

Value Stream Map – Event #2

Customer LeanMan Factory
Product Zoom Zoom Cars
Demand 3/4.00mins
TAKT 1.33 mins

Improvement

- Some NVA eliminated by reducing conveyance inside the work cell. NVA of 0.7 dropped to 0.5
- VA time unchanged

Future State
2-pc MRP Push
1-pc flow Work Cell
Simulation exercise

To run the LeanSim simulation exercises in a continuous loop, the finished cars are disassembled and the raw materials returned to the 'supplier' stage. This can be performed by the 'planner' or by other participants in the exercise.

