VALUE STREAM MAP

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

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

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.

How

Current State (VSM Construction)

1. Understand the Value (**Process Cycle Efficiency**)
2. What is the **focus**?
3. Go to **Gemba** (Process Walk)
4. Work **Backwards**
5. Define the **basic** Value Stream
6. Fill in Queue times (**Time Ladder**)
7. Fill in Process **Data**
8. Add Manpower (**Capacity Labor**)
9. Add the **Value-Added** Percentage (%VA)
10. **Interpret** the VSM

Future State (Ideal VSM)

1. Define the **Takt Time**
2. Determine the way inventories are controlled. **One-piece 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.

Hints

- ✓ Go to **"where the action happens".**
- ✓ 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.

Example