Value Stream Map – Event #1

Business Case

0.20 mins

1.00 mins

1.00 mins

Losing Business to competitors due to long lead times and late deliveries.

Current State

2-pc batch 'n queue

Simulation exercise

Value Statement

 Improve lead time performance by synchronizing production with customer demand.

0.20 mins

1.00 mins

Key Requirements

1) Reduce flow time to meet customer demand.
2) Reduce RAW, WIP and FGI levels.

To run the LeanSim simulation exercises in a continuous

Measurements

- 1) Total flow time2) Inventory levels
- 3) ROKA and EBIT performance.

Ideal State

- On-DemandDefect Free
- 1-By-1 Lowest Cost

0.10 mins

0.50 mins

Demand 3/4.00mins

Product

0.00 mins

0.10 mins

NVA

VA

0.70 mins

3.60 mins

TAKT 1.33 mins

Customer LeanMan Factory

Zoom Zoom Cars

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 ∞ ∞ Department #1 Department #4 Department #5 Department #2 Department #3 Department #6 Kit Jobs Detail - optional Final Assembly Inspect FG / Shiptable Subassembly 1 1.20 mins FT 1.20 mins 1.20 mins 0.60 mins 0.10 mins 1.00 mins MT 1.00 mins MT 1.00 mins MT MT 0.50 mins MT 0.10 mins 1.00 mins MT 0.10 mins ΑT ΑT 0.00 mins 0.00 mins 0.00 hrs ΑT 0.00 mins ΑT 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 YLD 100.00% 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

0.20 mins