

CITEC

Manufacturing & Technology Solutions

Making Value Flow agenda

I. Introduction & Background Review

II. Lucy Video (show n tell)

III. Spotting Poor Flow & Shop Floor Exercise #1 (45 minutes)

IV. Smokey's BBQ Case

- Current Layout
- Current Performance
- Little's Law

V. MVF Quiz #1

VI. Work Elements

- Definition
- Work Observation Form
- Tips

VII. Smokey's Work Elements

- Stack Chart
- Paper Kaizen
- Classroom Exercise #1

VIII. Shop Floor Exercise #2 (90 minutes)

IX. Section Summary & MVF Quiz #2

X. Can Equipment Make Production?

- Machine Balance Chart
- Why Smaller, Simpler, Dedicated Equipment is Better
- If a Machine is a Bottleneck What Can You Do?

XI. Levels of Automation

XII. Designing the Physical Layout

- Guidelines for Cell Layouts
- Classroom Exercise #2: Smokey's BBQ Layout (45 minutes)
- Review Group's solutions to Smokey's Layout

XIII. Shop Floor Exercise #3 (120 minutes)

- Machine Balance Chart
- Levels of Automation
- Layout
- Material Delivery Plan

XIV. Changeover Analysis

XV. Section Summary & Quiz #3

XVI. Staffing the Cell (Operator Balance Charts)

- Planned Cycle Time (PCT)
- # of Operators Required (calculation)

XVII. Distributing the Work in a Cell

- Straightline
- U-Shaped
- Circuit
- Combination
- Reverse Flow

XVIII. Classroom Exercise #3: Smokey's BBQ (45 minutes)

XIX. Shop Floor Exercise #4: Your MVF Cell (60 minutes)

XX. Section Summary & MVF Quiz #4

XXI. Customer Pull

- Pitch
- Smokey's BBQ Pitch
- Toggling
- Labor Linearity

XXII. Shop Floor Exercise #5

XXIII. Section Summary & MVF Quiz #5

XXIV. MFV Implementation

- Stages
- Timing
- Debugging

XXV. Direct Response Activities

- Maintenance
- Materials Handler
- Helpers

XXVI. Why Standardized Work is Critical

XXVII. Section Summary & MVF Quiz #5

XXVIII. MVF Summary