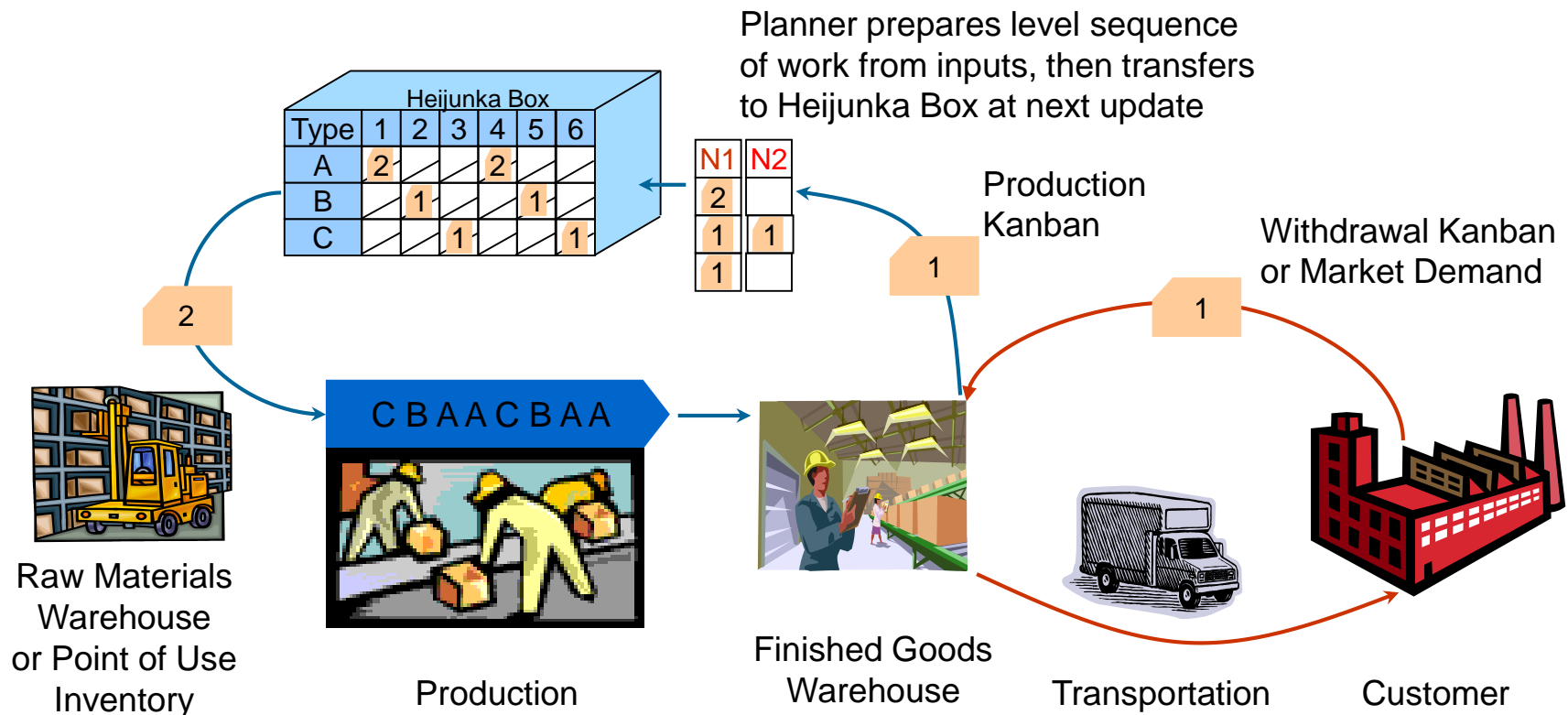


A Kanban System with Heijunka Leveling



A Kanban System with Heijunka Leveling



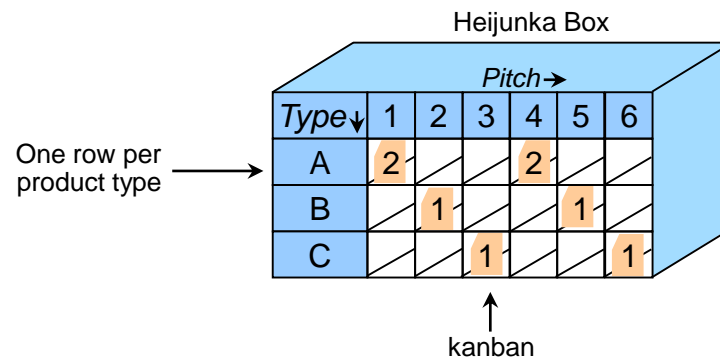
Traditional PUSH based on demand peaks and valleys

Heijunka Box						
Type	1	2	3	4	5	6
A	2			2		
B		1			1	
C			1			1



Lean PULL based on Heijunka leveling

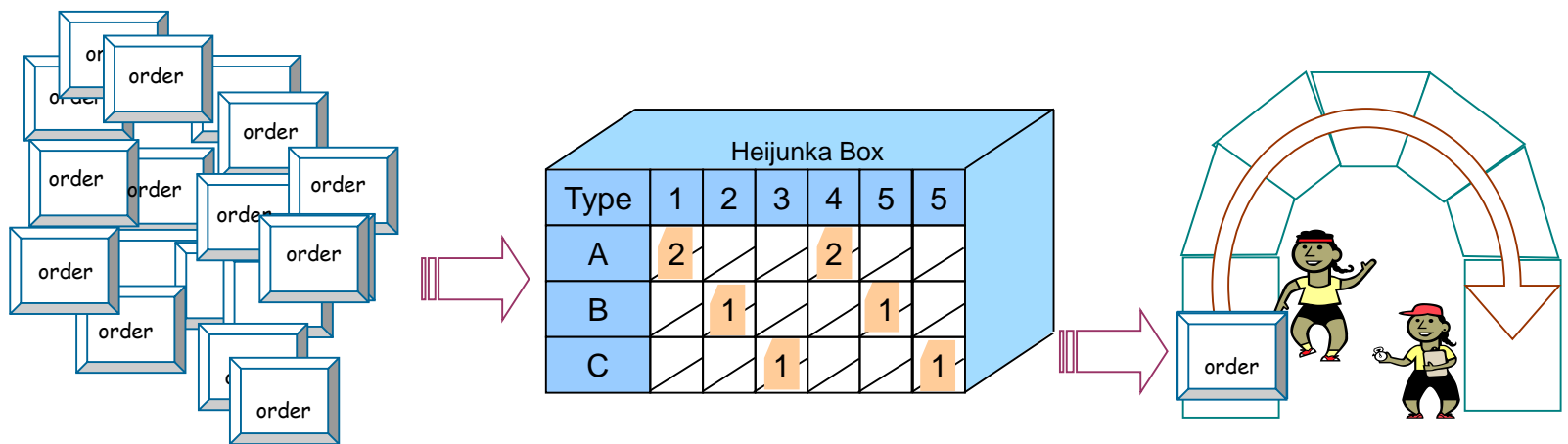
Heijunka Box



✖ Heijunka is a buffer that stages all orders.

✖ This means that when an order is made, orders sit in a queue — a virtual queue before that order is dropped or assigned to a work center. This buffer or waiting queue acts as a load leveler; otherwise orders would be coming into the work center at the rate of demand, which is characterized by peaks and valleys.

✖ The goal is to level production build since we can't entirely control customer demand. In other words, velocity is still key, but we must have balance in the system first in order to pull an order through with velocity.



EPEI – Every Part Every Interval Calculation

