<u>Value Stream Map – Event #2</u> Customer LeanMan Factory Zoom Zoom Cars **Product Demand** 3/4.00mins **Improvement TAKT** 1.33 mins Some NVA eliminated by reducing **Future State** conveyance inside the work cell. NVA of 0.7 dropped to 0.5 2-pc MRP Push VA time unchanged 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 **Production Planning** Customer Forecast Supplier Order supply 6 sets of each Pack & Ship Schedule 3 Cars Every item every 8 4 minutes minutes ∞ ∞ Work Cell Operators in Close Proximity Department #1 Department #4 Department #5 Department #2 Department #3 Department #6 Kit Jobs Detail - optional Inspect FG / Shiptable Subassembly Final Assembly 1.20 mins 1.00 mins 1.00 mins 0.50 mins 0.10 mins 1.00 mins MT 1.00 mins MT 1.00 mins МТ MT 0.50 mins MT 0.10 mins 1.00 mins MT 0.10 mins ΑT 0.00 hrs AT 0.00 mins AT 0.00 mins ΑT 0.00 mins ΑT 0.00 mins ΑT 0.00 mins CO 0.10 mins CO 0.10 mins CO 0.10 mins CO 0.10 mins CO 0.00 mins CO 0.00 mins YLD 100.00% YLD 100.00% YLD 67.00% YLD 67.00% YLD 66.70% YLD 100.00% Wheel 80.00=0.44d Axle 8.00=0.04d Car Body 2.00=0.04d Car Body 2.00=0.04d Plain Car 2.00=0.04d Plain Car 2.00=0.04d \$0.00 \$0.00 \$0.00 \$0.00 \$0.00 \$0.00 Axle 80.00=0.44d Brake Disk 8.00=0.04d Axle 8.00=0.04d Axle 8.00=0.04d \$0.00 \$0.00 \$0.00 \$0.00 Brake Disk 80.00=0.44d Car Body 2.00=0.04d Brake Disk 8.00=0.04d Brake Disk 8.00=0.04d \$0.00 \$0.00 \$0.00 \$0.00 Car Body 20.00=0.44d Wheel 8.00=0.04d Wheel 8.00=0.04d Wheel 8.00=0.04d \$0.00 \$0.00 \$0.00 \$0.00 Totes & Bags **Fixtures** Rework Rework Mtl 0.00 mins 0.20 mins 0.20 mins 0.00 mins 0.10 mins NVA 0.50 mins VA 3.60 mins 1.00 mins 1.00 mins 1.00 mins 0.50 mins 0.10 mins