

? What is It

Structured visualization map of the key steps and corresponding data needed to understand and intelligently make improvements to optimize the entire process, not just one section at the expense of another.

🗓 When

How

1.

2.

3.

5.

7.

9.

- Need to represent a **current state**, and the to develop the desired **future state**.
- To define improvement in the entire process value chain.

Current State (VSM Construction)

Understand the Value (Process Cycle Efficiency)

🎯 Goals

- To discern where the **actual value is being added** to the process.
- To show **significantly more information** than the traditional process map using a linear format.

Future State (Ideal VSM)

- 1. Define the Takt Time
- 2. Determine the way inventories are controlled. **Onepiece Flow**
- 3. Controlled inventory:
 - FIFO-Lane (First In First Out) or
 - A supermarket (Kanban System
- 4. Determination of the **Pacemaker** process.
- 5. Leveling the Production mix (Heijunka).
- 6. Amount of work quantities (Pitch or Interval).
- 7. Reducing changeover times.

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🛱 Hints

✓ Go to "where the action happens".

What is the **focus**?

Fill in Process Data

4. Work Backwards

10. Interpret the VSM

Go to Gemba (Process Walk)

Define the **basic** Value Stream

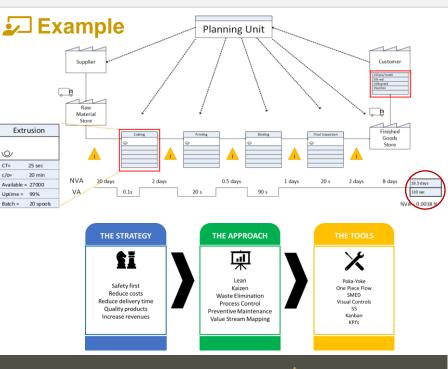
6. Fill in Queue times (Time Ladder)

8. Add Manpower (Capacity Labor)

Add the Value-Added Percentage (%VA)

- Change takes time, be patient, start small, encourage "Lean Experiments".
- This method typically looks for the "low-hanging fruit" first and prioritizes changes to the process accordingly.





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