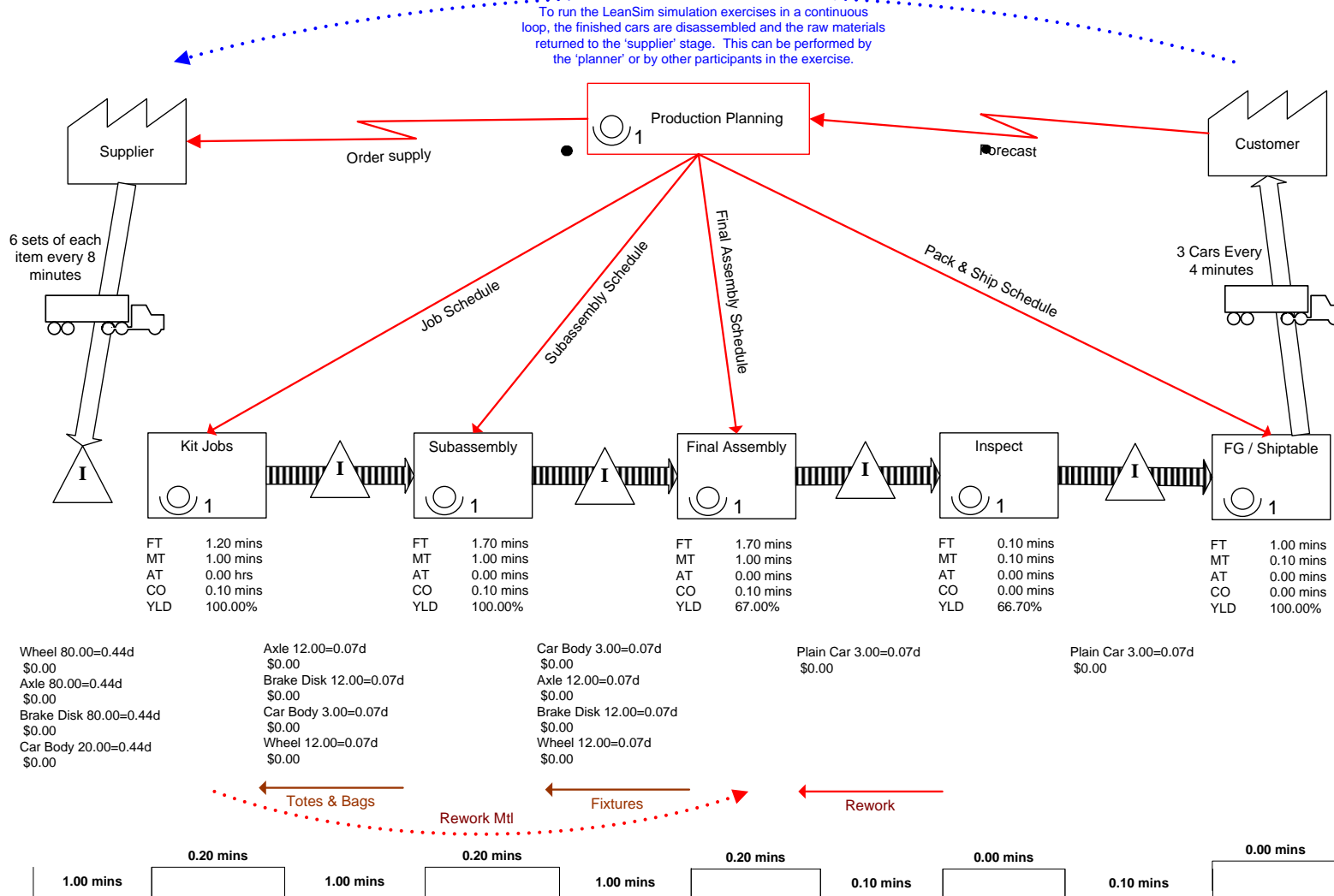


Value Stream Map

Customer LeanMan Factory
Product Zoom Zoom Cars
Demand 3/4.00mins
TAKT 1.33 mins

Current State
 3-pc batch 'n queue
 Simulation exercise

Business Case	Value Statement	Key Requirements	Measurements	Ideal State
Losing Business to competitors due to long lead times and late deliveries.	Improve lead time performance by synchronizing production with customer demand.	1) Reduce flow time to meet customer demand. 2) Reduce RAW, WIP and FGI levels.	1) Total flow time 2) Inventory levels 3) ROKA and EBIT performance.	On-Demand Defect Free 1-By-1 Lowest Cost



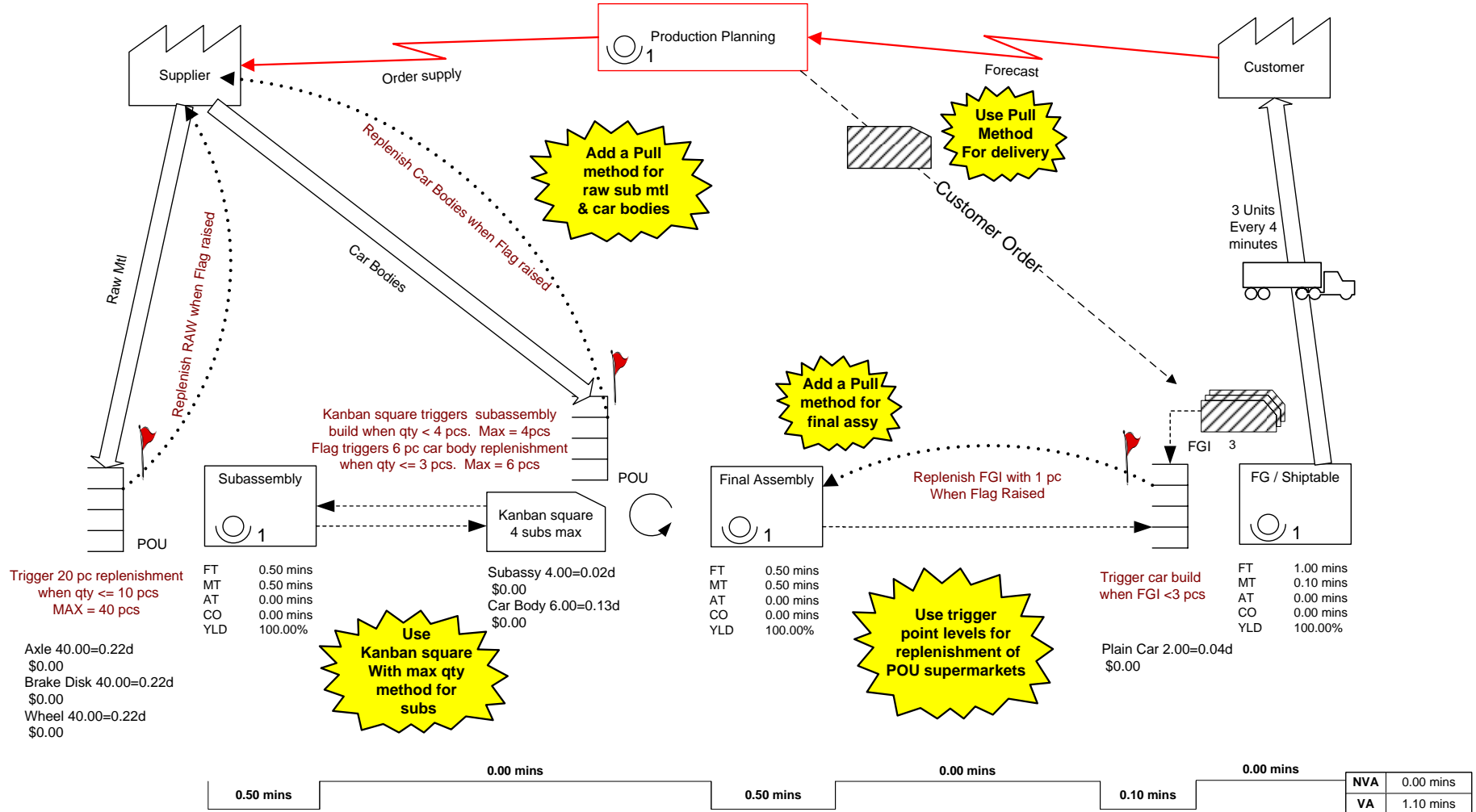
Value Stream Map

Customer LeanSim Factory
Product Zoom Zoom Cars
Demand 3/4.00mins
TAKT 1.33 mins

Future State
1-pc Lean Flow
Simulation exercise

Future state using visual kanban signal flag method of replenishment

To run the LeanSim simulation exercises in a continuous loop, the finished cars are disassembled and the raw materials returned to the 'supplier' stage. This can be performed by the 'planner' or by other participants in the exercise.



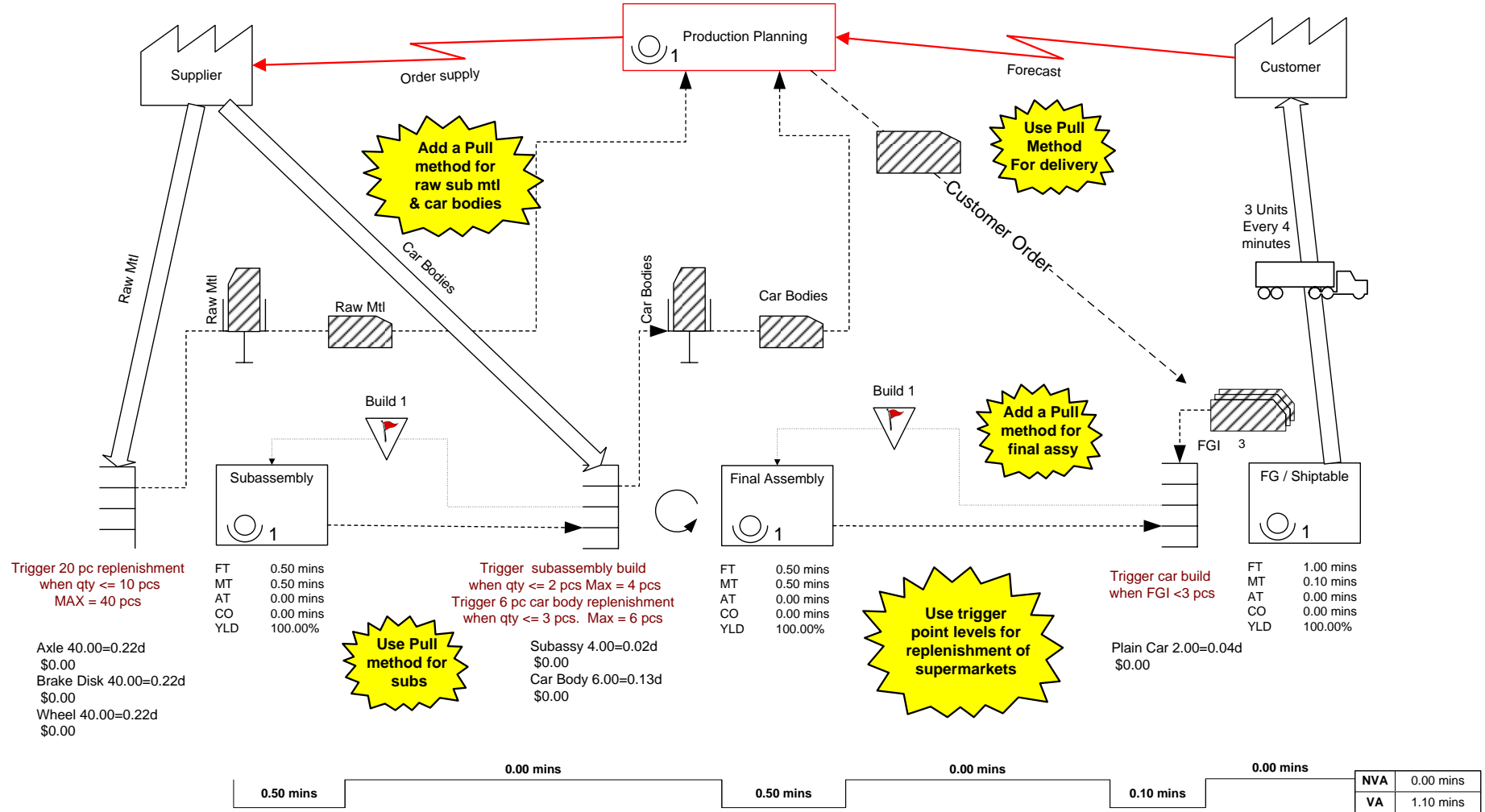
Value Stream Map

Customer LeanSim Factory
Product Zoom Zoom Cars
Demand 3/4.00mins
TAKT 1.33 mins

Future State
1-pc Lean Flow
Simulation exercise

Future state using kanban signal method of replenishment

To run the LeanSim simulation exercises in a continuous loop, the finished cars are disassembled and the raw materials returned to the 'supplier' stage. This can be performed by the 'planner' or by other participants in the exercise.



Value Stream Map

Customer LeanSim Factory
Product Zoom Zoom Cars
Demand 3/4.00mins
TAKT 1.33 mins

Future State
1-pc Lean Flow
Simulation exercise

Future state using kanban card method of replenishment

To run the LeanSim simulation exercises in a continuous loop, the finished cars are disassembled and the raw materials returned to the 'supplier' stage. This can be performed by the 'planner' or by other participants in the exercise.

