study reveals." ]].map(([item, insight]) => (
```

```
  █ █ █  `${item}`  
    `${insight}`
```

```
  )}
```

```
{[ ["Our inventory turns at least 8× per year for finished goods.", "Below 8 turns typically means excess stock worth 3–4 months of sales."], ["We have accurate, real-time visibility into raw material, WIP, and FG inventory levels.", "Inaccurate inventory drives both stockouts and excess — simultaneously."], ["We use demand-driven replenishment rather than fixed-order-quantity purchasing.", "Fixed quantity ordering ignores seasonality and demand shifts."], ["Our raw material inventory covers no more than 30 days of production requirements.", "30+ days of raw material = significant carrying cost with no service benefit."], ["We review slow-moving and obsolete inventory monthly and have a disposal process.", "Obsolete inventory is a silent write-off waiting to happen."], ["Our WIP (work-in-process) inventory is below 3 days of throughput.", "High WIP means long lead times and hidden quality problems."], ["We've calculated our actual inventory carrying cost rate (not just assume 20%).", "Your actual rate may be 25–35% when you include all costs."], ["Safety stock levels are calculated based on demand variability and lead time, not gut feel.", "Gut-feel safety stock is almost always too high or in the wrong place."], ["We've analyzed the top 20% of SKUs that drive 80% of inventory value (Pareto).", "Most inventory optimization opportunity sits in a small number of items."], ["Our supplier lead times are documented and used in planning.", "Undocumented lead times drive over-ordering as a hedge." ]].map(([item, insight]) => (
```

```
  □ □ □  `${item}`  
    `${insight}`
```

```
  )}
```

WHAT YOUR SCORE MEANS

0-3 CRITICAL MARKS

You're running a tight operation. The remaining inefficiencies are likely in optimization territory — the Full Report may still find \$20K–\$50K in marginal improvements worth capturing.

4-8 CRITICAL MARKS

Significant recoverable waste. Based on your facility profile, we'd estimate \$50K–\$150K in annual losses tied to your X marks. A Full Report will quantify these precisely and prioritize them by impact.

9+ CRITICAL MARKS

High-priority engagement. Based on industry benchmarks, a facility with 9+ gaps in these categories typically has \$150K–\$400K in recoverable annual waste. A MaxYield audit will almost certainly return 15–30x its cost.

READY FOR REAL NUMBERS?

This checklist gives you a directional view. The MaxYield Full Report puts a specific dollar amount on each gap — and tells you which ones to fix first for maximum ROI. Starting at \$6,000, it typically identifies 13x its cost in recoverable waste.

→ Start with the free operational snapshot (20 min, no cost)

maxyield.bywillo.ai/free-audit