

Value Stream Map – Event #1

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

Current State
2-pc batch 'n queue
Simulation exercise

| Business Case | Value Statement | Key Requirements | Measurements | Ideal State |
|--|---|--|--|---|
| <ul style="list-style-type: none"> Losing Business to competitors due to long lead times and late deliveries. | <ul style="list-style-type: none"> Improve lead time performance by synchronizing production with customer demand. | <ul style="list-style-type: none"> 1) Reduce flow time to meet customer demand. 2) Reduce RAW, WIP and FGI levels. | <ul style="list-style-type: none"> 1) Total flow time 2) Inventory levels 3) ROKA and EBIT performance. | <ul style="list-style-type: none"> On-Demand Defect Free 1-By-1 Lowest Cost |

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.

