

## Case Study 3

Kan Ban, POUS, Scheduling, Quality  
& Benefits




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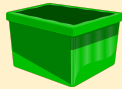
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## Kan Ban

- Kan Ban cards
  - Signal replenishment
- Cardboard boxes replaces with plastic bins



<https://pixabay.com/en/contain-er-box-green-emptily-etc-pix-304513/> CC0 Public Domain




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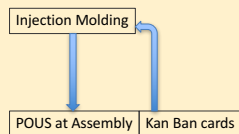
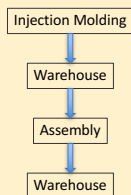
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Before Lean

POUS

After Lean




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## Lead Time and Scheduling

|             | Scheduling         | Lot size | Lead time   |
|-------------|--------------------|----------|-------------|
| Before Lean | To forecast        | Large    | 6 – 8 weeks |
| After Lean  | To customer demand | Small    | 3 days      |




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## Quality

- Before Lean
  - 2 – 3 million pieces Work in Process Inventory
    - 500,000 defective




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## Quality

- After Lean
  - 300,000 Work in Process Inventory
    - Fewer quality problems




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## Benefits

- Changeover times were reduced by 85-90%
- Lead times were reduced from 6 -12 weeks to 3 days (more than 90%)
- Work in process inventory reduced by 90%
- Cardboard costs greatly reduced
- Expedites eliminated
- Employee engagement improved



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