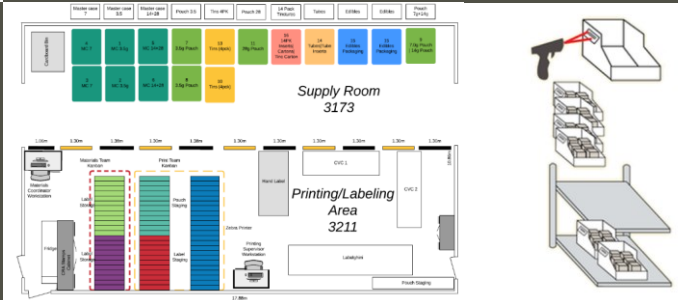


KANBAN SYSTEM FOR PRODUCTION LINES

- The Kanban systems requires minimal investment and can save thousands of dollars in warehouse space and production time.
- Start small to implement a robust Kanban System.



BACKGROUND

The Kanban Method suggests an approach of managing the flow of work without overloading the downstream team that focuses on productivity and efficiency.

THE SITUATION

FunSun Bakery Co* recognized that everything begins with an initial knowledge of how improvement and problem resolution works and to hand empowerment to the front-line employees.

Packaging materials were continually replenished on the production lines to meet the orders. It was not unusual for production lines to be inactive when the required materials did not show up on time, or the wrong materials were delivered to the staging areas.

THE SOLUTION

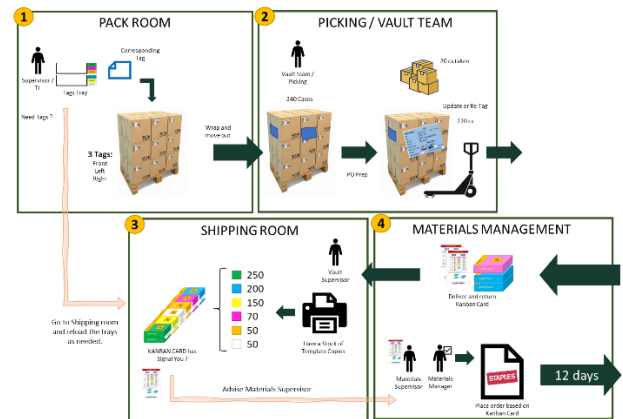
We developed a 2-session 2-hours Kanban training program for managers and supervisors. We analyzed the historical demand for the 23 packaging materials used in 7 production lines, from shrink wrap, corner posts and tape to box labels. Based on the demand, we calculated the kanban “signals” and added a safety buffer.



The Label room was improved with 5S to streamline the materials replenishment

We coordinated the material requests for the main warehouse that could deliver only 2 times a day, every 4 hours on average. We included the pallet tags, as they varied from customer to customer, using different colored paper.

The materials management team was synchronized with the production supervisors to replenish the materials as per the work instructions. Finally, the label room was changed, improved, and reorganized using the 5S approach. Finding the right materials was much easier and more efficient.



The pallet tags flow with the Kanban system to replenish the production lines.

The space at the production lines was the major constraint. We installed a rack with 6 shelves and adjusted their height to different distances to accommodate the materials. The shelves were tagged with a name and a picture of the material for quicker identification.

THE SUCCESS

- ⌚ Downtime because of materials accounted for 12% of total overall downtime for the 7 Production lines. The kanban system eliminated this downtime completely and sustained it overtime.

* The company's identity has been disguised for the sake of privacy; however, the case study is genuine.