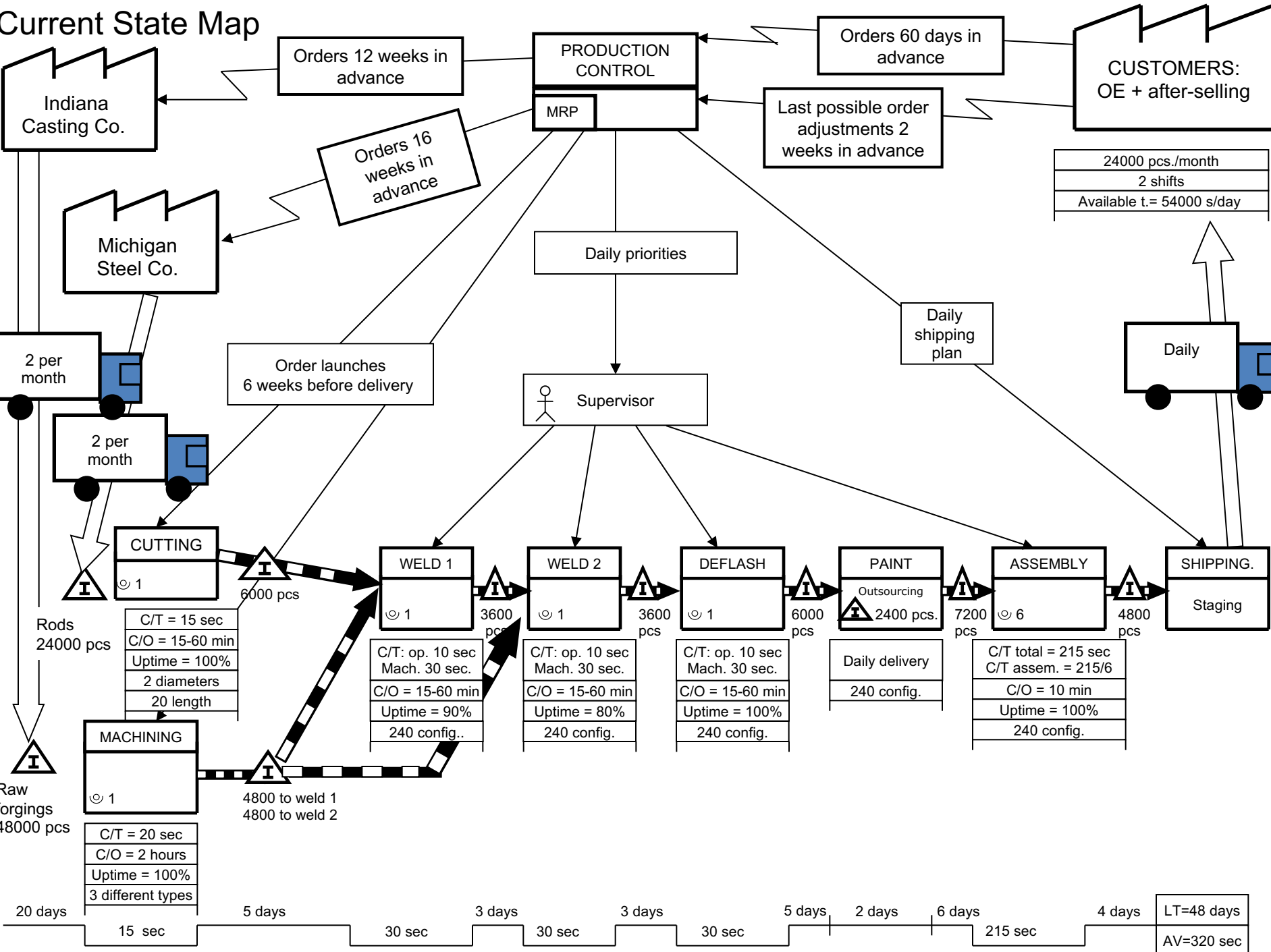


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## Starm case – Current state

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# Current State Map



# Timeline shaping

**In case of parallel processes: identify critical path and insert it in the timeline.**

In Starm S.p.A. critical path pass through rod cutting stage and cut rods buffer. Timeline has to consider 15 seconds of added value time and 5 day of not-added value time.

**When a product is composed by 2 or more identical elements the added value time is the sum of times to process all the components.**

In Starm S.p.A., machining added value time is equal to 40 seconds (2 forgings/product \*20 seconds/forging).



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