



# TRAINING OVERVIEW

## Value Stream Map / Value Stream Design

# TRAINING



### Initial Situation & Overview

- High quantity of activities along the value stream are waste from standpoint of end customer (material stocks and movements, waiting times, long changeover times, lack of productive plant surface, etc.)
- Big percentage of throughput time is wasted time.
- High effort on Kaizen offensives or continues improvements blitzes fixing one small part of the value stream and not building a Lean Value Stream
- Managers spend the majority of their efforts on hand-offs, work-arounds, and logistical complexity.

#### Layout organization

- Step 1 •Select a Value Stream
- Step 2 •Walk the Flow
- Step 3 •Gemba walk (Data collection)
- Step 4 •Draw the Current State Map
- Step 5 •Identify opportunities / draw VSD
- Step 6 •Generate a Value Stream Plan
- Step 7 •Start making the improvements
- Step 8 •Conduct Value Stream Reviews



### Description

#### Gemba Walk and Analysis

- Process measurement (Cycle time observation)
- Draw Takt time, cycle time bar chart
- Identify potential opportunities

#### Process Combination (Just Do It & Plan)

- Layout optimization
- Execution and simulation for just do it activities
- Line balance project plan

#### Run at rate

- Validation of defined activities (2 hours run at rate)
- Documentation of new process (Standard work)



### Course plan

- Introduction to Value Stream Mapping
- VSM Symbols (General symbols, Information flow & Kanban symbols, etc.)
- Steps to create a VSM
  - Follow 8 steps
  - Takt time calculations
  - Cycle time measurement
  - Potential improvements



### Objective

- ✓ Portray the process flow from the start to end of your value stream
- ✓ Identification of sources of waste and bottle necks within the process
- ✓ Draw transition future state map and value stream implementation plan

Cycle time / Takt time bar chart

