Using the Value Stream Mapping Tool

Understanding how the shop floor currently operates. The foundation for the future state.

Designing a lean flow.
Current State Drawing

Understanding how the shop floor currently operates.

- Material and Information flows
- Draw using icons
- Start with the “door to door” flow
- Have to walk the flow and get actuals
  - no standard times
  - draw by hand, with pencil
- Foundation for the Future State
Individual Efficiency vs. System Efficiency

How fast should we produce?
Acme Future State Map

- Michigan Steel Co.: 500 ft coils
- Daily forecast
- Daily Order: 920 pcs/day
- 90/90/90 day forecasts
- 18,400 pcs/mo
- 12,000 "L"
- 6,400 "R"
- Tray = 20 pieces
- 2 Shifts

Takt = 460 minutes
Pitch = 60 sec x 20 pcs = 20 min.

- State Street Assembly
- Daily Ship Schedule

- STAMPING: 200 T
  - C/T = 1 second
  - C/O = 1 hour
  - Uptime = 85%
  - 1

- WELD + ASSY.
- Work Content
  - TT = 60 sec
  - C/T = 55 sec
  - 3

- SW C/O
  - SW II uptime

- SHIPING Stage
- 46 Trays
- 2 days
- 5 days
- 166 seconds
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<th>OBJECTIVE &amp; MEASURABLE GOAL</th>
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- **SUCCESS**
- **LIMITED SUCCESS**
- **UNSUCCESSFULL**

PRODUCT FAMILY: