

LeanMan Car Factory Simulation – Heijunka 3-Event Simulation

190 minutes

<p>LM Heijunka Introduction 60 minutes</p>	<p>PowerPoint Leveling the Waves 49 slides</p> <p>Introduction to the Heijunka terms, definitions and methods of mixed-mode flow with random customer demand. Standard Work, Visual Management, Takt Time, 1-Pc flow, kanban, EPEI and planning will be presented with interactive discussion. Slides 1 - 28</p> <p>30 minutes</p>	<p>Introduction to the LeanMan Heijunka simulation methods, tools, and organization for running the event. Event 1 is a fixed demand flow. Event 2 is a pseudo-random flow, and optional event 3 is a totally random demand based on the toss of a die. Slides 29-49</p> <p>30 minutes</p>	
<p>Simulation Events 1 & 2 60 minutes</p>	<p>PowerPoint Simulation Placemat Set 20 Slides</p> <p>Setup Table with placemats, heijunka box and kit of materials</p> <p>15 minutes</p>	<p>EVENT 1: Stable-Demand: Initial build of product following instructions on participant placemats. Record metrics using wet erase marker and stopwatch. [6 participants + observer team]</p> <p>* 20 minutes</p>	<p>Reset Table materials</p> <p>EVENT 2: Random-Demand: Second build of product following instructions on participant placemats. Record metrics using wet erase marker and stopwatch. [6 participants + observer team]</p> <p>5 minutes * 20 minutes</p>
<p>Simulation Event 3 70 minutes</p>	<p>Discuss observations and metrics considering the difference between stable and random demand, and in particular the flow between operators and the use of the box, Consider improvements the team would like to see.</p> <p>15 minutes</p>	<p>Rearrange tables with suggested changes and customer rolls the die.</p> <p>10 minutes</p>	<p>EVENT 3: Random-Demand (roll of the die) Third build of product following instructions on participant placemats. Die determines the model to build. Record metrics using wet erase marker and stopwatch. [6 participants + observer team]</p> <p>* 30 minutes</p> <p>Discuss observations and metrics difference with true random demand</p> <p>15 minutes</p>