### ? What is It

A lean pull system has the purpose of creating a workflow where work is pulled only if there is a demand for it. build products based on actual demand and not on forecasts. By doing so, a company can focus on eliminating waste activities in the production process.

## When

- Determine the right type of pull connection when designing a Future State VSM.
- Need for inventory control and reduction.
- Lean Transformation.

## **Ø** Goals

- To eliminate interruptions by limiting the Work in Process.
- Visualize the workflow and manage flow.
- Improve the value stream.

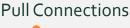




# Continuous Flow

Work cell with Continuous Flow.

One by one and with a maximum inventory of one between the workstations.





### Sequential Pull

Fixed Quantity.
Defined Sequence.
Buffer designed.

Example



#### Replenishment Pull

Supermarket.

maximum number of products is waiting to be worked on.

Kanban system.

#### When to use what type of connection.

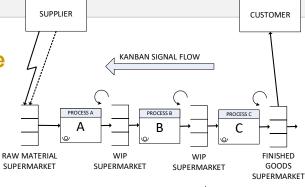
		Process Reliability (Good and on time)		Changeover times		Lead times		Demand Variation & Part usage		Part cost	
		LOW	HIGH	LOW	HIGH	LOW	HIGH	LOW	HIGH	LOW	HIGH
L	Continuous Flow		х	X		Х		х	X	Х	х
2	FIFO		х	x		х	x	X	x	X	х
3	Supermarket/ Kanban	х	х	Choose FIFO	х	х	X	Х		X	
ı	Push			х					X		X

#### Kanban Calculation





- A pull system allows workers to pull their next task if they can start working on it.
- Reducing inventory will uncover other problems. Address those problems., don't revert the pull system.



PRODUCT FLOW