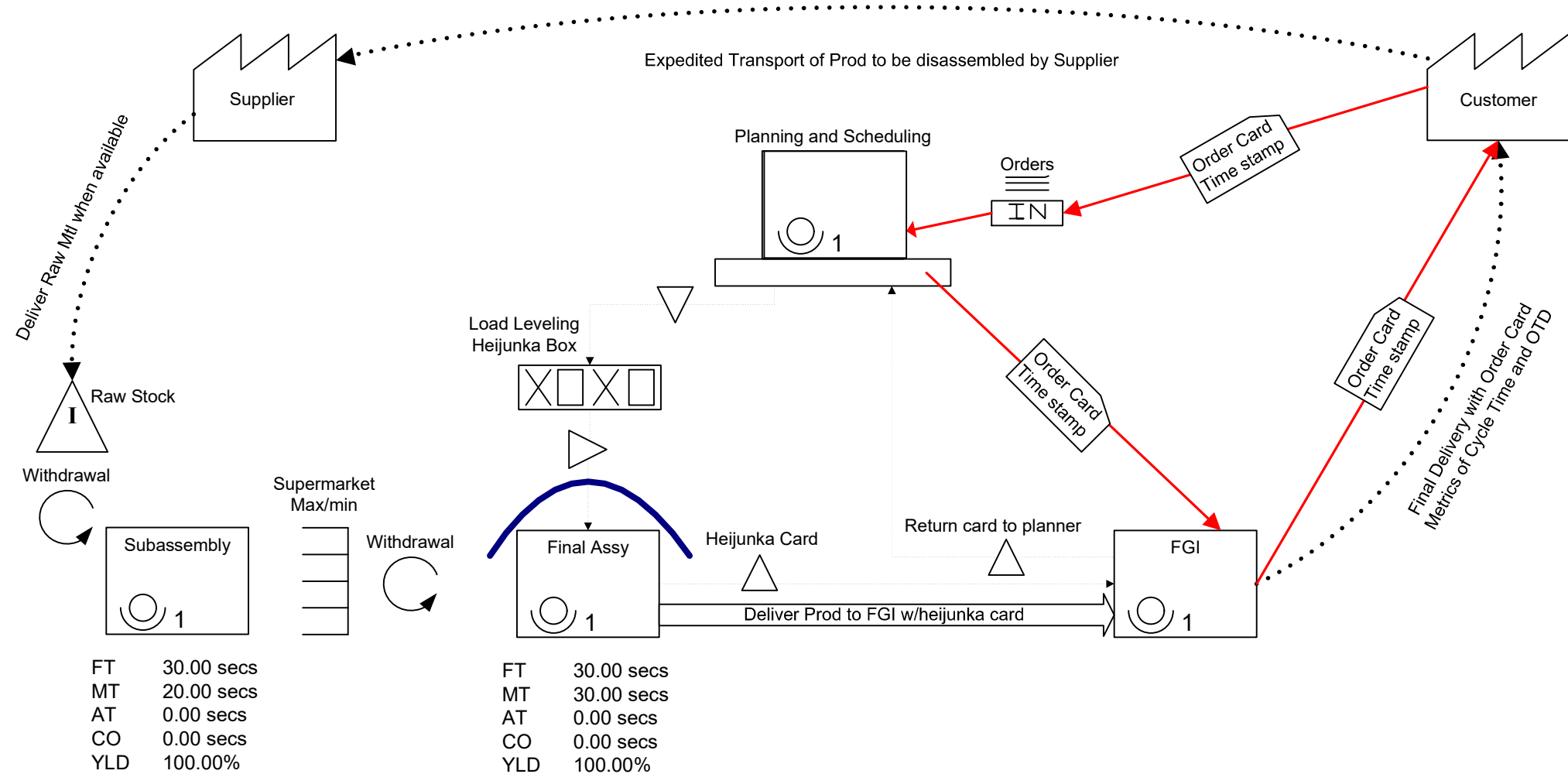


Value Stream Map

Customer Zoom Zoom Car Factory

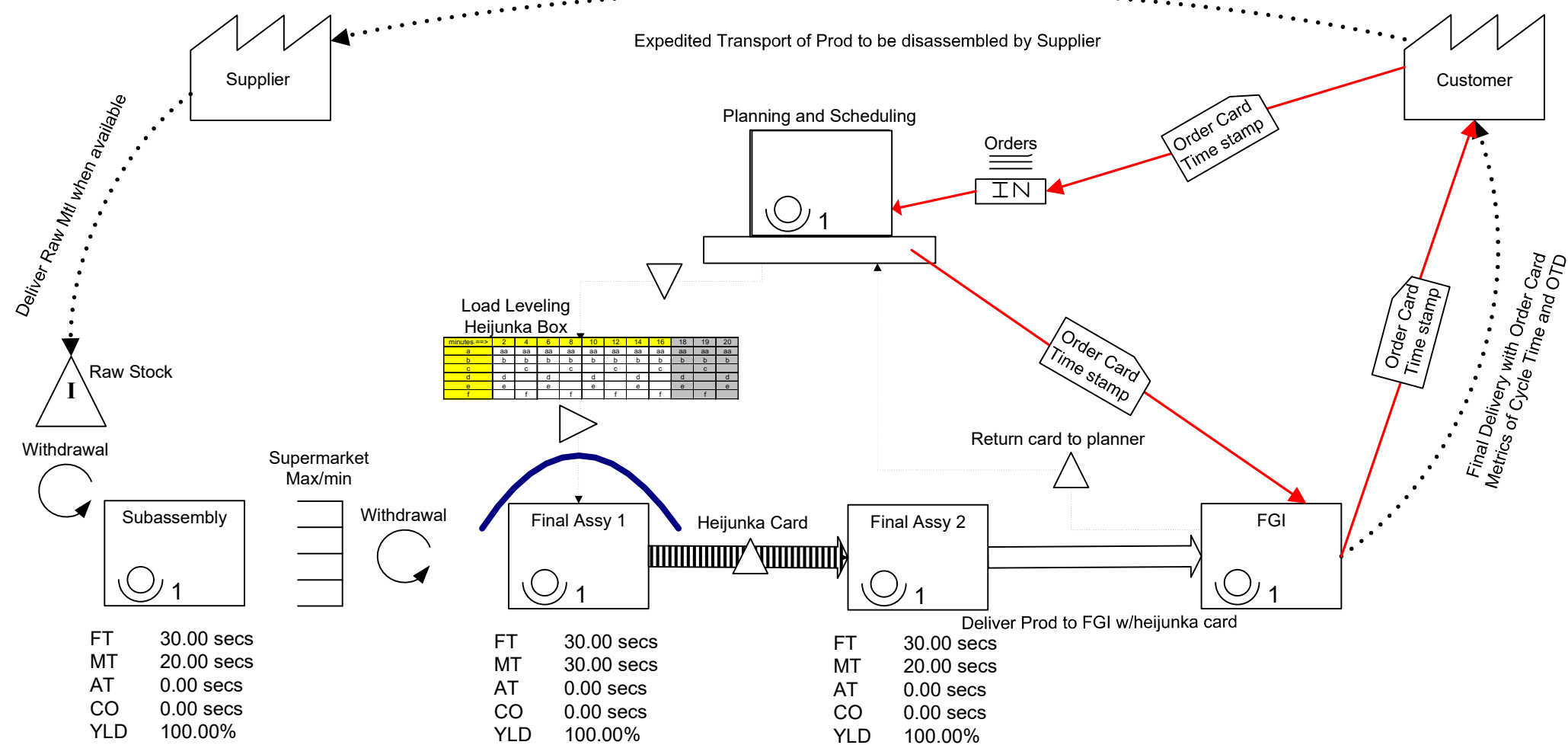
Business Case	Value Statement	Key Requirements	Measurements	Ideal State
<ul style="list-style-type: none">Mixed mode work cellHeijunka scheduleSupermarket stock	<ul style="list-style-type: none">Customer driven demand, build to order	<ul style="list-style-type: none">ProdA rate 16/11ProdB rate 16/5Prod C or E 16/3Prod D or F 16/3	<ul style="list-style-type: none">Mfg cycle timeOrder cycle timeOn time delivery	<ul style="list-style-type: none">On-DemandDefect Free1-By-1Lowest Cost



Pacemaker Loop

Value Stream Map – Plan #5

Customer Zoom Zoom Car Factory



Pacemaker Loop