



Manufacturing & Technology Solutions

Value Stream Mapping Agenda Day 1

Introduction to VSMing

- a) objectives
- b) VSMing as a tool
- c) IDing Product Families
- d) A typical VS map
- e) Waste on the Shop Floor
- f) Waste in the Office
- g) Waste Hunt

VS Mapping vs. Process Mapping

- a) Process Mapping = details, current process
- b) VS Mapping = roadmap for change
- c) VSM vs. PM chart

Quiz #1

Break

Current State VSM – Acme Stamping

- a) Objective: understand how you current work
- b) Acme Stamping Case Study
- c) Acme Stamping Data Set
- d) ID Product Family
- e) Draw in Customer & Customer data box
- f) Draw in Supplier & Supplier data box
- g) Draw in Acme Process Boxes & label
- h) Draw in Acme Process Data Boxes & fill in data as you go
- i) Draw in Acme Inventory triangles
- j) Write in Inventories from Acme Data Set
- k) Draw in Information Flow from Customer to Acme
- l) Draw in Information Flow from Acme to Supplier
- m) Draw in Information Flow from Production Control to Shop Floor
- n) Draw in Time Line (Crenellations)
- o) Write in Times for Processes
- p) Calculate Times for Inventories
- q) Summary of L/T and VAT in Summary Box @ end of timeline

Quiz #2

Lunch

Begin working on Your Current State VS Map

- a) Team Tips
- b) Identify Product Families
- c) Assign Mapping Teams
- d) Handout materials (forms, pencils)
- e) Hang large VS Mapping paper on walls
- f) Ask Mapping Teams to go out and collect their data
- g) Have Mapping Teams come back and post their data on the large wall chart for their VS Map
- h) Make sure they've collected all appropriate data necessary to complete their map
 - 1) Process Boxes
 - 2) Process Data Boxes
 - 3) C/Ts
 - 4) C/O times
 - 5) U/T's
 - 6) Yields
 - 7) Inventories (they've actually counted)
 - 8) How processes know what to make, and how much to make next (where info flow comes from)
 - 9) Information flow is connected to the material flow
 - 10) Timeline at the bottom is complete
 - 11) Summary L/T and VAT is complete

Break

List Observations by Mapping Teams

- a) Problems seen in your Value Stream
- b) Opportunities seen on your VS Maps

Questions/Concerns about Your Current State VS Maps

Adjourn for the Day

Value Stream Mapping Agenda Day 2

Lean Orientation

- a) Where we are today
- b) What is Lean?
- c) Principles of Lean
- d) Waste (Shop Floor & Office)
- e) Inventory Hides Waste

Lean Future State

- a) A Future State Roadmap
- b) Point Improvement vs. System Improvement
- c) FS Q1: What is Your TT?
- d) What happens if you cycle faster than TT?
- e) FS Q2: Build to Supermarket or Ship Direct?
- f) FS Q3: Where can you FLOW?
- g) Problem points (where you can't FLOW)?
- h) FS Q4: Where can we use Supermarket Pull Systems?
- i) FS Q5: Where do we "drop in the schedule"?
- j) FS Q6: What is the "INTERVAL"?
- k) FS Q7: What is the "TAKT IMAGE"?
- l) FS Q8: What value stream improvements will be necessary?

Develop
Acme's
FS as you
ask/answer
each
question.

Quiz #3

VS Teams begin working on their own FSs

- a) Handout FS Questions (on one sheet)
- b) Use FS VS Mapping icons
- c) Draw on your CS Map
- d) Create a new FS Map

Lunch

VS Teams continue working on their own FSs

Break

VS Teams finish their FS VS Maps

VS Teams present their FS VS Maps

- a) "show n tell"
- b) Explain VS changes required
- c) Describe new timeline and new L/T

Wrap up Value Stream Mapping

- a) Who is going to be responsible for the maps?
- b) Where will they be posted?
- c) When?

Quiz #4

Adjourn