

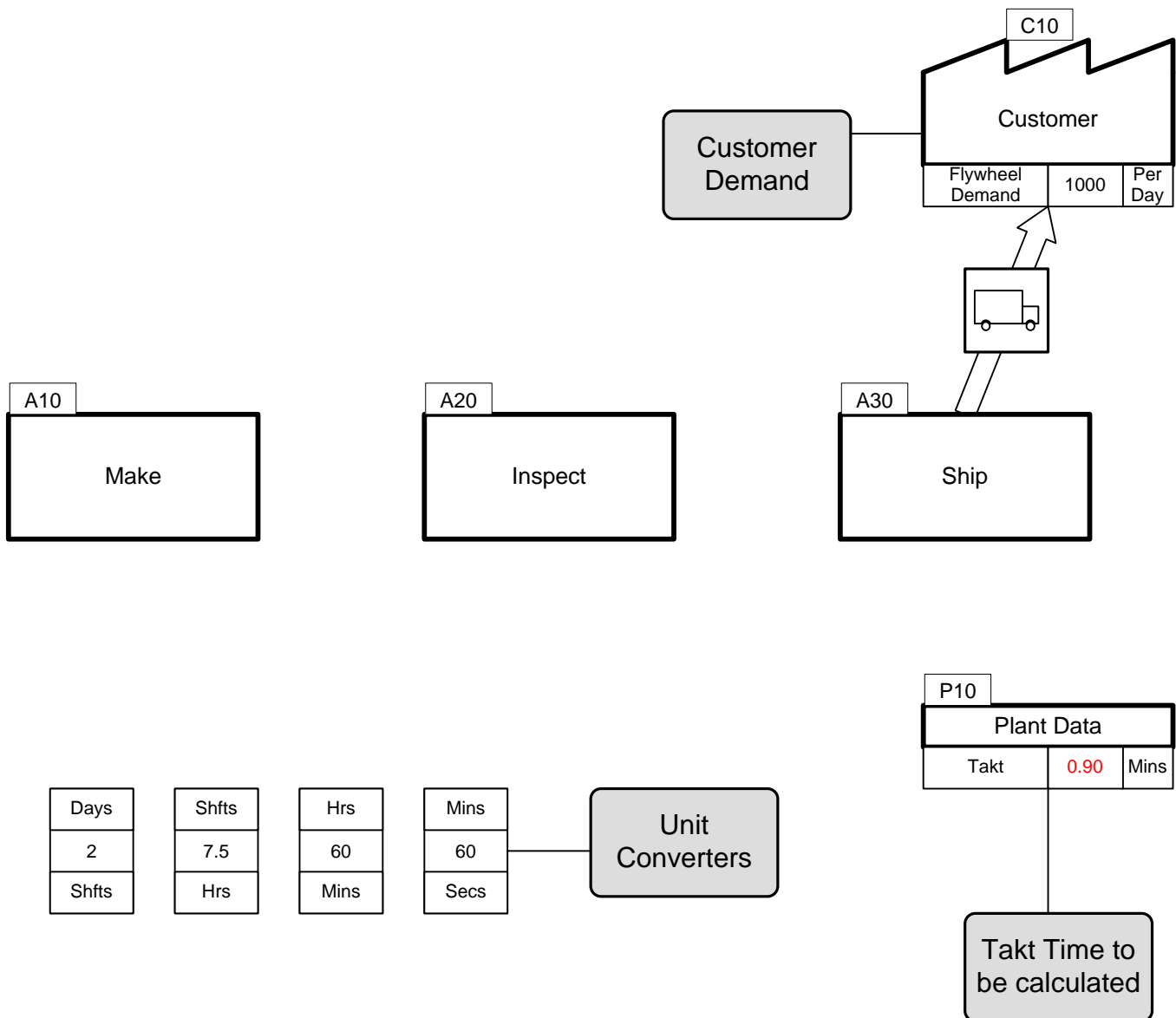
Takt Time Calculation

The “Lean Lexicon” published by the Lean Enterprise Institute defines Takt Time as :

“Takt Time is the time interval between parts being produced to meet customer demand”

This simple example shows how Takt time can be calculated from customer demand and the available production time.

Value Stream Map



Value Stream Calculator

The eVSM calculator transfers map data to an Excel spreadsheet. It also transfers the results of calculations in Excel back onto the map for display

	B	C	D	E
1	Tag	Operation	Data	Data
2			flywheel demand	takt
3			per day	mins
4				
5	A010	Make		
6	A020	Inspect		
7	A030	Ship		
8	C010	Customer	1000.00	
9	P010	Plant Data		0.90
10				

Takt Time = Production Time Per Day / Daily Demand
 = No of Minutes Per Day / Daily Demand
 = eVUnit_Page_1_days_mins / D8
 = 900/1000
 = 0.9 minutes

Note :

In the formula above the variable “eVUnit_Page_1_days_mins” is used to convert from days to minutes :

Conversion variables are automatically generated in the excel spreadsheet based on the unit converters defined on the map