

LeanMan Car Factory Simulation – Kanban 4-Event Value Stream Simulation

260 minutes

<p>LM Kanban Introduction 60 minutes</p>	<p>PowerPoint Kanban Simulation Facilitator guide 80 slides</p> <p>Introduction to kanban concepts begins with a discussion on the supermarket concept with two-kanban card replenishment.</p> <p>Facilitator training</p>	<p>PowerPoint Facilitator Presentation 23 slides</p> <p>Kaizen eno Yon Danki – improvement in 4 Steps. A bit of history in lean flow methods leading into a discussion on kanban. A 4-step approach to lean flow is depicted graphically for discussion. Tools for heijunka planning are reviewed.</p> <p>30 minutes</p>	<p>PowerPoint Little's Law Laundry Presentation 15 slides</p> <p>Discuss Little's Law</p> <p>30 minutes</p>		
<p>Simulation Events 1 to 4 200 minutes</p>	<p>Setup Table with placemats, heijunka box (if available) slideboard and kit of materials</p> <p>15 minutes</p>	<p>EVENT 1: Single-Kanban Card System: Initial build of product following instructions on participant placemats. Record metrics using wet erase marker and stopwatch. [8 participants + observer team]</p> <p>* 20 minutes</p>	<p>Record metrics for Financial and Inventory. Discuss pros and cons of a single card</p> <p>10 minutes</p>	<p>Refresh table arrangement and placemats for event two with Production and Move cards</p> <p>10 minutes</p>	<p>EVENT 2: Dual Card System: Second build of product following instructions on participant placemats. Record metrics using wet erase marker and stopwatch. [8 participants + observer team]</p> <p>* 20 minutes</p>
	<p>Record metrics for Financial and Inventory.</p> <p>10 minutes</p>	<p>Discuss observations and metrics considering the difference between single and dual card system, and in particular the flow between salesroom and the factory,</p> <p>15 minutes</p>	<p>Refresh table arrangement and placemats for event three</p> <p>10 minutes</p>	<p>EVENT 3: Dual Card with Heijunka: Third build of product following instructions on participant placemats. Use Heijunka box if available. [8 participants + observer team]</p> <p>* 20 minutes</p>	<p>Record metrics for Financial and Inventory.</p> <p>10 minutes</p>
	<p>Discuss observations and metrics considering the difference the Heijunka plan method made on the dual card system, and in particular the flow between salesroom and the factory,</p> <p>15 minutes</p>	<p>Refresh table arrangement and placemats for event four</p> <p>10 minutes</p>	<p>EVENT 4: Dual Card with Heijunka and Near-Zero FGI: Fourth build of product following instructions on participant placemats. [8 participants + observer team]</p> <p>* 20 minutes</p>	<p>Record metrics for Financial and Inventory.</p> <p>10 minutes</p>	<p>Discuss observations and metrics considering the difference reducing FGI made on the dual card system, and in particular the flow between salesroom and the factory,</p> <p>15 minutes</p>