## Can I easily capture the map and calculate all the lean metrics? PRODUCTION Forecast Forecasts State Street Assembly Michigan Daily Steel Co. weekly MRP Order 18,400 pos/mo fдx -12,000 "L" 500 ft colla -6,400 °R" Weekly Schedule Tray = 20 pieces 2 Shifts Tues. + Daily Ship Thurs. Schedule Daily. SHIPPING ASSEMBLY #2 S. WELD #2 ASSEMBLY #1 STAMPING 5. WELD #1 Staging 200T 2700 L Colls 5 days 1600 L 850 R 1200 L 640 R 1100 L 600 R 4600 L 01 1440 R 2400 R C/T = 62 seconds C/T = 40 seconds C/T = 46 seconds C/T = 39 seconds C/T = 1 second C/O = 10 C/0 = Ø C/O = 10 minutes C/O = 1 hour C/O = 10 minutes Uptime = 100% Uptime = 100% Uptime = 80% Uptime = 85% Uptime = 100% 2 Shifts 2 Shifts 2 Shifts 27,600 sec. avail. 2 Shifts 27,600 sec. avail. 27,600 sec. avail. 27,600 sec. avail. 27,600 sec. avail. EPE = 2 weeks Production = 23.6 days 4.5 days 2.7 days 2 days 5 days 1.8 days 7.6 days 40 seconds 62 seconds 39 seconds Processing. 1 second 46 seconds = 188 sec. Time