



Manufacturing & Technology Solutions

### Kanbans & Supermarkets Agenda

#### I. Review Toyota Production System ppt presentation

- Cells
- One-Piece Flow (1→)
- Product Flow in a Cell (1→)

#### II. SF Exercise #1: Locating Cells in YOUR Value Stream (60 minutes)

#### III. Supermarkets

- Show the slide and explain how Supermarkets & Kanbans work

#### IV. SF Exercise #2: Locating Supermarkets, Kanbans, and FIFO Lanes in YOUR Value Stream (60-90 minutes)

#### V. Kanban

- definition
- types of
- production Kanban example
- withdrawal Kanban example
- supplier Kanban example
- Visual Kanban (tabletop or bench top PULL)

#### VI. How to Construct a Kanban (work through an actual example)

#### VII. SF Exercise #3: Constructing Kanbans for YOUR Value Stream (180 minutes)

- Withdrawal Kanban Cards
- Production Kanban Cards

#### VIII. How to Construct a Supplier Kanban

#### IX. SF Exercise #4: Constructing Supplier Kanbans for YOUR Value Stream (120 minutes)

#### X. The 7 Rules of Kanban

- Rule #1: Explain in Detail
- Rule #2: ditto
- Rule #3: ditto
- Rule #4: ditto
- Rule #5: ditto
- Rule #6: ditto
- Rule #7: ditto

XI. SF Exercise #5: Implementing the 7 Kanban Rules in YOUR Value Stream (60 minutes)

XII. Water Spiders & Milk Runs

- personnel
- routes
- route lengths (time)
- route frequencies

XIII. SF Exercise #6: Water Spiders & Milk Run Routes/Frequencies in YOUR Value Stream (60 minutes)

XIV. Load Leveling

- the Heijunka Box

XV. SF Exercise #7: Load Leveling (Heijunka) in YOUR Value Stream (60 minutes)

XVI. Kanbans & Supermarkets

- Conclusion
- Questions?