

Value Stream Map – Event #4

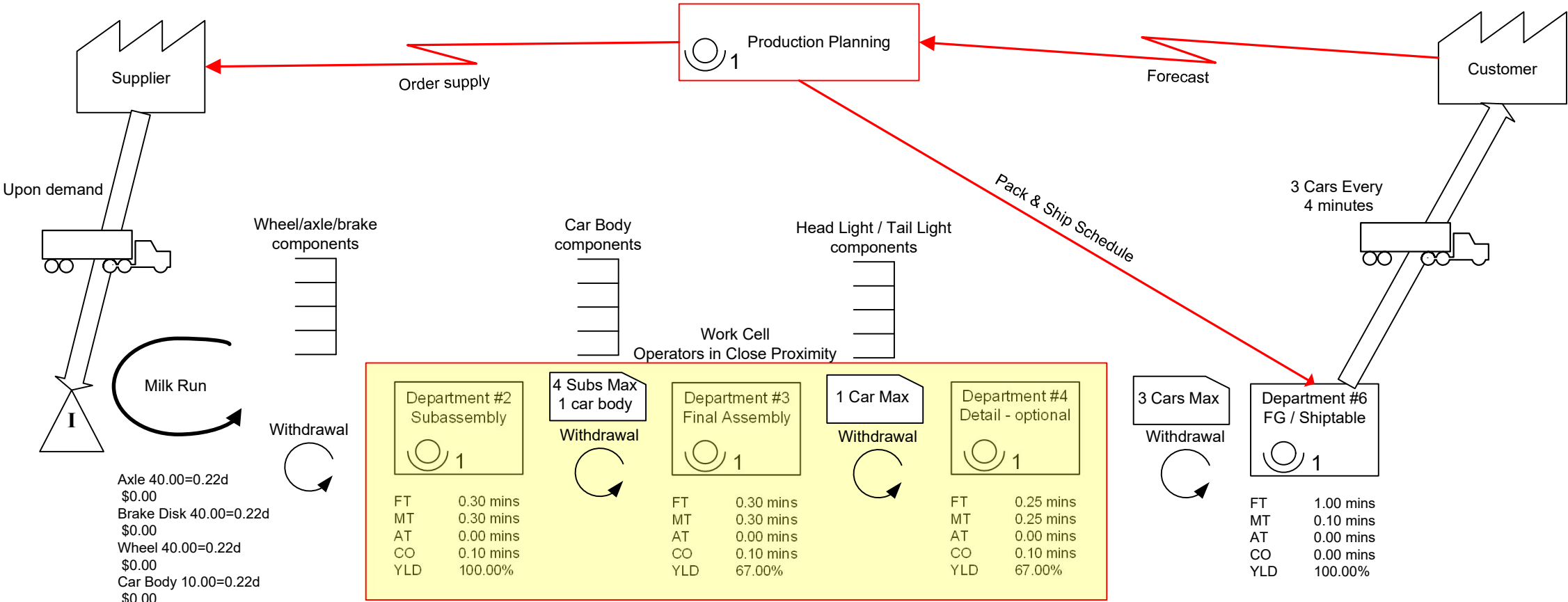
Customer LeanMan Factory
Product Zoom Zoom Cars
Demand 3/4.00mins
TAKT 1.33 mins

Improvement

- NVA changed because external stock keeper and inspection functions incorporated. Drops from 0.3 to 0
- Quality nonconforming material unlikely to be flow problem
- VA time reduced from 3.6 to 1.1

Future State
1-pc Lean Pull w/ kanban
Control, POU, CI
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.



0.30 mins	0.00 mins	0.30 mins	0.00 mins	0.50 mins	0.00 mins	NVA	0.00 mins
						VA	1.10 mins