LeanMan Car Factory Simulation – STD 4-Step Event 100 minutes LM Car Factory LTS Introduction **PowerPoint** Introduction to the 30 minutes Introduction to the 4-Event LeanMan Car Training four participation Factory Kit Guide events 25 slides components 15 minutes 15 minutes Events 1 & 2 30 minutes EVENT 2: 1-pc Push: Second build of Setup Table EVENT 1: 3-pc Batch n' Queue: Initial Reset Table **PowerPoint** Simulation build of product following instructions on with event 2 product following instructions on with event 1 Participation Placemat Set placemats participant placemats. Record metrics placemats participant placemats. Record metrics 5 Slides using wet erase marker and stopwatch. using wet erase marker and stopwatch. and kit of and re-kit [5 participants + observer team] [5 participants + observer team] materials materials 5 minutes * 10 minutes 5 minutes * 10 minutes EVENT 3: 1-pc Pull: Third build of EVENT 4: 1-piece Lean Flow w/Pull: Fourth Rearrange Rearrange Event 3 & 4 40 minutes tables with product following instructions on tables with build of product following instructions on Discuss Simulation participant placemats. Record metrics using event 3 flow participant placemats. Record metrics event 4 flow observations and re-kit using wet erase marker and stopwatch. and POU wet erase marker and stopwatch. and metrics materials [5 participants + observer team] materials [3 participants + observer team] 10 minutes 5 minutes * 10 minutes 5 minutes * 10 minutes

^{*} Time for exercise runs can be fixed, or variable as facilitator desires.