Value Stream Map – Event #3
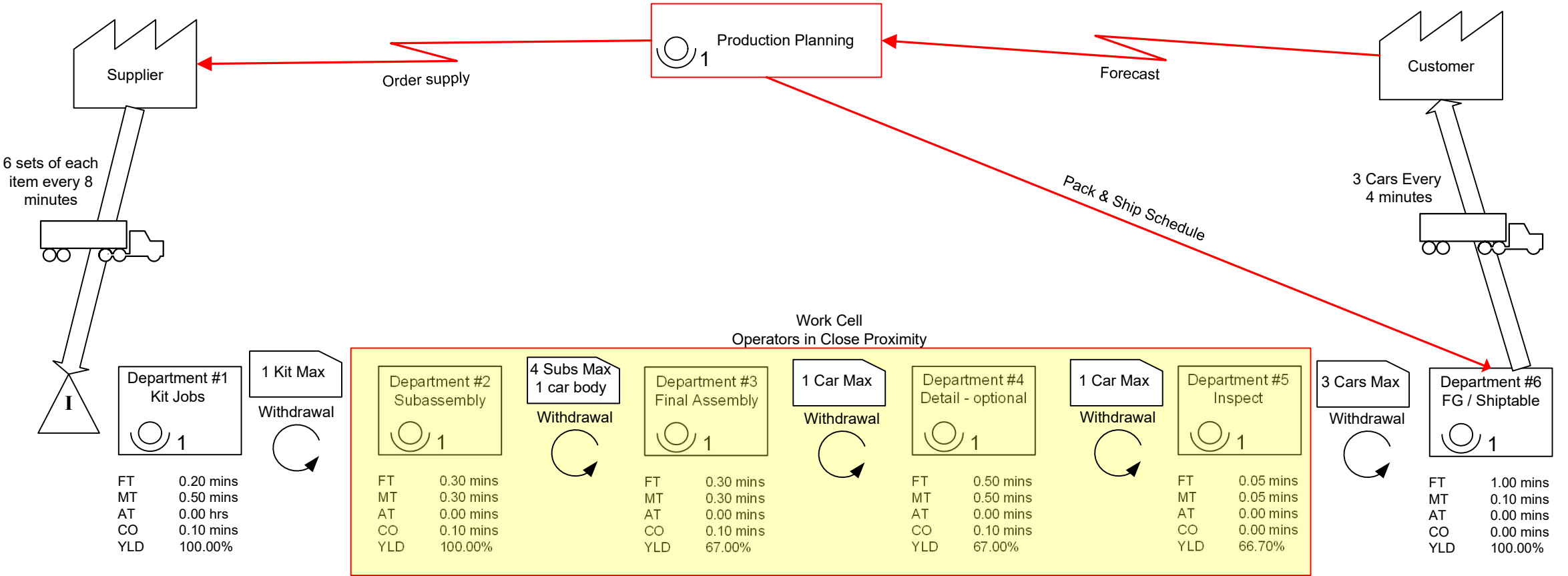
Improvement

- NVA changed because fixture handling is eliminated and inspection is moved into the cell. Drops from 0.5 to 0.2
- Quality nonconforming material still poses a threat to flow
- VA time reduced from 3.6 to 3.05

Future State
1-pc Pull w/ kanban control 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.

Supplier

Production Planning 1

Customer

Order supply

Forecast

6 sets of each item every 8 minutes

3 Cars Every 4 minutes

Pack & Ship Schedule

Work Cell
Operators in Close Proximity

	Department #1 Kit Jobs	1 Kit Max Withdrawal	Department #2 Subassembly	4 Subs Max 1 car body Withdrawal	Department #3 Final Assembly	1 Car Max Withdrawal	Department #4 Detail - optional	1 Car Max Withdrawal	Department #5 Inspect	3 Cars Max Withdrawal	Department #6 FG / Shiptable
FT	0.20 mins		0.30 mins		0.30 mins		0.50 mins		0.05 mins		1.00 mins
MT	0.50 mins		0.30 mins		0.30 mins		0.50 mins		0.05 mins		0.10 mins
AT	0.00 hrs		0.00 mins		0.00 mins		0.00 mins		0.00 mins		0.00 mins
CO	0.10 mins		0.10 mins		0.10 mins		0.10 mins		0.00 mins		0.00 mins
YLD	100.00%		100.00%		67.00%		67.00%		66.70%		100.00%

Wheel 80.00=0.44d
$0.00
Axle 80.00=0.44d
$0.00
Brake Disk 80.00=0.44d
$0.00
Car Body 20.00=0.44d
$0.00

Totes & Bags
Rework Mtl

Rework

	0.20 mins		0.00 mins		0.00 mins		0.00 mins		0.00 mins	
0.50 mins		1.00 mins		1.00 mins		0.50 mins		0.05 mins		

NVA	0.20 mins
VA	3.05 mins